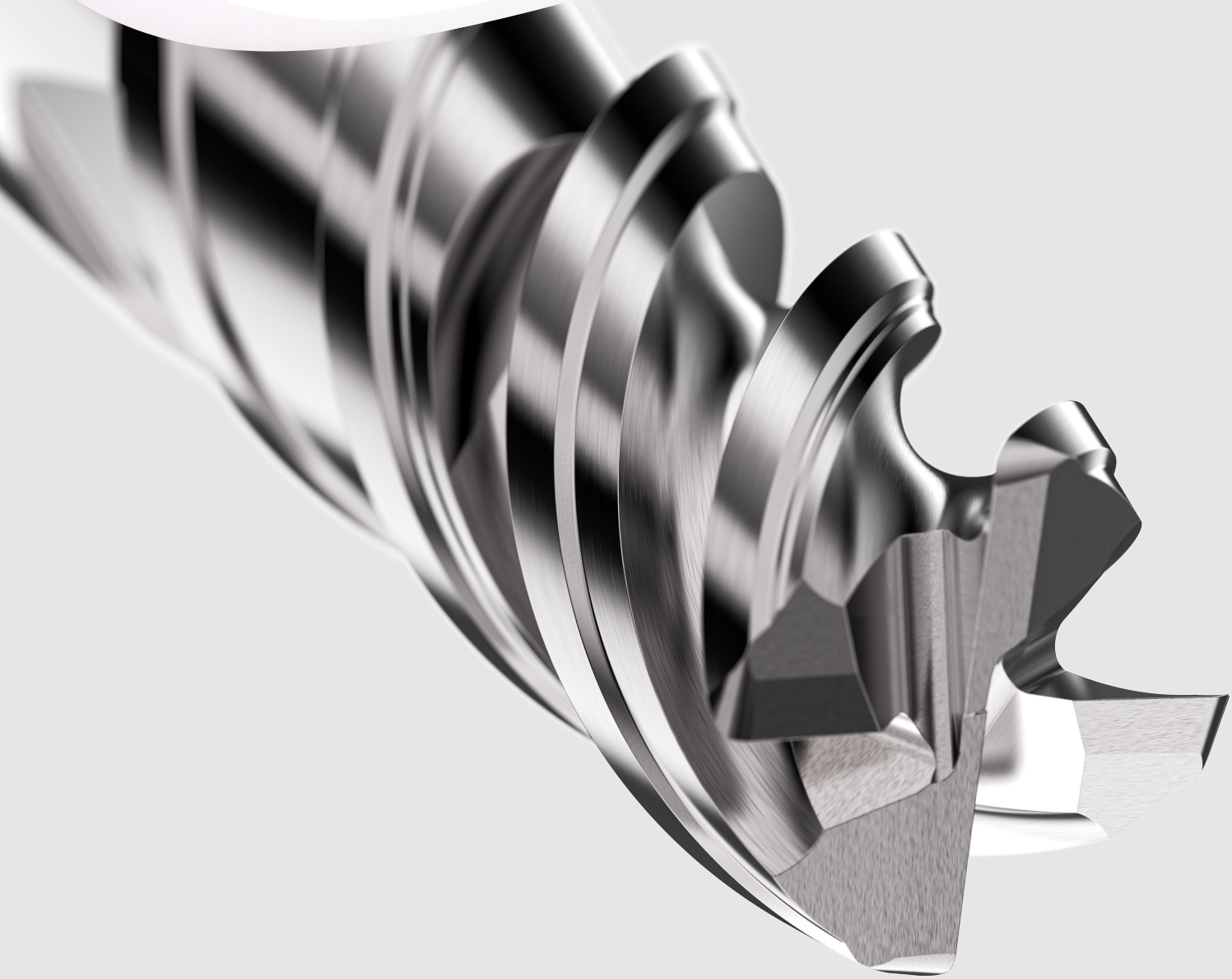
Catalog & technical guide 2024.1

Solid End Mills



At Seco, we make tools, tech, and solutions for the most advanced manufacturing challenges on Earth. From our founding in Fagersta Sweden, to today's global company, our business has always been made to measure, and built on trust.

Combining cutting-edge, precision tools with lasting, personal partnerships, we're a true people company helping our partners discover the future of the manufacturing industry.

We're proud to make for makers, invent for inventors, and partner with pioneers. Driving the future forward with our focus on innovation. In short - if the right tool for the job exists, we'll deliver it. If it doesn't, we'll create it.

We're proud to put sustainability at the heart of everything we do, challenging perceptions of our industry, changing the process of manufacturing, and playing our own small part in shaping a brighter looking future.

Made for Makers

WELCOME TO SECO SOLID MILLING

JABRO was founded in 1976 in Lottum, Netherlands.
JABRO is Seco's competence centre for solid milling solutions, and has the global responsibility for Research & Development, Manufacturing and Application Engineering.

Seco JABRO´s products provide the world market with a wide range of standard tools and custom tool solutions, including reconditioning, mainly for General Engineering, Aerospace, Energy, Medical and Mould & Die customers.

Advanced manufacturing technology and an environmental focus, ensures Seco's sustainable development and production of products that successfully respond to market demands in milling operations for both ferrous and non-ferrous materials.

- General Engineering
- Mould & Die
- Aerospace
- Medical
- Power energy
- 3C segment (Computer Customer Electronics and Communications)

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Product family overview

SOLID²

Jabro-Solid² is a range of solid carbide end mills for applications in general machining, offering flexibility, speed and cost efficiency. Jabro-Solid² is available in a diameter range of ∅1-∅32 mm and in *inch* ∅1/32 - 1 1/4.
Jabro-Solid² also includes a group of dedicated advanced roughing tools (JS564 and JS565).
The 564 and 565 offer excellent performance when applied in well defined tool paths with constant arc of contact with high cutting speed and high cutting depth applications (advanced roughing).
For the complete range of JS500 series tools all chamfer (c*45°) have the following tolerances: c = DC</=3=+0,01, 3<DC</=6=+0,02, 6<DC</=10=+0,03,
10<DC</=14=+0,04, 14<DC</=18=+0,05, 18<DC</=24=+0,06,
All Jabro-Solid² product codes begin with JS.
Please see page 9 for a grouped overview of JS² products.

HSM/TORNADO

These tools are characterized by high precision tolerances, short cutting lengths, reduced necks and significant core diameters, maximizing rigidity. These tools have been developed to excel in peripheral milling and copy milling machining methods.
Please see page 9 for a grouped overview of HSM/TORNADO (high speed machining) products.

HPM

Optimized endmills are dedicated for original equipment manufacturers and first-tier suppliers where large batches of a single component have to be machined and where processes need to be fully optimized to reduce cycle times, reducing costs per part.
Please see page 10 for a grouped overview of HPM (high performance machining) products.

HFM

High feed machining is the first choice for applications with deep and shallow workpiece features, 3D profiling for mold & die applications and machining in unstable conditions. High feed tools excel in plunge milling machine methods.
Please see page 10 for a grouped overview of HFM (high feed machining) products.

Product family overview

MINI

Seco's range of micro solid carbide end mills consists of square end mills and ballnose cutters with small cutting diameters. Universal tools are applicable for common workpiece materials and specific tools are dedicated for graphite and hardened-steel applications. All tools have a thin layered coating for optimal performance in small-sized applications.
Please see page 10 for a grouped overview of MINI (micro machining) products.

DIAMOND

Available in a variety of geometries and an extensive diameter range, these tools feature the best possible substrate to ensure the perfect adhesion of the diamond coating across a range of cutting parameters. Overall, these end mills significantly increase productivity and lower tooling costs by requiring fewer tool changes and being able to produce precision parts at high feed rates.
Please see page 10 for a grouped overview of DIAMOND (diamond coated) products.

COMPOSITE

It consists of diamond-coated and uncoated solid carbide and PCD end mills incorporating different geometries as well as with PCD-brazed cutting edges. This is a product range offering optimized tools for difficult cutting conditions on challenging workpiece materials.
Please see page 10 for a grouped overview of COMPOSITE (JC) products.

VHM

Includes universal coated and uncoated endmills, a range of products dedicated for machining plastics and aluminum, chamfer end mills and conical tools. These products consist of high-quality grades and coatings for predictable and premium tool life.
Please see page 11, 12 for a grouped overview of VHM (general engineering) products.

Product family overview

CERAMIC

To cut the world's toughest heat-resistant superalloys (HRSAs) quickly, you need a tool just as strong and advanced as the materials themselves. Streamline your processes and cut your HRSA parts considerably faster with these high-performance ceramic solid end mills.
Please see page 11, 12 for a grouped overview of CERAMIC products.

HSS-CO

High speed steel cobalt is a premium grade that offers higher performance compared to traditional high speed steels. Due to increased hardness, these end mills last longer in today's abrasive, heat resistant and exotic materials.
The high-quality, low-cost production advantages of these end mills are a direct result of engineered flute designs, wear resistant coatings and optimized features like internal coolant channels for these challenging materials.
Please see page 11, 12 for a grouped overview of HSS-CO products.

X-Heads

With the Seco exchangeable head milling system, quickly and easily change between various solid carbide milling head profiles and types to optimize all your milling operations while you reduce manufacturing costs and tooling inventories. X-Heads end mills mount to a variety of available shank lengths for even greater versatility, with long-reach capability. End mill changes only require a simple turn of a wrench, and the shank could remain in the machine. Eliminate the need to reset tool lengths thanks to a secure and reliable connection that provides exchange accuracies within 50 microns.
Please see page 487 for a grouped overview of X-heads (exchangeable heads) products.

Product family overview

Product family	Technology	Product	1xx	4xx	5xx	6xx	7xx	8xx	9xx
Jabro-Solid²	General machining	JS		■	■		■		
Jabro - HPM	High performance machining	JHP	■	■			■		■
Jabro - HFM	High feed machining	JHF	■						■
Jabro - Mini	Micro machining	JM	■	■	■	■			■
Jabro - HSM/Tornado	High speed machining	JH	■	■			■		■
Jabro - Ceramic	High performance machining	JCG					■		
Jabro - Diamond	Graphite machining	JD				■			
Jabro - Composite	Composite machining	JC, JPD						■	
Jabro - VHM	General machining	J		■					■
Jabro - HSS-E	General machining	JCO					■		
X-Heads - Solid²	High performance machining	XS		■	■		■		
X-Heads - HFM	High feed machining	XHF			■		■		
X-Heads - HSM/Tornado	High speed machining	XH			■		■		
X-Heads - VHM	General machining	XV			■		■		
SMG									
P1-8					■				■
P11-12					■				■
M1-3					■		■		
M4-5					■		■		
K1-7					■				■
S1-3					■		■		
S11-13					■		■		
H			■		■				
N1				■	■				
N2-3				■	■				
N11				■	■				
TS				■				■	
TP				■				■	
GR						■			
For further explanation on SMG (Seco material group) please see page 676									

Summary

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	37	SOLID[2]	JSE512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	41		JSE513	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	47		JSE514	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	117		JSB512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	57		JS553	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	77		JS554	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	338		JS412						●	●					●			●				
	341		JS413						●	●					●			●				
	344		JS452						●	●					●			●				
	349		JS453						●	●					●			●				
	110		JS520	●	○	○	○	●	●	●	●	○	●	○	●			●				○
	114		JS522	●	●	●	●	●	●	●	●	○	●		●			●				○
	119		JS532	●	○	●	●	●	●	●	●	○	●		●			●				○
	123		JS533	●	○	●	●	●	●	●	●	○	●		●			●				○
	127		JS534	●	○	●	●	●	●	●	●	○	●		●			●				○
	131		JS506	●	○	●	●	●	●	●	●	○	●	●	●			●				○
	135		JS509	●	○	●	●	●	●	●	●	○	●	●	●			●				○
	102		JS564	●	○	●	●	●	●	●	●	●	●	●								
	106		JS565	●	○	●	●	●	●	●	●	●	●	●								
	249		JS720			●	●					●	●									
	269		JS730			●	●					●	●									
	221		JS754		○	●	●					●	●									
	238		JS755		○	●	●					●	●									
	358	HSM/TORNADO	JH40						●		●				●							
	208, 398		JH112					●						●								
	388		JH120											●								
	390		JH130											●								
	203, 395		JH142	●	●			●						●								
	401		JH150					●						●								
	403		JH160	●	○									●								
	365		JH410						●		●				●							
	361		JH421						●		●				●			●				
	367		JH440						●	●	●				●			●				
	369		JH450						●	●	●				●			●				
	371		JH460						●		●		●		●			●				
	312		JH710									●	●									
	322		JHB720			●	●		●	●	●	○	●		●			●				
	324		JH721									●	●									
	326		JH722									●	●									
	296		JH724			●	●					●	●									
	298		JH726			●	●					●	●									
	316		JH730									●	●									
	300		JH734	○	●	●						○	●									
	302		JH736	○	●	●						○	●									
	304		JH740									●	●									
	304		JH744	○	●	●						○	●									
	306		JH746	○	●	●						○	●									
	308		JH770									●	●									
	320		JH780									●	●									
	314		JH790									●	●									
	139		JH910	●	○	●	●	●				●	●					●				●
	143, 392		JH930	●	○			●				●	●	●								
	145, 206		JHB970	●	○	●	●					●	●									

● Preferred choice, ○ Alternative choice

Summary

	Page	Family name	Name	P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TP1	TP2-3	TS2/TP2+N1	TS2/TP2+S12	Honeycomb	GR
	382	HPM	JHP170											●								
	273		JHP751									●	●									
	276		JHP760			●	●															
	280		JHP770										●									
	287		JHP780									●										
	292		JHP794			●	●															
	354		JHP490						●	●												
	199		JHP951	●	○			●														
	193		JHP993	●	○			●														
	318		JHP994									●	●									
	385	HFM	JHF181	○	○			●				●	●	●								
	328		SHF712																			
	147		JHF980	●	○	●	●	●				●	●	○								
	412	MINI	JMB112											●								
	405		JME142											●								
	410		JME144											●								
	375		JM403/404/406						●	●												
	377		JM413/416						●	●	●				●		●					
	377		SMB413/414/416						●	●					●		●					
	181		JMB542	●	●	●	●		○	○	○		●	○								○
	184		JMB562	●	●	●	●		○	○	○		●	○								○
	188		JMB563	●	●	●	●		○	○	○		●	○								○
	171		JME542	●	●	●	●		○	○	○		●	○								○
	174		JME562	●	●	●	●		○	○	○		●	○								○
	178		JME564	●	●	●	●		○	○	○		●	○								○
	178		SMB713/714/416																			
	178		JME714/716									●	●									
	484	MINI DIAMOND	JMB642/JMB662																			●
	484		JMB662																			●
	482		JME642																			●
	480		SMB614/616																			●
	420	COMPOSITE	JC845													●		●				
	422		JC850													●		●				
	424		JC860													●		●			●	
	426		JC870													●		●			●	
	432		JC871													●		●			●	
	438		JC875													●		●				
	442		JC876													●		●				
	446		JC877													●		●				
	450		JC880													●		●				
	452		JC885													●		●				
	454		JC898																●	●		
	456		JC899																●	●		
	459	PCD	JPD850													●		●				
	461		JPD880													●		●				
	463		JPD890													●		●				
	472	DIAMOND	JD620																			●
	474		JD630																			●
	476		JD640																			●
	478		JD660																			●

● Preferred choice, ○ Alternative choice

Summary

	Page	Family name	Name	P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TS4	TP1	TP2-3	TP4	Honeycomb	GR
	467	VHM	J28												●							
	154		J36	○	●	○	○	○	○	●	●	○	○		○			○				
	157		HK/HKM	●		●	●	●	●	○		●	●	●	●			●				
	168		V31	●	○	●	○	●	●	●	●	●	●	●	●			●				●
	151		J29	●	●	●	●	●	●	●	●	●	●	○	●			●				●
	465		J93F												●			●				
	294	Ceramic	JCG790									●										
	497-505	X-HEADS SOLID²	XSE550	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	514		XSB540	●	○	●	●	●	●	●	●	○	●	○	●			●				○
	567		XSC509	●	●	●	●	●	○	○	○	○	○		●			●				○
	528-529		XSE450						●	●	●				●			●				
	516-517		XSE720	○	●	●	●					●	●									
	522		XSB720	○	●	●	●					●	●									
	304	X-HEADS HSM/TORNADO	XHT740	○	●	●						○	●									
	537	X-HEADS HFM	XHF580	●	●	●	●	●				○	○	○								
	542		XHF780	○	○	●	●					●	●	○								

	555	X-HEADS VHM	XVE540	●	●	●	●	●	●	●	●	○	○	○	●			●				○
	560		XVE510	●	●	●	●	●	○	○	○	○	○		●			●				○
	563-564		XVB510	●	●	●	●	●	○	○	○	○	○		●			●				○
	567		XVC506/509/512	●	●	●	●	●	○	○	○	○	○		●			●				○
	571		XVK310	●	●	●	●	●	●	●	●	○	○	○	●			●				○

● Preferred choice, ○ Alternative choice

Code keys

Solid end mills

R	JS	720	100	D	2	R050	.0	Z6	C	,	HXT
1	2	3	5	6	7	8	9	10	11		12

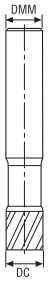
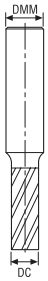
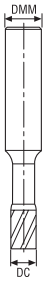
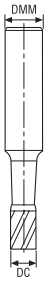
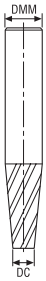
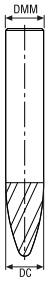
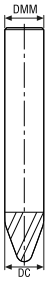
X-Heads – Heads

R	XSE	550	E10	100	D	2	R050	Z4	A	,	SIRA
1	2	3	4	5	6	7	8	10	11		12

1. Type of product	2. Product range		3. Geometry
BLANK = Standard (catalogue) product R = Reconditioned product (complete) RK = Reconditioned product (frontal)	J = JABRO® VHM JC = JABRO® Composites JD = JABRO® Diamond JH = JABRO® HSM/Tornado JHF = JABRO® HFM JHP = JABRO® HPM JM = JABRO® Mini JS = JABRO® SOLID²	JPD = JABRO® PCD JCO = JABRO® HSS-Co JCG = JABRO® Ceramic XS* = X-Head SOLID² XH* = X-Head HSM/Tornado XV* = X-Head VHM XHF = X-Head HFM	A three-digit combination specifying the cutting geometry. Example: 111, 950, 553, 514, etc.

4. Connection size	5. Cutting diameter
This figure indicates the threading connection size between the head and adaptor E10 = 10 mm E12 = 12 mm E16 = 16 mm E20 = 20 mm E25 = 25 mm	Metric = 3 digit code (in case of 4 digit code – xx,xx mm) Imperial = a dot followed by a 3 digit code Example: (050 = metric, 5 mm) / (.500 = imperial, ½ inch)

6. Tool shape

(DC = DMM)		(DC < DMM)			(DC > DMM)
					
D	E	F	G	J	P
Form shape					
					
N		X		T	

7. Length of shape

A single digit that gives an indication of the length of the cutter compared to other products with the same cutting geometry.

9. Type of shank

.0 = Cylindrical
.3 = Weldon
.5 = Whistle Notch
.9 = Safe-Lock

10. Number of flutes

This figure indicates the number of flutes in the cutter.
Example: PCEDC2= 2 flutes, PCEDC6 = 6 flutes

11. Coolant channels

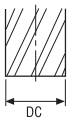
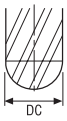
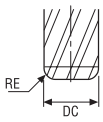
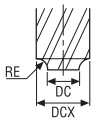
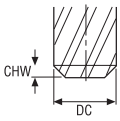
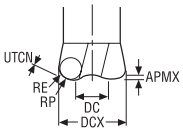
BLANK = No coolant channels
A = Internal coolant channel(s)
C = Chip splitters

12. Grades

4 character code specifying the coating on the cutter.

MEGA =	MEGA	DURA =	DURA
MT =	MEGA-T	NXT =	NXT
M64 =	MEGA-64	HXT =	HXT
M64 T=	MEGA-64-T	STAX =	STAX
SIRA =	SIRON-A	TAN =	TAN
HEMI =	HEMI	M9 =	M9
DIA =	DIAMOND	AXT =	AXT

8. Tip shape

Sharp	Ball-nose	Corner radius	Concave radius	Chamfer	High feed
					
S	**B**	**R...**	**K...**	**C**	**H**

Size of radius for convex and concave radius tipped products

000 = For metric products the tip shape is shown by a three-digit figure.
By dividing this figure by 100 you will get the actual corner radius size in millimetres.

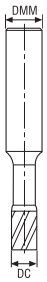
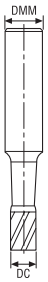
.000 = For imperial products the tip shape is shown by a dot, followed by a three-digit figure.
This figure actually shows the size of the corner radius in *inch* (e.g. R.100 would indicate a radius of 0.100 *inch*).

Code keys

X-Heads – Shanks

X	E10	100	E	2	-	055	-	00	.0	S
1	2	3	4	5		6		7	8	9

1. Product range	2. Connection size	3. Shank diameter
X = X-Head Cylindrical shank	This figure indicates the threading connection size between the head and adaptor E10 = 10 mm E12 = 12 mm E16 = 16 mm E20 = 20 mm E25 = 25 mm	Metric = 3 digit code Imperial = a dot followed by a 3 digit code Example: (050 = metric, 5 mm) / (.500 = imperial, 1/2 inch)

4. Tool shape		
(DC = DMM)	(DC < DMM)	
		
E	G	J

5. Length of shape	6. Overall length
A single digit that gives an indication of the length of the cutter compared to other products with the same cutting geometry.	Metric = 3 digit code Imperial = 3 digit code with a dot after the first digit Example: (055 = metric, 55 mm) / (2.50 = imperial, 2 1/2 inch)

7. Taper angle	8. Type of shank	9. Type of material
Indicates the body half taper angle. Example: (00 = 0°;0°; 05 = 5°; 10 = 10°)	.0 = Cylindrical .3 = Weldon .5 = Whistle Notch .9 = Safe-Lock	Indicates the different shank materials that are available. S = Steel DM = Densimet E = Solid Carbide

How our solutions can benefit you

The individual solution - Custom and modified tools

If the requirements are very special, we have the right solution with our individual and customized tools - solutions that have been tailored specifically to your individual requirements. This will enable you to take your machining productivity to a whole new level.
In addition to the standard solutions, our offer includes:

Custom tools
They are modified geometries or form shaped tools for customer specific demands as we can fully cooperate with the customer and design a specific tool which answers the needs. Examples can be:

- Modified tools within a standard geometry
- MEP (Mechanised edge Profiling)
- Firtree,
- Dovetail
- Tapered ballnose
- Condyle cutter
- Form shaped tools
- Barrel

Modified tools
Seco offers a quick delivery solution for standard tools requiring modification to meet specific dimensional requirements as this can be:

- (full) Radius/Facet/Chamfer/Concave
- OD reduction (neck reduction), including increased length
- Coating (application for uncoated tools)
- Reduced cutting diameter
- Chip breakers
- Adding Weldon / Safelock
- External coolant channels

Reconditioning cuts cost and tools inventory

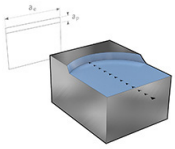
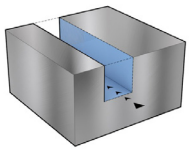
Seco's modern carbide tools offer remarkable performance by utilizing the best combinations of carbide substrates with highly wear resistant coatings, optimized cutting geometry and controlled edge preparation.

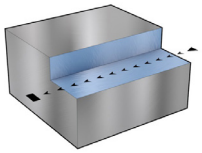
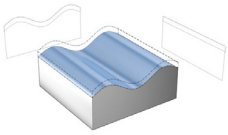
However good a tool is, as part of its function, it will eventually show signs of wear on the cutting edge. Controlling this wear and the timely replacement of the tool will allow the used tool to be reconditioned, thus reducing tool investment costs. And we use the same advanced technology to recondition your solid carbide tools as we use to manufacture new products.

Your benefits from reconditioning

- Manufactured to Seco´s high standards with the original Seco geometry, edge preparation and coating processes.
- Savings on tooling costs by repeated use of the same solid carbide tool.
- Our easy to use and free 'reconditioning box' includes a pre-prepared delivery note.
- Free, reliable collection on the following day when you call your Seco contact for pick up.
- An easy process due to the package service, reconditioning box and prepared delivery note.
- Delivery via the normal Seco channels.
- Safe transportation and storage of the reconditioned tools by packaging them in similar packaging as new tools.
- A new packaging label is included.
- Work towards greener and cleaner environment. -Seco´s processes are globally certified with ISO14001.
- Guaranteed quality, as all processes are ISO9001 certified.

Basic operations:

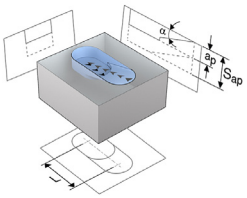
Face milling:	Slot milling:
Operation where the tool is in engagement with less than 180° arc of contact. Tool engagement: Small a_p and large a_e. 	Operation where the full diameter is in engagement, a_e is equal to DC and a_p up to 2 times DC depending on the machining strategy in use. 

Side milling:	Copy milling:
Operation where the side of the tool is in engagement, a_p is large and a_e is small. 	Operation where the radius is in engagement. a_p and a_e are both small. 

Advanced machining methods:

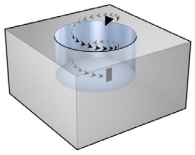
Ramping:

Opening up a pocket by making a Z axis at an angle.



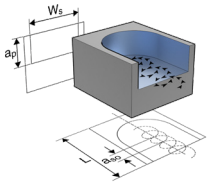
Helical interpolation ramping:

Opening a pocket by making a circular movement with the tool while ramping in Z axis.



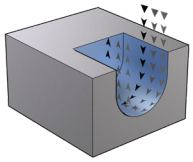
Trochoidal:

Opening a slot by using side milling, making a partial circular movement in X- or Y-axis. (changing slot milling into side milling).



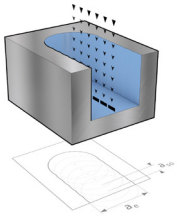
Push-pull:

Machining a 3D form by making a down and up copying movement following the profile of the form.



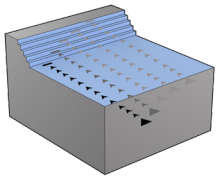
Plunge milling:

Opening up a deep slot by using drilling (Z) axis.



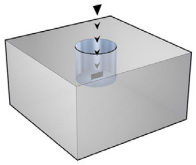
Z-leveling:

Machining a surface by making a small drilling or ramping in Z axis then opening the pocket with X and Y movements.



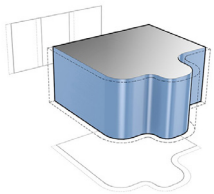
Drilling:

Making a hole with movement in Z axis.



Advanced roughing/ Optirough

Well defined tool paths with constant arc of contact for reliable roughing of simple & complex shapes. The large axial depths (a_p) & small radial depths (a_e) of cut combined with high feeds per tooth (f_z) and cutting speeds (V_c) results in high productivity.



Definitions, machining strategies:

General machining:
A machining strategy for general use. a_e - a_p ratio can vary depending on the operation.
Tool characteristics: Tools have relatively long cutting lengths and thin core diameters.
There are no high requirements on the tolerances.
Machine requirements: There are no special machine requirements needed.
With basic CNC technology, difficult advanced machining methods are not possible.
Average results will be reached on metal removal rate Q (cm^3/min).
The application area usually includes small batch sizes and a wide range of materials.

High Performance Machining:
Is a machining strategy where very high metal removal rates can be achieved. Typical for this strategy is that a_e is 1 times DC and a_p is 1 to 1½ times DC depending the workpiece material.
With HPM (High Performance Machining) you achieve an extremely high metal removal rate by using a much higher chip load than in general machining.
Tool characteristics: Specially developed chip formers in the flute of the tool, tip protection with a small 45° face or corner radius, special smooth formed chip space and coating, with or without Weldon shank.
Machine requirements: High stability, high power requirements, CNC control, rigid clamping system.
The application areas are: Operations in a mass production environment where production time/lead time is of great importance or on single products where a high metal removal rate Q (cm^3/min.) is required.

High Feed Machining:
Is a machining strategy where high feed rates can be reached with large radial engagements (a_e) in combination with a small a_p.
With HFM (High Feed Machining) you achieve high metal removal rates and/or surface finish by using a much higher table feed compared to general machining.
Tool characteristics: Specially developed front teeth, very short cutting length and coating.

Machine requirements: Good stabillity, CNC, possibility for high table feed (v_f).
The big advantage of this technology is that it is very user friendly, easy, safe and quick to program in CAM. By using the so called Z-leveling strategy it is relatively easy to program complex forms without the necessity of having extensive experience in programming.
The application area is: From soft to hardened steel, titanium and stainless steel and it is very good as a pre operation before HSM is used.
It can also be applied in deep pocket machining.

Micro machining:
Is a machining strategy where extremely small tool diameters are used.
Tool characteristics: Diameter range Ø 0,1 to 2,0 mm, small cutting lengths, a wide range of OD reductions, high accuracy, coating.

Machine requirements: High spindle accuracy, high RPM, CNC, thermal stability against spindle growth.
Application area is: Production of cavities like slots, pockets, holes or engravings in many types of material.

High speed machining:
Is a machining strategy where a combination of a small radial depth of cut and high cutting speed and table feeds are used.
Depending on the method a high metal removal and a low R_a value can be reached.
Typical for this strategy are the low cutting forces, less heat build up in tool and workpiece, less burr formation and high dimensional accuracy on the workpiece.

With HSM (High Speed Machining) you achieve high metal removal rate and/or surface finish by using a much higher cutting speed compared to general machining.
Tool characteristics: Stable, (thick core diameter and a short cutting length) clear and well formed chip space for good chip evacuation, coating.

Machine requirements: Quick CNC control, high RPM, quick transmission to the axis.
The applications area is: Mould & Die industry on pre-finishing and finishing operations in hardened steel (48-62 HRc) in a short lead time.
This technique can also be applied in most other materials when using the right tool and advanced machining method.

Advanced roughing / Optirough:
Well defined tool paths with constant arc of contact for reliable roughing of simple & complex shapes. The large axial depths (ap) & small radial depths (ae) of cut combined with high feeds per tooth (fz) and cutting speeds (Vc) results in high productivity.

These CAM-based rough-machining, or dynamic milling, strategies are ones that centre on a cutting tool's arc of contact and its average chip load.

When reducing the arc of contact, the amount of heat generated during roughing operations is reduced. As the radial depth of cut decreases, so does a cutter's arc of contact. A smaller amount of contact results in less friction and, therefore, less heat between the tool's cutting edges and the workpiece it is machining. These lower machining temperatures, in turn, allow for increased cutting speeds shorter cycle times.

Explanation of Advanced Roughing

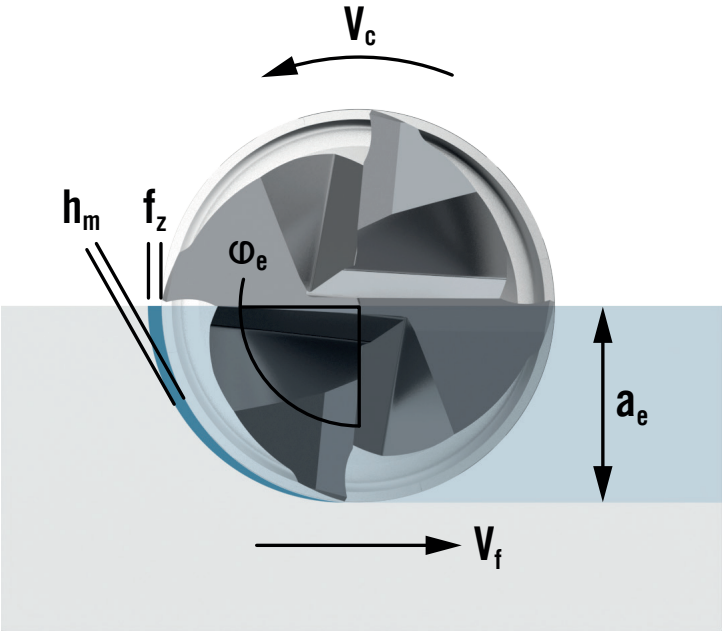
Advanced Roughing, what does it mean?

Today's CAM packages offer toolpath strategies specifically for inside/outside radii shapes where changing arcs of contact are common when using conventional tool-paths. These software packages automatically apply different feeds to control arc of contact and keep chip loads consistent.
These CAM-based rough-machining, or advanced roughing, focus on a cutting tool's arc of contact and its average chip load. When reducing the arc of contact, the amount of heat generated during roughing operations is reduced. As the radial depth of cut decreases, so does a cutter's arc of contact. A smaller amount of contact results in less friction and, therefore, less heat between the tool's cutting edges and the workpiece it is machining. These lower machining temperatures, in turn, allow for increased cutting speeds shorter cycle times. Also, the resulting cutting force is lower, allowing high APMXS, or cutting depth to be programmed.

In advanced roughing, to maintain arc of contact, CAM packages need to employ trochoidal machining-like techniques when entering a radius.

When using an optimized roughing toolpath and maintaining consistent arc of contact, the cutter's radius can match that of the inside radius being cut without risk of cutter overload. This capability allows our Advanced Roughing tools (JS554-3C, JS564, JS565, JS754, JS755 and JS720) to remove more stock in the roughing pass, thus reducing the amount of stock the finish pass has to cut – all of which translates to faster machining cycle times and longer tool life. Also, while the remaining stock is constant the finishing tool can generate a better final surface quality and at the same time will have longer tool life.

Impact of arc of contact on cutting speed and feed per tooth



How our products can benefit you

Achieve Revolutionary speeds in superalloys with JABRO® Ceramic end mills

SiAlON ceramics, high-strength geometries and reinforced frontal teeth are some of the main features of these highly optimized tools and allow full utilization of high speed, high-performance machine tools. The tools can operate at cutting speeds of up to 1200M/min and can offer a significant productivity increase when compared to standard solid carbide solutions.

Since high temperatures are needed, also a significant amount of RPM is needed in order to achieve the high vc. The high temperatures are required in order to reach a level where the HRSA softens (850c +). With these tools, multiple strategies can be applied as long as a constant cut and constant contact with the workpiece is maximized.

The tool is designed for side milling, slot milling, high-feed milling and advanced roughing! All these are possible. To maintain the high cutting temperature in the cutting zone, coolant is compressed air. Because the tool operates at high speeds, also run out is of high importance.

You can find JABRO®Ceramic tools on page 294.

Simplify aerospace hybrid materials holemaking with two-in-one-geometry

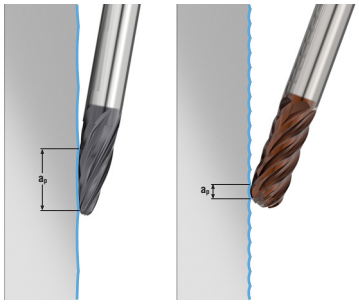
The JC899 has a patented two-in-one double geometry solution, designed for machining hybrid stacked material combinations such as CFRP-Ti and CFRP-Alu. Due to its left-hand helix, right-hand cut design, this tool is preventing delamination, fiber pull-out and chip marks from damaging the workpiece surface (this as chips will be pushed downwards out of the hole). As a result, the JC899 left-hand helix, right-hand cut STAX finisher gives a perfect surface finish and prevents chip pollution between the 2 stack layers.

This means post-machining, unstacking, cleaning and deburring, and re-stacking is not needed anymore which can can boost process efficiency by as much as 200 to 300 percent and provide tool life three to six times longer than that of conventional reamers.
At the same time the drilling process is replaced by applying the JC898 high feed rougher. This tool helical interpolates and allows the JC899 to operate in continuous stock conditions, maximizing quality output while minimizing corellation in hole size and tolerance.

You can find JABRO® JC898/JC899 on pages 454 - 456.

Take bigger stepovers for faster finishing productivity

For the fastest, most reliable finishing operations, new barrel-shaped tools use an innovative “taper” or “drop” geometry to enable large increases in stepover. This is possible through the use of advanced CAD/CAM systems or new plugins built for the uses of these tools. Using 5-axis machine movement, the tool’s cutting profile can remain engaged with the surface of the part at the proper angle at all times.
In addition to our standard barrel-style shapes, Seco can also offer all styles of barrel geometry’s as custom products, such as lens shapes, ensuring you always have access to the ideal tools for your part-production needs.



Take the risk out of micro milling operations

Achieve accuracy, precision and high surface finish quality from the very start when machining small, micro-sized surfaces with our range of solid-carbide JABRO® end mills. SECO's new Mini ranges deliver longer tool life, stability and peace of mind for machining operations where it is typically impossible to actually see the workpiece and cutting tool as it works.

Precisely produced geometries, virtually zero runout, advanced coatings and true line-form radius tolerances give these mini ranges its incredibly long tool life and reliability. Key is to apply these tools in suitable conditions, in which the benifits can be maximized. Minimize run-out of the tool plus the tool holder is essential.
Also the CAM program can be optimized with the SECO JABRO® feed optimizer which calculates the ideal RPM and feed speed (vf) for every applicaton. As a result, the tool and set-up help to eliminate any unforeseen problems during rough, pre-finish and final finish micro milling operations.

You can find an overview of JABRO®Mini tools on page 10.

JS522 long flute finisher

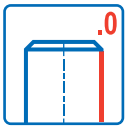
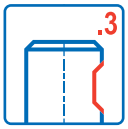
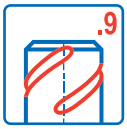
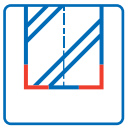
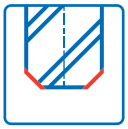
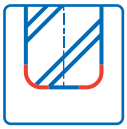
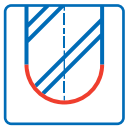
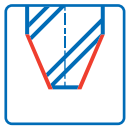
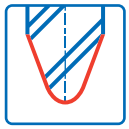
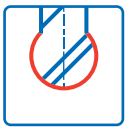
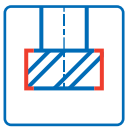
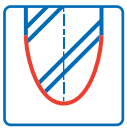
The JS522 long-flute finishing tool is capable of meeting the aerospace industry's stringent criteria for perpendicularity, fine surface finish, high metal removal rates and more effective machining.

With a cutting length of 5*Dc, an increased core diameter and a slightly negative taper to compensate deflection, the JS522 is specially designed to machine high shoulders in single-pass finishing operations. This single pass saves time (up to 80%) but most important, also delivers instant quality. This tool is often used in mass production areas.

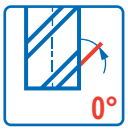
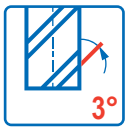
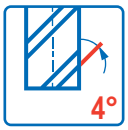
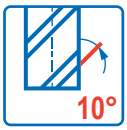
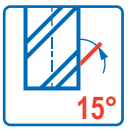
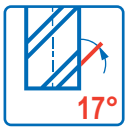
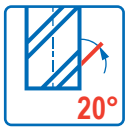
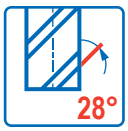
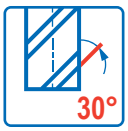
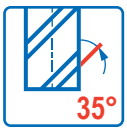
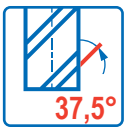
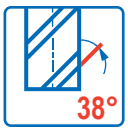
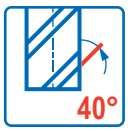
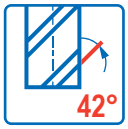
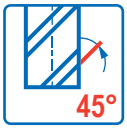
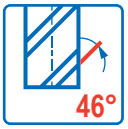
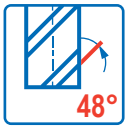
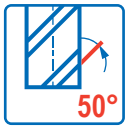
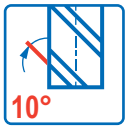
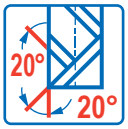
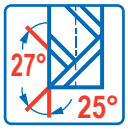
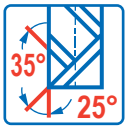
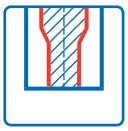
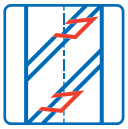
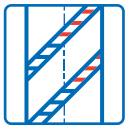
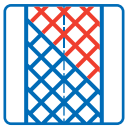
Once in place and optimized, this has proven to be the number one cost saver in multiple applications!

You can find JABRO® JS522 on page 114.

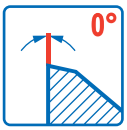
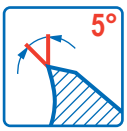
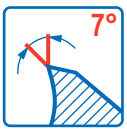
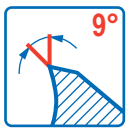
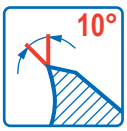
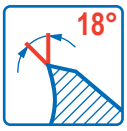
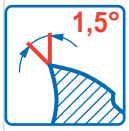
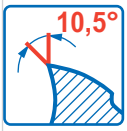
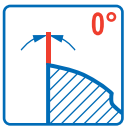
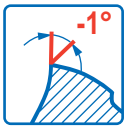
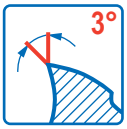
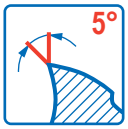
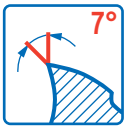
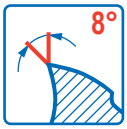
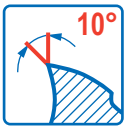
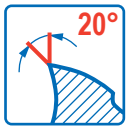
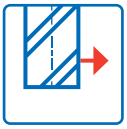
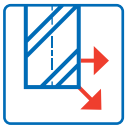
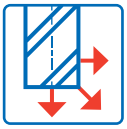
Key symbols

Center cut PCEDC 1	Center cut PCEDC 2	No center cut PCEDC 2	Center cut PCEDC 3	No center cut PCEDC 3	Center cut PCEDC 4
No center cut PCEDC 4	Center cut PCEDC 5	No center cut PCEDC 5	Center cut PCEDC 6	No center cut PCEDC 6	No center cut PCEDC 7
No center cut PCEDC 8	No center cut PCEDC 9				
 Cylindrical shank	 Weldon shank	 Safelock shank			
 Sharp	 Chamfer	 Corner radius	 Ball nose	 Tapered sharp	 Tapered ball nose
 Cutter 250°	 T-shape	 Barrel			

Key symbols

 Helix angle 0°	 Helix angle 3°	 Helix angle 4°	 Helix angle 10°	 Helix angle 15°	 Helix angle 17°	 Helix angle 20°
Helix angle 25°	 Helix angle 28°	 Helix angle 30°	 Helix angle 35°	 Helix angle 37,5°	 Helix angle 38°	 Helix angle 40°
Helix angle 41°	 Helix angle 42°	Helix angle 44°	 Helix angle 45°	 Helix angle 46°	 Helix angle 48°	 Helix angle 50°
Helix angle Left 3°	 Helix angle Left 10°	Helix angle Left 15°				Double left hand helix 40° - 10°
 Double helix 20° - 20°	 Double helix 27° - 25°	 Double helix 35° - 25°	Double helix 35° - 30°	Double helix 34° - 36°	Double helix 36° - 40°	Double helix 40° - 42°
 Double core	Tapered Core					
 Chip splitters	 Roughing profile	 Router profile				

Key symbols

 Cutting rake 0° Angular relief	Cutting rake 1° Angular relief	Cutting rake -1° Angular relief	Cutting rake 2° Angular relief	Cutting rake 3° Angular relief	Cutting rake 4° Angular relief	Cutting rake 4-6° Angular relief
 Cutting rake 5° Angular relief	Cutting rake 6° Angular relief	 Cutting rake 7° Angular relief	Cutting rake 8° Angular relief	 Cutting rake 9° Angular relief	 Cutting rake 10° Angular relief	Cutting rake 11° Angular relief
Cutting rake 12° Angular relief	Cutting rake -12° Angular relief	Cutting rake 14° Angular relief	Cutting rake 15° Angular relief	Cutting rake 16° Angular relief	 Cutting rake 18° Angular relief	Cutting rake 20° Angular relief
Cutting rake -24° Angular relief				 Cutting rake 1,5° Radial relief	 Cutting rake 10,5° Radial relief	Cutting rake 13° Radial relief
 Cutting rake 0° Radial relief	 Cutting rake -1° Radial relief	 Cutting rake 3° Radial relief	 Cutting rake 5° Radial relief	Cutting rake 6° Radial relief	 Cutting rake 7° Radial relief	 Cutting rake 8° Radial relief
 Cutting rake 10° Radial relief	Cutting rake 11° Radial relief	Cutting rake 15° Radial relief	Cutting rake 16° Radial relief	 Cutting rake 20° Radial relief	Cutting rake 7-11° Radial relief	
ICC straight	ICC and Y					
 Radial	 Radial/Ramping	 Radial/Ramping/Plunging				

Key symbols

DIAMOND Diamond	DURA Dura	HEMI Hemi	HSCO HSCO	HXT HXT
MEGA Mega	MEGA-T Mega-T	MEGA-64 Mega-64	MEGA-64-T Mega-64-T	NXT NXT
STAX Stax	SIRON-A SIRA	TAN TAN	AXT AXT	CERAMIC Ceramic
PCD PCD	M9 M9			
RECONDITIONING Regrind possible	+ Advanced roughing			

Attributes Solid Milling and X-Heads

Attribute	Explanation
AP1	depth of cut split
APMXS	depth of cut maximum in feed direction side
BHTA	body half taper angle
CA	collision angle
CHW	corner chamfer width
CSP	coolant supply property
CZCMS	connection size code machine side
CZCWS	connection size code workpiece side
DC	cutting diameter
DCSFMS	contact surface diameter machine side
DCSFWS	contact surface diameter workpiece side
DCX	cutting diameter maximum
DMM	shank diameter
DN	neck diameter
FCEDC	face cutting edge count
ICC	internal coolant channel
L	cutting edge length
L2	cutting edge length 2
LF	functional length
LN	neck length
LN2	neck length 2
LSCN	clamping length minimum
NA	neck angle
OAL	overall length
PCEDC	peripheral cutting edge count
PRFA/2	profile angle divided by two
PRFRAD1	profile radius 1
PRFRAD2	profile radius 2
PRFRAD3	profile radius 3
PSIR	tool lead angle
RE	corner radius
RE2	corner radius 2
RP	programming radius
SA	sphere angle
SIG	point angle
SW	wrench size
TQ	torque
TQN	torque minimum
TQX	torque maximum
UTCN	uncut thickness

Attributes Minimaster

Attribute	Explanation
APMXE	depth of cut maximum in feed direction end
APMXS	depth of cut maximum in feed direction side
AZ	plunge depth maximum
BEC	back end chamfer angle
BHTA	body half taper angle
CCER	curved cutting edge radius
Cmax	helical interpolation hole diameter maximum
Cmin	helical interpolation hole diameter minimum
DC	cutting diameter
DCSFMS	contact surface diameter machine side
DCSFWS	contact surface diameter work piece side
DCX	cutting diameter maximum
DMM	shank diameter
DN	neck diameter
FCEDC	face cutting edge count
FHA	flute helix angle
KAPRS	tool cutting edge angle in feed direction side
LE	cutting edge effective length
LF	functional length
LPR	protruding length
OAL	overall length
RA	relief angle
RE	corner radius
RMPX	ramping angle maximum
RP	programming radius
RPMX	rotational speed maximum
SA	sphere angle
SIG	point angle
UTCN	uncut thickness
ZEFP	peripheral effective cutting edge count

UNIVERSAL

Seco offers a complete range of high performance solid carbide square shoulder end mills, ballnose cutters and finish end mills for high productivity and extended tool life. This range covers universal products and optimized end mills for specific workpiece materials.

Universal products offer full machining flexibility at an excellent price/performance ratio.

- JSE512, JSE513, JSE514, JS553, JS554, JS564, JS565 and JS520 with 45° chamfer type.
- JS522, JS553, JS554, JH910, JH930, JHF980, J36, V31, JME542, JME562 and JME564 for radius type.
- JS506, JS509, HK, HKM and J29 for conical type.
- JSB512, JS532, JS533, JS534, JHB970, JMB542, JMB562 and JMB563 for ball-nose type.

Tool Selection Unversal

Name		JSE512	JSE513	JSE514	JS553	JS554
Page(s)		37	41	47	57	77
Family name		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Type of mill						
Shank	Cylindrical	■	■	■	■	■
	Weldon	■	■	■	■	■
Number of Flutes		2	2	4	3	4
ICC						
Diameter range	Metric	2-12	2-20	2-25	2-25	3-25
	Inch			1/8-3/4	1/8 - 1/2	1/4-1
Length availability		2	2,3	2,3	1,2,3	1,2,3
Operation						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	●	●
M1-3		●	●	●	●	●
M4-5		○	○	○	●	●
K1-7		●	●	●	●	●
S1-3		○	○	○	●	●
S11-13		○	○	○	●	●
H3 H5 H8 H11 H12 H21 H31		○	○	○	●	●
N1		○	○	○	●	●
N2-3		○	○	○	●	●
N11		○	○	○	●	●
TS1		○	○	○	●	●
TP1		○	○	○	●	●
GR		○	○	○	○	○

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice
*JS554 3C also available. Can be applied in advanced roughing.

Seco

Tool Selection Unversal

Name		JS564	JS565	JS520	JS522	JSB512
Page(s)		102	106	110	114	117
Family name		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Type of mill						
Shank	Cylindrical	■	■	■	■	■
	Weldon	■	■	□		
Number of Flutes		4	5	5,6,8	2	2
ICC						
Diameter range	Metric	3-20	4-20	4-25	6-32	2-12
	Inch					
Length availability		2,3	2,3	2,3	4	2
Operation						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	●	○
M1-3		●	●	○	●	●
M4-5		●	●	○	●	○
K1-7		●	●	●	●	●
S1-3		●	●	○	○	○
S11-13		●	●	●	●	○
H3 H5 H8 H11 H12 H21 H31		●	●	○		○
N1		●	●	●	●	○
N2-3		●	●	●	●	○
N11		●	●	●	●	○
TS1				●	●	○
TP1				●	●	○
GR				○	○	○

■ Stock standard □ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

Tool Selection Unversal

Name		JS532	JS533	JS534	JS506	JS509
Page(s)		119	123	127	131	135
Family name		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Type of mill						
Shank	Cylindrical	■	■	■	■	■
	Weldon	□	■	■	■	■
Number of Flutes		2	3	4	3-4	3-4
ICC						
Diameter range	Metric	1-20	1-20	2-20	3-12	3-12
	Inch					
Length availability		1,2,3	1,2	1,2,3	2	2
Operation						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	○	○
M1-3		●	●	●	●	●
M4-5		●	●	●	●	●
K1-7		●	●	●	●	●
S1-3		○	○	○	○	○
S11-13		●	●	●	●	●
H3 H5 H8 H11 H12 H21 H31					●	●
N1		●	●	●	●	●
N2-3		●	●	●	●	●
N11		●	●	●	●	●
TS1		●	●	●	●	●
TP1		●	●	●	●	●
GR		○	○	○	○	○

■ Stock standard □ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

Seco

Tool Selection Unversal

Name		JH910	JH930	JHB970	JHF980
Page(s)		139	143, 392	145, 206	147
Family name		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM
Type of mill					
Shank	Cylindrical	■	■	■	■
	Weldon				
Number of Flutes		3	5-6, 8	2	2,3,4,5
ICC					
Diameter range	Metric	2-20	6-20	2-16	1-12
	Inch				
Length availability		2,3,4	2	1,2,3	1,2,3,4
Operation					
SMG					
P1-8		●	●	●	●
P11-12		○	○	○	○
M1-3		●		●	●
M4-5		●		●	●
K1-7		●	●		●
S1-3		●	●	●	●
S11-13		●	●	●	●
H3 H5 H8 H11 H12 H21 H31			●		○
N1					
N2-3					
N11					
TS1					
TP1		●			
GR		●			

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

Tool Selection Unversal

Name		J29	J36	HK/HKM	V31
Page(s)		151	154	157	168
Family name		VHM	VHM	VHM	VHM
Type of mill					
Shank	Cylindrical	■	■	■	■
	Weldon				
Number of Flutes		1	3	2,3,4	4
ICC					
Diameter range	Metric	0,2-6	2-20	1-10	6-28
	Inch				
Length availability		2	2	2	2
Operation					
SMG					
P1-8		●	○	●	●
P11-12		●	●		○
M1-3		●	○	●	●
M4-5		●	○	●	○
K1-7		●	○	●	●
S1-3		●	○	●	●
S11-13		●	○	●	●
H3 H5 H8 H11 H12 H21 H31		○		●	●
N1		●	○	●	●
N2-3		●	●	○	●
N11		●	●		●
TS1		●	○	●	●
TP1		●	○	●	●
GR		●			●

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

Seco

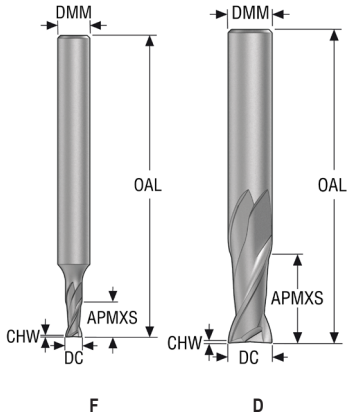
Tool Selection Unversal

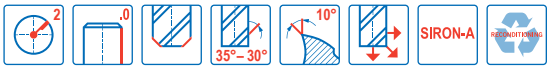
Name		JME542	JME562	JME564	JMB542	JMB562	JMB563
Page(s)		171	174	178	181	184	188
Family name		MINI	MINI	MINI	MINI	MINI	MINI
Type of mill							
Shank	Cylindrical	■	■	■	■	■	■
	Weldon						
Number of Flutes		2	2	4	2	2	3
ICC							
Diameter range	Metric	2-20	0,5-3,0	0,5-3,0	0,2-3,0	0,5-3,0	1,0-3,0
	Inch						
Length availability		1,3,4,5,6	2,4,5,6,7	2,4	1,3,4,5,6	1,2,3,4,5,6	2,4
Operation							
SMG							
P1-8		●	●	●	●	●	●
P11-12		●	●	●	●	●	●
M1-3		●	●	●	●	●	●
M4-5		●	●	●	●	●	●
K1-7							
S1-3							
S11-13		●	●	●	●	●	●
H3 H5 H8 H11 H12 H21 H31							
N1		○	○	○	○	○	○
N2-3		○	○	○	○	○	○
N11		○	○	○	○	○	○
TS1							
TP1							
GR		○	○	○	○	○	○

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

JSE512

General purpose – Universal – Square – 2 Flutes – Cylindrical – chamfer





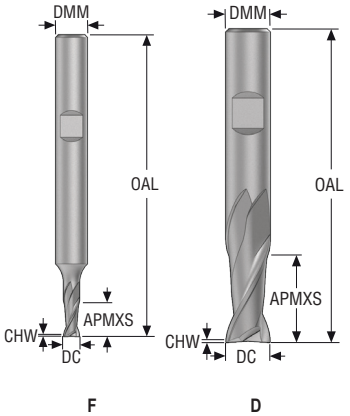
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø10

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JSE512021F2C.0Z2	SIRA	10052986	2	F	2,0	3,0	4,0	50,0	0,02	2	■
JSE512020F2C.0Z2	SIRA	10052990	2	F	2,0	6,0	4,0	57,0	0,02	2	■
JSE512030D2C.0Z2	SIRA	10052987	2	D	3,0	3,0	6,0	50,0	0,03	2	■
JSE512030F2C.0Z2	SIRA	10052991	2	F	3,0	6,0	6,0	57,0	0,03	2	■
JSE512040D2C.0Z2	SIRA	10052988	2	D	4,0	4,0	8,0	50,0	0,04	2	■
JSE512040F2C.0Z2	SIRA	10052992	2	F	4,0	6,0	8,0	57,0	0,04	2	■
JSE512050D2C.0Z2	SIRA	10052989	2	D	5,0	5,0	10,0	50,0	0,05	2	■
JSE512060D2C.0Z2	SIRA	10052993	2	D	6,0	6,0	12,0	57,0	0,06	2	■
JSE512080D2C.0Z2	SIRA	10052994	2	D	8,0	8,0	16,0	63,0	0,08	2	■
JSE512100D2C.0Z2	SIRA	10052995	2	D	10,0	10,0	20,0	72,0	0,1	2	■
JSE512120D2C.0Z2	SIRA	10052996	2	D	12,0	12,0	24,0	83,0	0,12	2	■

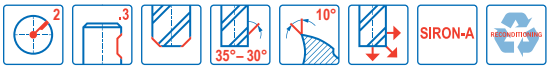
■ Stocked standard.

JSE512

General purpose – Universal – Square – 2 Flutes – Weldon – chamfer



- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø10



Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE512020F2C.3Z2	SIRA	10053113	2	F	2,0	6,0	4,0	57,0	0,02	2	■
JSE512030F2C.3Z2	SIRA	10053114	2	F	3,0	6,0	6,0	57,0	0,03	2	■
JSE512040F2C.3Z2	SIRA	10053115	2	F	4,0	6,0	8,0	57,0	0,04	2	■
JSE512060D2C.3Z2	SIRA	10053116	2	D	6,0	6,0	12,0	57,0	0,06	2	■
JSE512080D2C.3Z2	SIRA	10053117	2	D	8,0	8,0	16,0	63,0	0,08	2	■
JSE512100D2C.3Z2	SIRA	10053118	2	D	10,0	10,0	20,0	72,0	0,1	2	■
JSE512120D2C.3Z2	SIRA	10053119	2	D	12,0	12,0	24,0	83,0	0,12	2	■

■ Stocked standard.

Cutting data – JSE512 Side milling

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P2	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P3	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P4	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P5	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P6	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P7	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P8	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P11	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
P12	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M1	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M2	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M3	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M4	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M5	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
K1	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K2	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K3	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K4	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K5	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K6	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K7	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
N1	E/M/A	0.200 *0,200*	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	500 (380 — 630) *1650 (1300 — 2000)*
N11	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	365 (250 — 480) *1200 (830 — 1500)*
S11	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
S12	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
S13	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JSE512 Slot milling

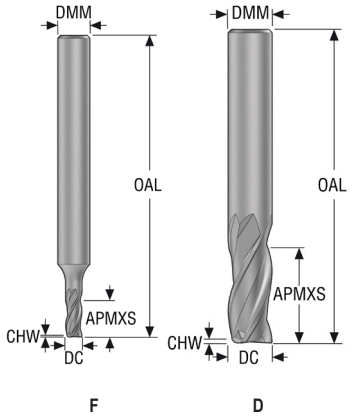
SMG		a_p/DC	f_z								v_c
			2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P3	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P5	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P6	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P7	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P11	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M1	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M2	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M3	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M4	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M5	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
K1	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K2	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K3	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K4	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K5	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K6	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K7	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
N1	E/M/A	0.40 *0,40*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	400 (300 — 500) *1300 (990 — 1600)*
N11	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	300 (200 — 390) *980 (660 — 1200)*
S11	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S12	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S13	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*

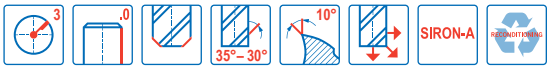
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JSE513

General purpose – Universal – Square – 3 Flutes – Cylindrical – chamfer





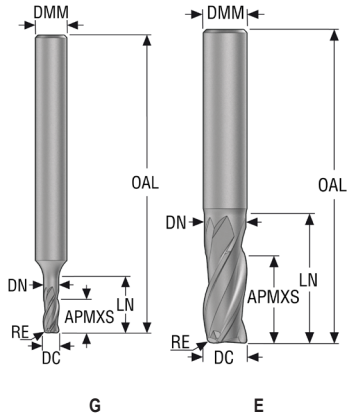
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø10

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JSE513020F2C.0Z3	SIRA	10053000	2	F	2,0	6,0	4,0	57,0	0,02	3	■
JSE513025F2C.0Z3	SIRA	10053001	2	F	2,5	6,0	5,0	57,0	0,025	3	■
JSE513030D2C.0Z3	SIRA	10052998	2	D	3,0	3,0	6,0	50,0	0,03	3	■
JSE513030F2C.0Z3	SIRA	10053002	2	F	3,0	6,0	6,0	57,0	0,03	3	■
JSE513040D2C.0Z3	SIRA	10052999	2	D	4,0	4,0	8,0	50,0	0,04	3	■
JSE513040F2C.0Z3	SIRA	10053003	2	F	4,0	6,0	8,0	57,0	0,04	3	■
JSE513050F2C.0Z3	SIRA	10053004	2	F	5,0	6,0	10,0	57,0	0,05	3	■
JSE513060D2C.0Z3	SIRA	10053005	2	D	6,0	6,0	12,0	57,0	0,06	3	■
JSE513070F2C.0Z3	SIRA	10053006	2	F	7,0	8,0	14,0	63,0	0,07	3	■
JSE513080D2C.0Z3	SIRA	10053007	2	D	8,0	8,0	16,0	63,0	0,08	3	■
JSE513090F2C.0Z3	SIRA	10053008	2	F	9,0	10,0	18,0	72,0	0,09	3	■
JSE513100D2C.0Z3	SIRA	10053009	2	D	10,0	10,0	20,0	72,0	0,1	3	■
JSE513110F2C.0Z3	SIRA	10053010	2	F	11,0	12,0	22,0	83,0	0,11	3	■
JSE513120D2C.0Z3	SIRA	10053011	2	D	12,0	12,0	24,0	83,0	0,12	3	■
JSE513140D2C.0Z3	SIRA	10053012	2	D	14,0	14,0	28,0	80,0	0,14	3	■
JSE513160D2C.0Z3	SIRA	10053013	2	D	16,0	16,0	32,0	92,0	0,16	3	■
JSE513180D2C.0Z3	SIRA	10053014	2	D	18,0	18,0	35,0	100,0	0,18	3	■
JSE513200D2C.0Z3	SIRA	10053015	2	D	20,0	20,0	35,0	104,0	0,2	3	■
JSE513030F3C.0Z3	SIRA	10053038	3	F	3,0	6,0	10,0	57,0	0,03	3	■
JSE513040F3C.0Z3	SIRA	10053039	3	F	4,0	6,0	14,0	57,0	0,04	3	■
JSE513050F3C.0Z3	SIRA	10053040	3	F	5,0	6,0	18,0	57,0	0,05	3	■
JSE513060D3C.0Z3	SIRA	10053046	3	D	6,0	6,0	20,0	63,0	0,06	3	■
JSE513080D3C.0Z3	SIRA	10053047	3	D	8,0	8,0	28,0	80,0	0,08	3	■
JSE513100D3C.0Z3	SIRA	10053048	3	D	10,0	10,0	35,0	89,0	0,1	3	■
JSE513120D3C.0Z3	SIRA	10053049	3	D	12,0	12,0	42,0	100,0	0,12	3	■
JSE513160D3C.0Z3	SIRA	10053050	3	D	16,0	16,0	50,0	115,0	0,16	3	■
JSE513200D3C.0Z3	SIRA	10053052	3	D	20,0	20,0	60,0	125,0	0,2	3	■
JSE513030F4C.0Z3	SIRA	10201454	4	F	3,0	6,0	15,0	57,0	0,03	3	■
JSE513040F4C.0Z3	SIRA	10201455	4	F	4,0	6,0	20,0	63,0	0,04	3	■
JSE513050F4C.0Z3	SIRA	10201456	4	F	5,0	6,0	25,0	75,0	0,05	3	■
JSE513060D4C.0Z3	SIRA	10201457	4	D	6,0	6,0	30,0	75,0	0,06	3	■
JSE513080D4C.0Z3	SIRA	10201458	4	D	8,0	8,0	40,0	87,0	0,08	3	■
JSE513100D4C.0Z3	SIRA	10201459	4	D	10,0	10,0	50,0	104,0	0,1	3	■
JSE513120D4C.0Z3	SIRA	10201460	4	D	12,0	12,0	60,0	125,0	0,12	3	■
JSE513160D4C.0Z3	SIRA	10201461	4	D	16,0	16,0	80,0	150,0	0,16	3	■
JSE513200D4C.0Z3	SIRA	10201462	4	D	20,0	20,0	100,0	170,0	0,2	3	■

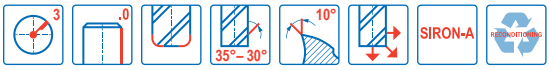
■ Stocked standard.

JSE513

General purpose – Universal – Square – 3 Flutes – Cylindrical – Corner radius



- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø10

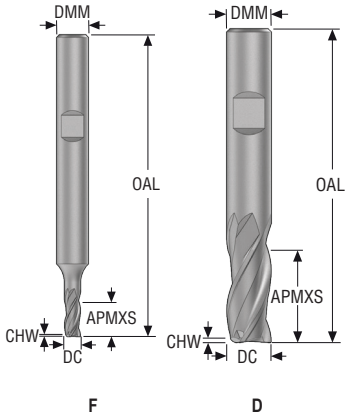


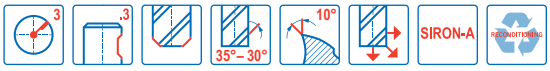
Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JSE513030G2R050.0Z3	SIRA	10053023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	■
JSE513040G2R050.0Z3	SIRA	10053024	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	■
JSE513050G2R050.0Z3	SIRA	10053025	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	■
JSE513060E2R050.0Z3	SIRA	10053026	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	■
JSE513060E2R100.0Z3	SIRA	10053032	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	■
JSE513080E2R050.0Z3	SIRA	10053027	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	■
JSE513080E2R100.0Z3	SIRA	10053033	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	■
JSE513100E2R050.0Z3	SIRA	10053028	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	■
JSE513100E2R100.0Z3	SIRA	10053034	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	■
JSE513120E2R050.0Z3	SIRA	10053029	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	■
JSE513120E2R100.0Z3	SIRA	10053035	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	■
JSE513160E2R050.0Z3	SIRA	10053030	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	■
JSE513160E2R100.0Z3	SIRA	10053036	2	E	16,0	16,0	28,0	92,0	42,0	15,2	1,0	3	■
JSE513200E2R050.0Z3	SIRA	10053031	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	■
JSE513200E2R100.0Z3	SIRA	10053037	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	3	■

■ Stocked standard.

JSE513

General purpose – Universal – Square – 3 Flutes – Weldon – chamfer





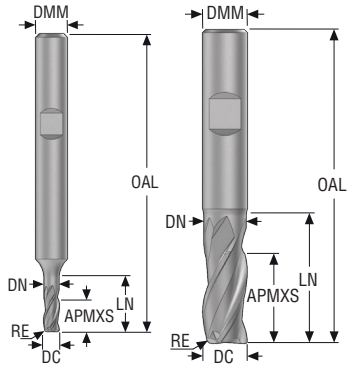
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø10

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE513020F2C.3Z3	SIRA	10053120	2	F	2,0	6,0	4,0	57,0	0,02	3	■
JSE513025F2C.3Z3	SIRA	10053121	2	F	2,5	6,0	5,0	57,0	0,025	3	■
JSE513030F2C.3Z3	SIRA	10053122	2	F	3,0	6,0	6,0	57,0	0,03	3	■
JSE513040F2C.3Z3	SIRA	10053123	2	F	4,0	6,0	8,0	57,0	0,04	3	■
JSE513050F2C.3Z3	SIRA	10053124	2	F	5,0	6,0	10,0	57,0	0,05	3	■
JSE513060D2C.3Z3	SIRA	10053125	2	D	6,0	6,0	12,0	57,0	0,06	3	■
JSE513070F2C.3Z3	SIRA	10053126	2	F	7,0	8,0	14,0	63,0	0,07	3	■
JSE513080D2C.3Z3	SIRA	10053127	2	D	8,0	8,0	16,0	63,0	0,08	3	■
JSE513090F2C.3Z3	SIRA	10053128	2	F	9,0	10,0	18,0	72,0	0,09	3	■
JSE513100D2C.3Z3	SIRA	10053129	2	D	10,0	10,0	20,0	72,0	0,1	3	■
JSE513110F2C.3Z3	SIRA	10053130	2	F	11,0	12,0	22,0	83,0	0,11	3	■
JSE513120D2C.3Z3	SIRA	10053131	2	D	12,0	12,0	24,0	83,0	0,12	3	■
JSE513140D2C.3Z3	SIRA	10053132	2	D	14,0	14,0	28,0	80,0	0,14	3	■
JSE513160D2C.3Z3	SIRA	10053133	2	D	16,0	16,0	32,0	92,0	0,16	3	■
JSE513180D2C.3Z3	SIRA	10053258	2	D	18,0	18,0	35,0	100,0	0,18	3	■
JSE513200D2C.3Z3	SIRA	10053259	2	D	20,0	20,0	35,0	104,0	0,2	3	■
JSE513030F3C.3Z3	SIRA	10053275	3	F	3,0	6,0	10,0	57,0	0,03	3	■
JSE513040F3C.3Z3	SIRA	10053276	3	F	4,0	6,0	14,0	57,0	0,04	3	■
JSE513050F3C.3Z3	SIRA	10053277	3	F	5,0	6,0	18,0	57,0	0,05	3	■
JSE513060D3C.3Z3	SIRA	10053283	3	D	6,0	6,0	20,0	63,0	0,06	3	■
JSE513080D3C.3Z3	SIRA	10053284	3	D	8,0	8,0	28,0	80,0	0,08	3	■
JSE513100D3C.3Z3	SIRA	10053285	3	D	10,0	10,0	35,0	89,0	0,1	3	■
JSE513120D3C.3Z3	SIRA	10053286	3	D	12,0	12,0	42,0	100,0	0,12	3	■
JSE513160D3C.3Z3	SIRA	10053287	3	D	16,0	16,0	50,0	115,0	0,16	3	■
JSE513200D3C.3Z3	SIRA	10053288	3	D	20,0	20,0	60,0	125,0	0,2	3	■
JSE513030F4C.3Z3	SIRA	10201463	4	F	3,0	6,0	15,0	57,0	0,03	3	■
JSE513040F4C.3Z3	SIRA	10201464	4	F	4,0	6,0	20,0	63,0	0,04	3	■
JSE513050F4C.3Z3	SIRA	10201465	4	F	5,0	6,0	25,0	75,0	0,05	3	■
JSE513060D4C.3Z3	SIRA	10201466	4	D	6,0	6,0	30,0	75,0	0,06	3	■
JSE513080D4C.3Z3	SIRA	10201467	4	D	8,0	8,0	40,0	87,0	0,08	3	■
JSE513100D4C.3Z3	SIRA	10201468	4	D	10,0	10,0	50,0	104,0	0,1	3	■
JSE513120D4C.3Z3	SIRA	10201469	4	D	12,0	12,0	60,0	125,0	0,12	3	■
JSE513160D4C.3Z3	SIRA	10201470	4	D	16,0	16,0	80,0	150,0	0,16	3	■
JSE513200D4C.3Z3	SIRA	10201471	4	D	20,0	20,0	100,0	170,0	0,2	3	■

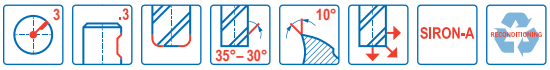
■ Stocked standard.

JSE513

General purpose – Universal – Square – 3 Flutes – Weldon – Corner radius



- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø10



Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JSE513030G2R050.3Z3	SIRA	10053260	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	■
JSE513040G2R050.3Z3	SIRA	10053261	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	■
JSE513050G2R050.3Z3	SIRA	10053262	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	■
JSE513060E2R050.3Z3	SIRA	10053263	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	■
JSE513060E2R100.3Z3	SIRA	10053269	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	■
JSE513080E2R050.3Z3	SIRA	10053264	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	■
JSE513080E2R100.3Z3	SIRA	10053270	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	■
JSE513100E2R050.3Z3	SIRA	10053265	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	■
JSE513100E2R100.3Z3	SIRA	10053271	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	■
JSE513120E2R050.3Z3	SIRA	10053266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	■
JSE513120E2R100.3Z3	SIRA	10053272	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	■
JSE513160E2R050.3Z3	SIRA	10053267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	■
JSE513160E2R100.3Z3	SIRA	10053273	2	E	16,0	16,0	28,0	92,0	42,0	15,2	1,0	3	■
JSE513200E2R050.3Z3	SIRA	10053268	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	■
JSE513200E2R100.3Z3	SIRA	10053274	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	3	■

■ Stocked standard.

Cutting data – JSE513 Side milling

SMG		a_e/DC	a_p/DC	f_z															v_c
				2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P2	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P3	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P4	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P5	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P6	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P7	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P8	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P11	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
P12	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (64 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (210 — 390)*
M1	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M2	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M3	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M4	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M5	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
K1	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K2	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K3	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K4	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K5	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K6	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K7	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
N1	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	510 (390 — 630)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*1675 (1300 — 2000)*
N11	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	385 (260 — 510)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*1275 (860 — 1600)*
S11	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
S12	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
S13	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JSE513 Slot milling

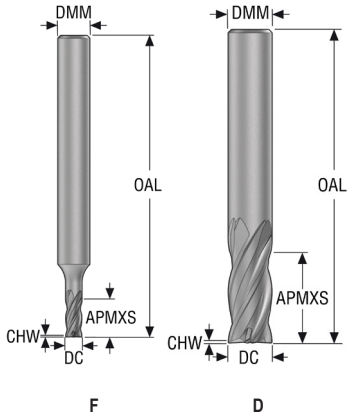
SMG		a_p/DC	f_z															v_c
			2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P2	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P3	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P4	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P5	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P6	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P7	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P8	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P11	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (51 — 100)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
P12	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M1	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M2	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M3	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M4	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M5	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
K1	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K2	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K3	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K4	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K5	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K6	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K7	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
N1	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	400 (310 — 500)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*1300 (1100 — 1600)*
N11	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	300 (200 — 400)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*980 (660 — 1300)*
S11	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S12	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S13	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*

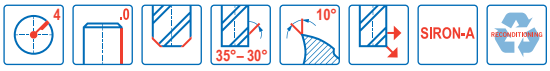
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JSE514

General purpose – Universal – Square – 4 Flutes – Cylindrical – chamfer





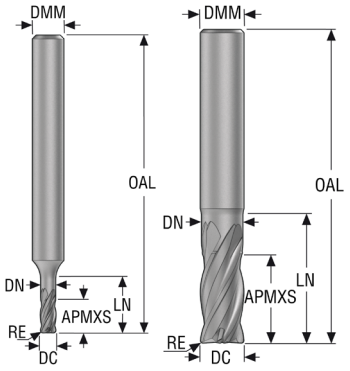
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø10

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JSE514021F2C.0Z4	SIRA	10053053	2	F	2,0	3,0	4,0	50,0	0,02	4	■
JSE514020F2C.0Z4	SIRA	10053057	2	F	2,0	6,0	4,0	57,0	0,02	4	■
JSE514030D2C.0Z4	SIRA	10053054	2	D	3,0	3,0	6,0	50,0	0,03	4	■
JSE514030F2C.0Z4	SIRA	10053058	2	F	3,0	6,0	6,0	57,0	0,03	4	■
JSE514040D2C.0Z4	SIRA	10053055	2	D	4,0	4,0	8,0	50,0	0,04	4	■
JSE514040F2C.0Z4	SIRA	10053059	2	F	4,0	6,0	8,0	57,0	0,04	4	■
JSE514050D2C.0Z4	SIRA	10053056	2	D	5,0	5,0	10,0	50,0	0,05	4	■
JSE514050F2C.0Z4	SIRA	10053060	2	F	5,0	6,0	10,0	57,0	0,05	4	■
JSE514060D2C.0Z4	SIRA	10053061	2	D	6,0	6,0	12,0	57,0	0,06	4	■
JSE514080D2C.0Z4	SIRA	10053062	2	D	8,0	8,0	16,0	63,0	0,08	4	■
JSE514100D2C.0Z4	SIRA	10053063	2	D	10,0	10,0	20,0	72,0	0,1	4	■
JSE514120D2C.0Z4	SIRA	10053064	2	D	12,0	12,0	24,0	83,0	0,12	4	■
JSE514160D2C.0Z4	SIRA	10053067	2	D	16,0	16,0	32,0	92,0	0,16	4	■
JSE514180D2C.0Z4	SIRA	10053068	2	D	18,0	18,0	35,0	100,0	0,18	4	■
JSE514200D2C.0Z4	SIRA	10053069	2	D	20,0	20,0	35,0	104,0	0,2	4	■
JSE514250D2C.0Z4	SIRA	10053070	2	D	25,0	25,0	40,0	125,0	0,25	4	■
JSE514030F3C.0Z4	SIRA	10053090	3	F	3,0	6,0	10,0	57,0	0,03	4	■
JSE514040F3C.0Z4	SIRA	10053091	3	F	4,0	6,0	14,0	57,0	0,04	4	■
JSE514050F3C.0Z4	SIRA	10053092	3	F	5,0	6,0	18,0	57,0	0,05	4	■
JSE514060D3C.0Z4	SIRA	10053093	3	D	6,0	6,0	20,0	63,0	0,06	4	■
JSE514080D3C.0Z4	SIRA	10053094	3	D	8,0	8,0	28,0	80,0	0,08	4	■
JSE514100D3C.0Z4	SIRA	10053095	3	D	10,0	10,0	35,0	89,0	0,1	4	■
JSE514120D3C.0Z4	SIRA	10053096	3	D	12,0	12,0	42,0	100,0	0,12	4	■
JSE514160D3C.0Z4	SIRA	10053097	3	D	16,0	16,0	50,0	115,0	0,16	4	■
JSE514200D3C.0Z4	SIRA	10053098	3	D	20,0	20,0	60,0	125,0	0,2	4	■
JSE514030F4C.0Z4	SIRA	10201472	4	F	3,0	6,0	15,0	57,0	0,03	4	■
JSE514040F4C.0Z4	SIRA	10201473	4	F	4,0	6,0	20,0	63,0	0,04	4	■
JSE514050F4C.0Z4	SIRA	10201474	4	F	5,0	6,0	25,0	75,0	0,05	4	■
JSE514060D4C.0Z4	SIRA	10201475	4	D	6,0	6,0	30,0	75,0	0,06	4	■
JSE514080D4C.0Z4	SIRA	10201476	4	D	8,0	8,0	40,0	87,0	0,08	4	■
JSE514100D4C.0Z4	SIRA	10201477	4	D	10,0	10,0	50,0	104,0	0,1	4	■
JSE514120D4C.0Z4	SIRA	10201478	4	D	12,0	12,0	60,0	125,0	0,12	4	■
JSE514160D4C.0Z4	SIRA	10201479	4	D	16,0	16,0	80,0	150,0	0,16	4	■
JSE514200D4C.0Z4	SIRA	10201480	4	D	20,0	20,0	100,0	170,0	0,2	4	■

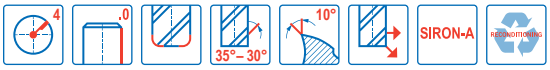
■ Stocked standard.

JSE514

General purpose – Universal – Square – 4 Flutes – Cylindrical – Corner radius



- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø10

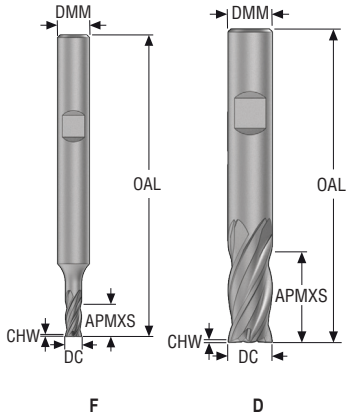


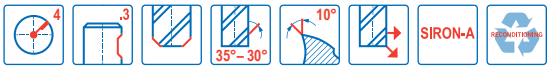
Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JSE514030G2R050.0Z4	SIRA	10053071	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	■
JSE514040G2R050.0Z4	SIRA	10053072	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	■
JSE514050G2R050.0Z4	SIRA	10053073	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	■
JSE514060E2R050.0Z4	SIRA	10053074	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JSE514060E2R100.0Z4	SIRA	10053081	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JSE514080E2R050.0Z4	SIRA	10053075	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JSE514080E2R100.0Z4	SIRA	10053082	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JSE514100E2R050.0Z4	SIRA	10053076	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JSE514100E2R100.0Z4	SIRA	10053083	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JSE514120E2R050.0Z4	SIRA	10053077	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JSE514120E2R100.0Z4	SIRA	10053084	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JSE514160E2R050.0Z4	SIRA	10053078	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JSE514160E2R100.0Z4	SIRA	10053087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JSE514200E2R050.0Z4	SIRA	10053079	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	■
JSE514200E2R100.0Z4	SIRA	10053088	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	■
JSE514250E2R050.0Z4	SIRA	10053080	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	■
JSE514250E2R100.0Z4	SIRA	10053089	2	E	25,0	25,0	40,0	125,0	66,0	23,8	1,0	4	■

■ Stocked standard.

JSE514

General purpose – Universal – Square – 4 Flutes – Weldon – chamfer





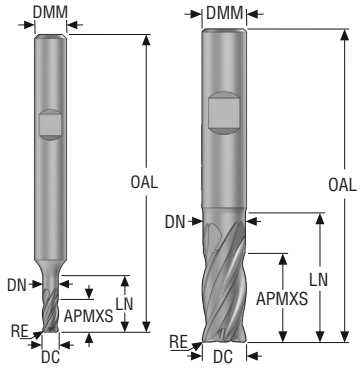
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø10

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE514020F2C.3Z4	SIRA	10053289	2	F	2,0	6,0	4,0	57,0	0,02	4	■
JSE514030F2C.3Z4	SIRA	10053290	2	F	3,0	6,0	6,0	57,0	0,03	4	■
JSE514040F2C.3Z4	SIRA	10053291	2	F	4,0	6,0	8,0	57,0	0,04	4	■
JSE514050F2C.3Z4	SIRA	10053292	2	F	5,0	6,0	10,0	57,0	0,05	4	■
JSE514060D2C.3Z4	SIRA	10053293	2	D	6,0	6,0	12,0	57,0	0,06	4	■
JSE514080D2C.3Z4	SIRA	10053294	2	D	8,0	8,0	16,0	63,0	0,08	4	■
JSE514100D2C.3Z4	SIRA	10053295	2	D	10,0	10,0	20,0	72,0	0,1	4	■
JSE514120D2C.3Z4	SIRA	10053296	2	D	12,0	12,0	24,0	83,0	0,12	4	■
JSE514160D2C.3Z4	SIRA	10053297	2	D	16,0	16,0	32,0	92,0	0,16	4	■
JSE514180D2C.3Z4	SIRA	10053298	2	D	18,0	18,0	35,0	100,0	0,18	4	■
JSE514200D2C.3Z4	SIRA	10053299	2	D	20,0	20,0	35,0	104,0	0,2	4	■
JSE514250D2C.3Z4	SIRA	10053300	2	D	25,0	25,0	40,0	125,0	0,25	4	■
JSE514030F3C.3Z4	SIRA	10053321	3	F	3,0	6,0	10,0	57,0	0,03	4	■
JSE514040F3C.3Z4	SIRA	10053322	3	F	4,0	6,0	14,0	57,0	0,04	4	■
JSE514050F3C.3Z4	SIRA	10053323	3	F	5,0	6,0	18,0	57,0	0,05	4	■
JSE514060D3C.3Z4	SIRA	10053324	3	D	6,0	6,0	20,0	63,0	0,06	4	■
JSE514080D3C.3Z4	SIRA	10053325	3	D	8,0	8,0	28,0	80,0	0,08	4	■
JSE514100D3C.3Z4	SIRA	10053326	3	D	10,0	10,0	35,0	89,0	0,1	4	■
JSE514120D3C.3Z4	SIRA	10053327	3	D	12,0	12,0	42,0	100,0	0,12	4	■
JSE514160D3C.3Z4	SIRA	10053328	3	D	16,0	16,0	50,0	115,0	0,16	4	■
JSE514200D3C.3Z4	SIRA	10053329	3	D	20,0	20,0	60,0	125,0	0,2	4	■
JSE514030F4C.3Z4	SIRA	10201481	4	F	3,0	6,0	15,0	57,0	0,03	4	■
JSE514040F4C.3Z4	SIRA	10201482	4	F	4,0	6,0	20,0	63,0	0,04	4	■
JSE514050F4C.3Z4	SIRA	10201483	4	F	5,0	6,0	25,0	75,0	0,05	4	■
JSE514060D4C.3Z4	SIRA	10201484	4	D	6,0	6,0	30,0	75,0	0,06	4	■
JSE514080D4C.3Z4	SIRA	10201485	4	D	8,0	8,0	40,0	87,0	0,08	4	■
JSE514100D4C.3Z4	SIRA	10201486	4	D	10,0	10,0	50,0	104,0	0,1	4	■
JSE514120D4C.3Z4	SIRA	10201487	4	D	12,0	12,0	60,0	125,0	0,12	4	■
JSE514160D4C.3Z4	SIRA	10201488	4	D	16,0	16,0	80,0	150,0	0,16	4	■
JSE514200D4C.3Z4	SIRA	10201489	4	D	20,0	20,0	100,0	170,0	0,2	4	■

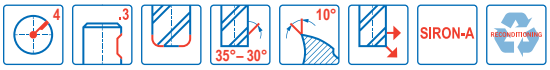
■ Stocked standard.

JSE514

General purpose – Universal – Square – 4 Flutes – Weldon – Corner radius



- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø10

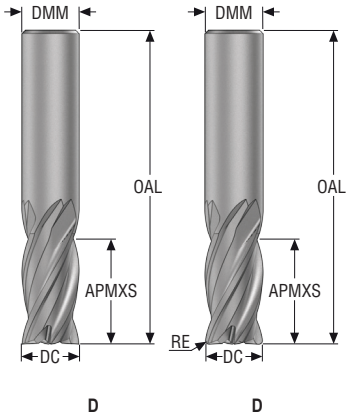


Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JSE514030G2R050.3Z4	SIRA	10053301	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	■
JSE514040G2R050.3Z4	SIRA	10053302	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	■
JSE514050G2R050.3Z4	SIRA	10053306	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	■
JSE514060E2R050.3Z4	SIRA	10053307	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JSE514060E2R100.3Z4	SIRA	10053314	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JSE514080E2R050.3Z4	SIRA	10053308	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JSE514080E2R100.3Z4	SIRA	10053315	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JSE514100E2R050.3Z4	SIRA	10053309	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JSE514100E2R100.3Z4	SIRA	10053316	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JSE514120E2R050.3Z4	SIRA	10053310	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JSE514120E2R100.3Z4	SIRA	10053317	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JSE514160E2R050.3Z4	SIRA	10053311	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JSE514160E2R100.3Z4	SIRA	10053318	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JSE514200E2R050.3Z4	SIRA	10053312	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	■
JSE514200E2R100.3Z4	SIRA	10053319	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	■
JSE514250E2R050.3Z4	SIRA	10053313	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	■
JSE514250E2R100.3Z4	SIRA	10053320	2	E	25,0	25,0	40,0	125,0	66,0	23,8	1,0	4	■

■ Stocked standard.

JSE514

General purpose – Universal – Square – 4 Flutes – Cylindrical – Sharp or corner radius – *Inch*



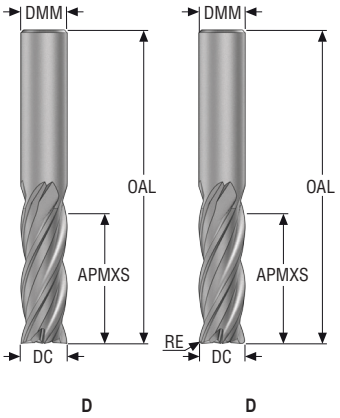
- Tolerances:
- DMM=h5
- DC=e8
- RE= ±.002 Inch
- Regrind possible if DC is ≥Ø.375

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
					inch	inch	inch	inch	inch		
JSE514.250D1S.0Z4	SIRA	10201805	1	D	0.250	0.250	0.375	2.000	–	4	■
JSE514.250D1R030.0Z4	SIRA	10201812	1	D	0.250	0.250	0.375	2.000	0.030	4	■
JSE514.375D1S.0Z4	SIRA	10201806	1	D	0.375	0.375	0.500	2.000	–	4	■
JSE514.375D1R030.0Z4	SIRA	10201813	1	D	0.375	0.375	0.500	2.000	0.030	4	■
JSE514.500D1S.0Z4	SIRA	10201807	1	D	0.500	0.500	0.625	2.500	–	4	■
JSE514.500D1R030.0Z4	SIRA	10201814	1	D	0.500	0.500	0.625	2.500	0.030	4	■
JSE514.500D1R060.0Z4	SIRA	10201815	1	D	0.500	0.500	0.625	2.500	0.060	4	■
JSE514.625D1S.0Z4	SIRA	10201808	1	D	0.625	0.625	0.750	3.000	–	4	■
JSE514.625D1R030.0Z4	SIRA	10201816	1	D	0.625	0.625	0.750	3.000	0.030	4	■
JSE514.625D1R060.0Z4	SIRA	10201817	1	D	0.625	0.625	0.750	3.000	0.060	4	■
JSE514.750D1S.0Z4	SIRA	10201809	1	D	0.750	0.750	0.875	3.000	–	4	■
JSE514.750D1R030.0Z4	SIRA	10201818	1	D	0.750	0.750	0.875	3.000	0.030	4	■
JSE514.750D1R060.0Z4	SIRA	10201819	1	D	0.750	0.750	0.875	3.000	0.060	4	■
JSE514.125D2S.0Z4	SIRA	10201803	2	D	0.125	0.125	0.250	1.500	–	4	■
JSE514.125D2R015.0Z4	SIRA	10201810	2	D	0.125	0.125	0.250	1.500	0.015	4	■
JSE514.188D2S.0Z4	SIRA	10201804	2	D	0.188	0.188	0.375	2.000	–	4	■
JSE514.188D2R020.0Z4	SIRA	10201811	2	D	0.188	0.188	0.375	2.000	0.020	4	■
JSE514.250D2S.0Z4	SIRA	10201822	2	D	0.250	0.250	0.500	2.000	–	4	■
JSE514.250D2R030.0Z4	SIRA	10201829	2	D	0.250	0.250	0.500	2.000	0.030	4	■
JSE514.375D2S.0Z4	SIRA	10201823	2	D	0.375	0.375	0.625	2.000	–	4	■
JSE514.375D2R030.0Z4	SIRA	10201830	2	D	0.375	0.375	0.625	2.000	0.030	4	■
JSE514.500D2S.0Z4	SIRA	10201824	2	D	0.500	0.500	1.000	3.000	–	4	■
JSE514.500D2R030.0Z4	SIRA	10201831	2	D	0.500	0.500	1.000	3.000	0.030	4	■
JSE514.500D2R060.0Z4	SIRA	10201832	2	D	0.500	0.500	1.000	3.000	0.060	4	■
JSE514.625D2S.0Z4	SIRA	10201825	2	D	0.625	0.625	1.250	3.500	–	4	■
JSE514.625D2R030.0Z4	SIRA	10201833	2	D	0.625	0.625	1.250	3.500	0.030	4	■
JSE514.625D2R060.0Z4	SIRA	10201834	2	D	0.625	0.625	1.250	3.500	0.060	4	■
JSE514.750D2S.0Z4	SIRA	10201826	2	D	0.750	0.750	1.500	4.000	–	4	■
JSE514.750D2R030.0Z4	SIRA	10201835	2	D	0.750	0.750	1.500	4.000	0.030	4	■
JSE514.750D2R060.0Z4	SIRA	10201836	2	D	0.750	0.750	1.500	4.000	0.060	4	■

■ Stocked standard.

JSE514

General purpose – Universal – Square – 4 Flutes – Cylindrical – Sharp or corner radius – *Inch*



- Tolerances:
- DMM=h5
- DC=e8
- RE= ±.002 Inch
- Regrind possible if DC is ≥Ø.375

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
					inch	inch	inch	inch	inch		
JSE514.125D3S.0Z4	SIRA	10201820	3	D	0.125	0.125	0.500	1.500	–	4	■
JSE514.125D3R015.0Z4	SIRA	10201827	3	D	0.125	0.125	0.500	1.500	0.015	4	■
JSE514.188D3S.0Z4	SIRA	10201821	3	D	0.188	0.188	0.625	2.000	–	4	■
JSE514.188D3R020.0Z4	SIRA	10201828	3	D	0.188	0.188	0.625	2.000	0.020	4	■
JSE514.250D3S.0Z4	SIRA	10201837	3	D	0.250	0.250	0.750	2.500	–	4	■
JSE514.250D3R030.0Z4	SIRA	10201842	3	D	0.250	0.250	0.750	2.500	0.030	4	■
JSE514.375D3S.0Z4	SIRA	10201838	3	D	0.375	0.375	1.000	2.500	–	4	■
JSE514.375D3R030.0Z4	SIRA	10201843	3	D	0.375	0.375	1.000	2.500	0.030	4	■
JSE514.500D3S.0Z4	SIRA	10201839	3	D	0.500	0.500	2.000	4.000	–	4	■
JSE514.500D3R030.0Z4	SIRA	10201844	3	D	0.500	0.500	2.000	4.000	0.030	4	■
JSE514.500D3R060.0Z4	SIRA	10201845	3	D	0.500	0.500	2.000	4.000	0.060	4	■
JSE514.625D3S.0Z4	SIRA	10201840	3	D	0.625	0.625	2.250	5.000	–	4	■
JSE514.625D3R030.0Z4	SIRA	10201846	3	D	0.625	0.625	2.250	5.000	0.030	4	■
JSE514.625D3R060.0Z4	SIRA	10201847	3	D	0.625	0.625	2.250	5.000	0.060	4	■
JSE514.750D3S.0Z4	SIRA	10201841	3	D	0.750	0.750	2.250	5.000	–	4	■
JSE514.750D3R030.0Z4	SIRA	10201848	3	D	0.750	0.750	2.250	5.000	0.030	4	■
JSE514.750D3R060.0Z4	SIRA	10201849	3	D	0.750	0.750	2.250	5.000	0.060	4	■

■ Stocked standard.

Cutting data – JSE514 Side milling

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.11 *0,0044*	0.13 *0,0050*	160 (67 — 190) *520 (220 — 620)*
P3	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P4	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P5	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P6	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P7	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P8	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P11	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
P12	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M2	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M3	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M4	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M5	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
K1	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K2	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K3	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K4	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K5	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K6	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K7	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
N1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	410 (280 — 540) *1350 (920 — 1700)*
S11	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
S12	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
S13	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JSE514 Slot milling

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P2	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P3	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P4	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 140)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 450)*
P5	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P6	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 140)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 450)*
P7	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P8	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P11	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (51 — 100)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
P12	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M1	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M2	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M3	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M4	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M5	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
K1	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K2	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K3	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K4	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K5	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K6	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K7	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
N1	E/M/A	0.30	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	400 (300 — 500)
		0,30	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*1300 (990 — 1600)*
N11	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	300 (200 — 390)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*980 (660 — 1200)*
S11	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
S12	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
S13	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS514 Side milling – *Inch*

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/8	3/16	1.4	3/8	1/2	5/8	3/4	
P1	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,022 *0.00085*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	160 (67 — 200) *520 (220 — 650)*
P3	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P4	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P5	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P6	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P7	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P8	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P11	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
P12	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M1	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M2	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M3	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M4	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M5	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
K1	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K2	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K3	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K4	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K5	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K6	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K7	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
N1	E/M/A	0,15 *0.15*	1,2 *1.2*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	410 (280 — 540) *1350 (920 — 1700)*
S11	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
S12	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
S13	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JS514 Slot milling – *Inch*

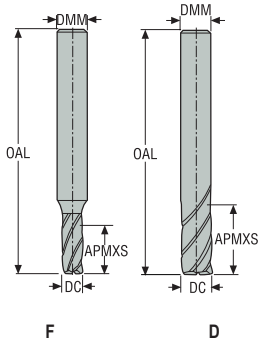
SMG		a_p/DC	f_z							v_c
			1/8	3/16	1/4	3/8	1/2	5/8	3/4	
P1	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P3	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P5	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P6	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P7	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P11	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M1	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M2	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M3	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M4	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M5	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
K1	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K2	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K3	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K4	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K5	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K6	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K7	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
N1	E/M/A	0,30 *0.30*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	400 (310 — 500) *1300 (1100 — 1600)*
N11	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	300 (210 — 400) *980 (690 — 1300)*
S11	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
S12	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
S13	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*

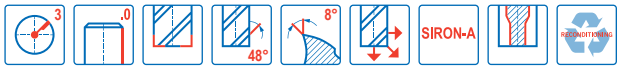
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS553

High performance – Universal – Square – 3 Flutes – Cylindrical – Sharp





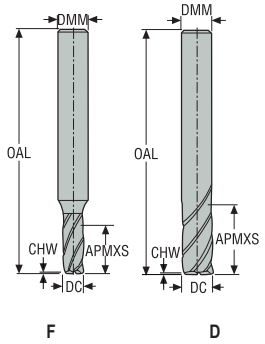
- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
553020SZ3.0-SIRON-A	02733903	2	F	2,0	6,0	5,0	50,0	3	■
553030SZ3.0-SIRON-A	02733906	2	F	3,0	6,0	7,0	50,0	3	■
553040SZ3.0-SIRON-A	02733910	2	F	4,0	6,0	10,0	55,0	3	■
553050SZ3.0-SIRON-A	02733912	2	F	5,0	6,0	12,0	55,0	3	■
553060SZ3.0-SIRON-A	02733914	2	D	6,0	6,0	14,0	55,0	3	■
553080SZ3.0-SIRON-A	02733918	2	D	8,0	8,0	18,0	60,0	3	■
553100SZ3.0-SIRON-A	02733922	2	D	10,0	10,0	22,0	70,0	3	■

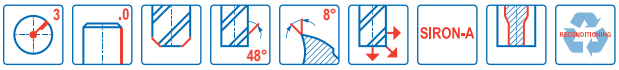
■ Stocked standard.

JS553

High performance – Universal – Square – 3 Flutes – Cylindrical – Chamfer



- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

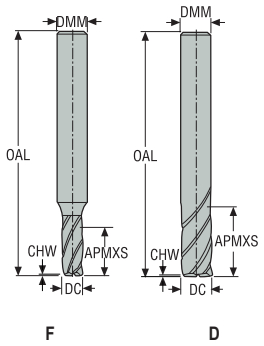


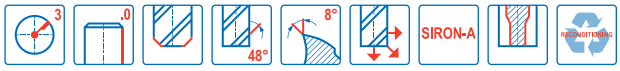
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS553020F1C.0Z3-SIRA	10041466	1	F	2,0	6,0	3,0	40,0	0,025	3	■
JS553030F1C.0Z3-SIRA	10041467	1	F	3,0	6,0	4,0	40,0	0,035	3	■
JS553040F1C.0Z3-SIRA	10041468	1	F	4,0	6,0	6,0	40,0	0,045	3	■
JS553045F1C.0Z3-SIRA	10041469	1	F	4,5	6,0	6,0	40,0	0,045	3	■
JS553050F1C.0Z3-SIRA	10041470	1	F	5,0	6,0	7,0	40,0	0,055	3	■
JS553055F1C.0Z3-SIRA	10041472	1	F	5,5	6,0	8,0	40,0	0,055	3	■
JS553060D1C.0Z3-SIRA	10041473	1	D	6,0	6,0	8,0	40,0	0,075	3	■
JS553080D1C.0Z3-SIRA	10041474	1	D	8,0	8,0	11,0	50,0	0,1	3	■
JS553100D1C.0Z3-SIRA	10041475	1	D	10,0	10,0	13,0	57,0	0,125	3	■
JS553120D1C.0Z3-SIRA	10041476	1	D	12,0	12,0	15,0	65,0	0,15	3	■
553020Z3.0-SIRON-A	02679241	2	F	2,0	6,0	5,0	50,0	0,025	3	■
553025Z3.0-SIRON-A	02679352	2	F	2,5	6,0	7,0	50,0	0,025	3	■
553030Z3.0-SIRON-A	02679353	2	F	3,0	6,0	7,0	50,0	0,035	3	■
553035Z3.0-SIRON-A	02679359	2	F	3,5	6,0	9,0	55,0	0,035	3	■
553040Z3.0-SIRON-A	02679360	2	F	4,0	6,0	10,0	55,0	0,045	3	■
553045Z3.0-SIRON-A	02679361	2	F	4,5	6,0	12,0	55,0	0,045	3	■
553050Z3.0-SIRON-A	02679364	2	F	5,0	6,0	12,0	55,0	0,055	3	■
553055Z3.0-SIRON-A	02679365	2	F	5,5	6,0	14,0	55,0	0,055	3	■
553060Z3.0-SIRON-A	02679368	2	D	6,0	6,0	14,0	55,0	0,075	3	■
553075Z3.0-SIRON-A	02733916	2	F	7,5	8,0	18,0	60,0	0,1	3	■
553080Z3.0-SIRON-A	02679371	2	D	8,0	8,0	18,0	60,0	0,1	3	■
553095Z3.0-SIRON-A	02733920	2	F	9,5	10,0	22,0	70,0	0,125	3	■
553100Z3.0-SIRON-A	02679374	2	D	10,0	10,0	22,0	70,0	0,125	3	■
553115Z3.0-SIRON-A	02733925	2	F	11,5	12,0	26,0	80,0	0,15	3	■
553120Z3.0-SIRON-A	02679380	2	D	12,0	12,0	26,0	80,0	0,15	3	■
553140Z3.0-SIRON-A	02733932	2	D	14,0	14,0	30,0	85,0	0,175	3	■
553160Z3.0-SIRON-A	02679384	2	D	16,0	16,0	34,0	90,0	0,2	3	■
553200Z3.0-SIRON-A	02679389	2	D	20,0	20,0	42,0	110,0	0,25	3	■
553250Z3.0-SIRON-A	02679393	2	D	25,0	25,0	52,0	125,0	0,3	3	■

■ Stocked standard.

JS553

High performance – Universal – Square – 3 Flutes – Cylindrical – Chamfer





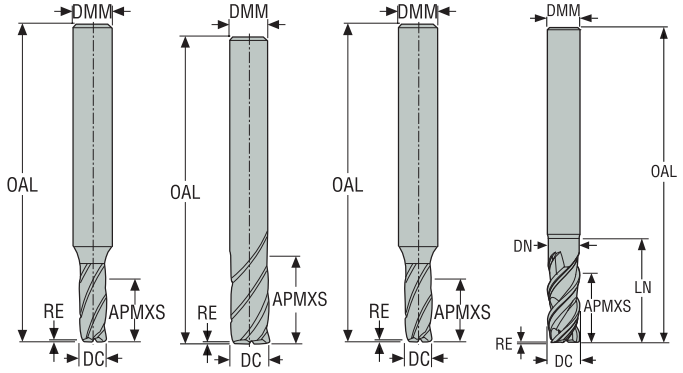
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
553L020Z3.0-SIRON-A	02733962	3	F	2,0	6,0	7,0	50,0	0,025	3	■
553L030Z3.0-SIRON-A	02733971	3	F	3,0	6,0	10,0	55,0	0,035	3	■
553L040Z3.0-SIRON-A	02733972	3	F	4,0	6,0	14,0	60,0	0,045	3	■
553L050Z3.0-SIRON-A	02733974	3	F	5,0	6,0	18,0	60,0	0,055	3	■
553L060Z3.0-SIRON-A	02733982	3	D	6,0	6,0	20,0	65,0	0,075	3	■
553L080Z3.0-SIRON-A	02733986	3	D	8,0	8,0	28,0	70,0	0,1	3	■
553L100Z3.0-SIRON-A	02733992	3	D	10,0	10,0	35,0	85,0	0,125	3	■
553L120Z3.0-SIRON-A	02733994	3	D	12,0	12,0	40,0	95,0	0,15	3	■
553L160Z3.0-SIRON-A	02733996	3	D	16,0	16,0	50,0	110,0	0,2	3	■
553L200Z3.0-SIRON-A	02733998	3	D	20,0	20,0	60,0	125,0	0,25	3	■
553L250Z3.0-SIRON-A	02734000	3	D	25,0	25,0	75,0	150,0	0,3	3	■

■ Stocked standard.

JS553

High performance – Universal – Square – 3 Flutes – Cylindrical – Corner radius



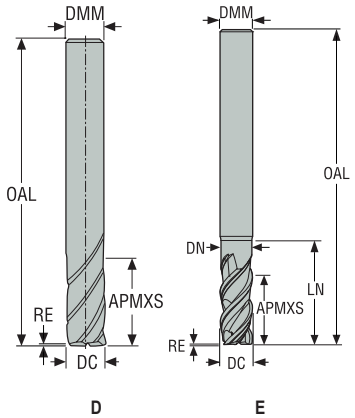
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS553020F1R020.0Z3-SIRA	10194458	1	F	2,0	6,0	3,0	40,0	5,0	2,05	0,2	3	■
JS553030F1R020.0Z3-SIRA	10194459	1	F	3,0	6,0	4,0	40,0	6,0	3,05	0,2	3	■
JS553040F1R020.0Z3-SIRA	10194460	1	F	4,0	6,0	6,0	40,0	9,0	4,05	0,2	3	■
JS553050F1R020.0Z3-SIRA	10194461	1	F	5,0	6,0	7,0	40,0	10,0	5,05	0,2	3	■
JS553060D1R020.0Z3-SIRA	10194462	1	D	6,0	6,0	8,0	40,0	–	–	0,2	3	■
JS553060D1R050.0Z3-SIRA	10194463	1	D	6,0	6,0	8,0	40,0	–	–	0,5	3	■
JS553080D1R050.0Z3-SIRA	10194464	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	■
JS553100D1R050.0Z3-SIRA	10194465	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	■
JS553100D1R100.0Z3-SIRA	10194466	1	D	10,0	10,0	13,0	57,0	–	–	1,0	3	■
JS553120D1R050.0Z3-SIRA	10194467	1	D	12,0	12,0	15,0	65,0	–	–	0,5	3	■
JS553120D1R100.0Z3-SIRA	10194468	1	D	12,0	12,0	15,0	65,0	–	–	1,0	3	■
JS553020G2R050.0Z3-SIRA	02881683	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	■
553030R015Z3.0-SIRON-A	02733908	2	F	3,0	6,0	7,0	50,0	8,5	3,0	0,15	3	■
JS553030G2R050.0Z3-SIRA	02881684	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	■
553040R020Z3.0-SIRON-A	02733911	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,2	3	■
JS553040G2R050.0Z3-SIRA	02881685	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	■
553050R020Z3.0-SIRON-A	02687282	2	F	5,0	6,0	12,0	55,0	14,7	5,0	0,2	3	■
JS553050G2R050.0Z3-SIRA	02881686	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	■
553060R020Z3.0-SIRON-A	02679369	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	■
JS553060E2R050.0Z3-SIRA	02881687	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	■
JS553060E2R100.0Z3-SIRA	02881688	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	■
553080R050Z3.0-SIRON-A	02679372	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	■
553100R050Z3.0-SIRON-A	02679375	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	■
553100R100Z3.0-SIRON-A	02679376	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	■
553100R200Z3.0-SIRON-A	02810364	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	■
553100R250Z3.0-SIRON-A	02810365	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	■
553100R310Z3.0-SIRON-A	02810366	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	■
553120R050Z3.0-SIRON-A	02679381	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	■
553120R100Z3.0-SIRON-A	02679382	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	■
553120R200Z3.0-SIRON-A	02810367	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	■
553120R250Z3.0-SIRON-A	02810368	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	■
553120R310Z3.0-SIRON-A	02810369	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	■

■ Stocked standard.

JS553

High performance – Universal – Square – 3 Flutes – Cylindrical – Corner radius



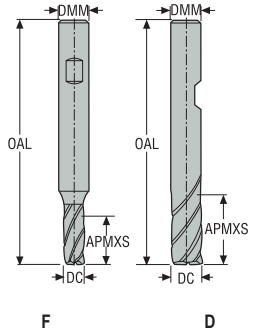
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
553160R050Z3.0-SIRON-A	02679385	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	■
553160R100Z3.0-SIRON-A	02679386	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	■
553160R200Z3.0-SIRON-A	02810370	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	■
553160R250Z3.0-SIRON-A	02810371	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	■
553160R310Z3.0-SIRON-A	02810372	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	■
553160R400Z3.0-SIRON-A	02810373	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	■
553200R050Z3.0-SIRON-A	02679390	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	■
553200R100Z3.0-SIRON-A	02679391	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	■
JS553200E2R200.0Z3-SIRA	02881689	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	■
553250R050Z3.0-SIRON-A	02679395	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	■
553250R100Z3.0-SIRON-A	02679396	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	■

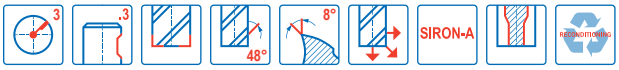
■ Stocked standard.

JS553

High performance – Universal – Square – 3 Flutes – Weldon – Sharp



- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

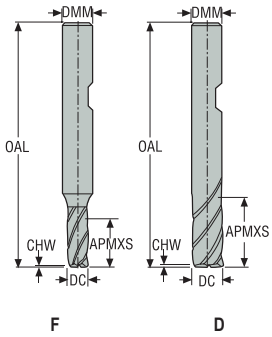


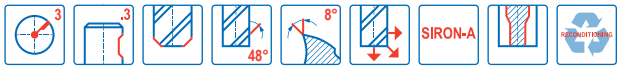
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
553020SZ3.0-SIRON-AW	02733936	2	F	2,0	6,0	5,0	50,0	3	■
553030SZ3.0-SIRON-AW	02733939	2	F	3,0	6,0	7,0	50,0	3	■
553040SZ3.0-SIRON-AW	02733943	2	F	4,0	6,0	10,0	55,0	3	■
553050SZ3.0-SIRON-AW	02733945	2	F	5,0	6,0	12,0	55,0	3	■
553060SZ3.0-SIRON-AW	02733946	2	D	6,0	6,0	14,0	55,0	3	■
553080SZ3.0-SIRON-AW	02733950	2	D	8,0	8,0	18,0	60,0	3	■
553100SZ3.0-SIRON-AW	02733952	2	D	10,0	10,0	22,0	70,0	3	■

■ Stocked standard.

JS553

High performance – Universal – Square – 3 Flutes – Weldon – Chamfer





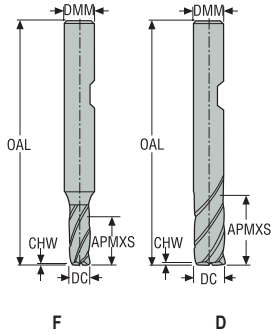
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS553020F1C.3Z3-SIRA	10041477	1	F	2,0	6,0	3,0	40,0	0,025	3	■
JS553030F1C.3Z3-SIRA	10041478	1	F	3,0	6,0	4,0	40,0	0,035	3	■
JS553040F1C.3Z3-SIRA	10041479	1	F	4,0	6,0	6,0	40,0	0,045	3	■
JS553045F1C.3Z3-SIRA	10041480	1	F	4,5	6,0	6,0	40,0	0,045	3	■
JS553050F1C.3Z3-SIRA	10041481	1	F	5,0	6,0	7,0	40,0	0,055	3	■
JS553055F1C.3Z3-SIRA	10041482	1	F	5,5	6,0	8,0	40,0	0,055	3	■
JS553060D1C.3Z3-SIRA	10041483	1	D	6,0	6,0	8,0	40,0	0,075	3	■
JS553080D1C.3Z3-SIRA	10041484	1	D	8,0	8,0	11,0	50,0	0,1	3	□
JS553100D1C.3Z3-SIRA	10041485	1	D	10,0	10,0	13,0	57,0	0,125	3	□
JS553120D1C.3Z3-SIRA	10041486	1	D	12,0	12,0	15,0	65,0	0,15	3	□
553020Z3.0-SIRON-AW	02697423	2	F	2,0	6,0	5,0	50,0	0,025	3	□
553025Z3.0-SIRON-AW	02700354	2	F	2,5	6,0	7,0	50,0	0,025	3	■
553030Z3.0-SIRON-AW	02700355	2	F	3,0	6,0	7,0	50,0	0,035	3	■
553035Z3.0-SIRON-AW	02700357	2	F	3,5	6,0	9,0	55,0	0,035	3	■
553040Z3.0-SIRON-AW	02700358	2	F	4,0	6,0	10,0	55,0	0,045	3	■
553045Z3.0-SIRON-AW	02700359	2	F	4,5	6,0	12,0	55,0	0,045	3	□
553050Z3.0-SIRON-AW	02700360	2	F	5,0	6,0	12,0	55,0	0,055	3	■
553055Z3.0-SIRON-AW	02700361	2	F	5,5	6,0	14,0	55,0	0,055	3	□
553060Z3.3-SIRON-A	02679367	2	D	6,0	6,0	14,0	55,0	0,075	3	■
553075Z3.3-SIRON-A	02733915	2	F	7,5	8,0	18,0	60,0	0,1	3	■
553080Z3.3-SIRON-A	02679370	2	D	8,0	8,0	18,0	60,0	0,1	3	■
553095Z3.3-SIRON-A	02733919	2	F	9,5	10,0	22,0	70,0	0,125	3	■
553100Z3.3-SIRON-A	02679373	2	D	10,0	10,0	22,0	70,0	0,125	3	■
553115Z3.3-SIRON-A	02733923	2	F	11,5	12,0	26,0	80,0	0,15	3	■
553120Z3.3-SIRON-A	02679379	2	D	12,0	12,0	26,0	80,0	0,15	3	■
553140Z3.3-SIRON-A	02733929	2	D	14,0	14,0	30,0	85,0	0,175	3	■
553160Z3.3-SIRON-A	02679383	2	D	16,0	16,0	34,0	90,0	0,2	3	■
553200Z3.3-SIRON-A	02679388	2	D	20,0	20,0	42,0	110,0	0,25	3	■
553250Z3.3-SIRON-A	02679392	2	D	25,0	25,0	52,0	125,0	0,3	3	■

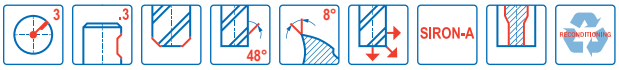
■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS553

High performance – Universal – Square – 3 Flutes – Weldon – Chamfer



- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

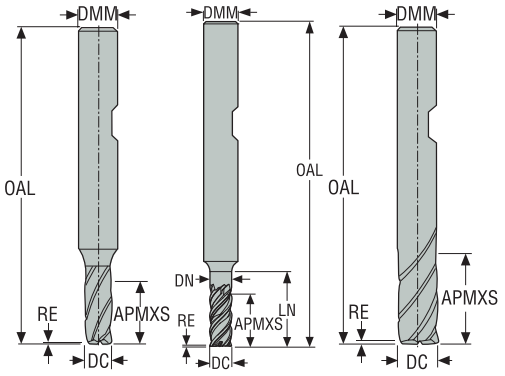


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
553L020Z3.0-SIRON-AW	02734001	3	F	2,0	6,0	7,0	50,0	0,025	3	□
553L030Z3.0-SIRON-AW	02734006	3	F	3,0	6,0	10,0	55,0	0,035	3	■
553L040Z3.0-SIRON-AW	02734007	3	F	4,0	6,0	14,0	60,0	0,045	3	■
553L050Z3.0-SIRON-AW	02734008	3	F	5,0	6,0	18,0	60,0	0,055	3	□
553L060Z3.3-SIRON-A	02733980	3	D	6,0	6,0	20,0	65,0	0,075	3	■
553L080Z3.3-SIRON-A	02733984	3	D	8,0	8,0	28,0	70,0	0,1	3	■
553L100Z3.3-SIRON-A	02733988	3	D	10,0	10,0	35,0	85,0	0,125	3	■
553L120Z3.3-SIRON-A	02733993	3	D	12,0	12,0	40,0	95,0	0,15	3	■
553L160Z3.3-SIRON-A	02733995	3	D	16,0	16,0	50,0	110,0	0,2	3	■
553L200Z3.3-SIRON-A	02733997	3	D	20,0	20,0	60,0	125,0	0,25	3	■
553L250Z3.3-SIRON-A	02733999	3	D	25,0	25,0	75,0	150,0	0,3	3	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS553

High performance – Universal – Square – 3 Flutes – Weldon – Corner radius



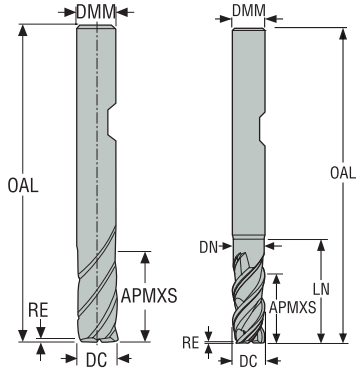
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS553080D1R050.3Z3-SIRA	10194469	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	☐
JS553100D1R050.3Z3-SIRA	10194470	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	☐
JS553100D1R100.3Z3-SIRA	10194471	1	D	10,0	10,0	13,0	57,0	–	–	1,0	3	☐
JS553120D1R050.3Z3-SIRA	10194472	1	D	12,0	12,0	15,0	65,0	–	–	0,5	3	☐
JS553120D1R100.3Z3-SIRA	10194474	1	D	12,0	12,0	15,0	65,0	–	–	1,0	3	☐
JS553020G2R050.3Z3-SIRA	02881690	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	☐
553030R015Z3.0-SIRON-AW	02733941	2	F	3,0	6,0	7,0	50,0	8,5	3,0	0,15	3	☐
JS553030G2R050.3Z3-SIRA	02881691	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	☐
553040R020Z3.0-SIRON-AW	02733944	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,2	3	☐
JS553040G2R050.3Z3-SIRA	02881692	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	☐
553050R020Z3.0-SIRON-AW	02703763	2	F	5,0	6,0	12,0	55,0	14,7	5,0	0,2	3	☐
JS553050G2R050.3Z3-SIRA	02881693	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	☐
553060R020Z3.0-SIRON-AW	02700364	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	☐
JS553060E2R050.3Z3-SIRA	02881694	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	☐
JS553060E2R100.3Z3-SIRA	02881695	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	■
553080R050Z3.0-SIRON-AW	02700366	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	■
553100R050Z3.0-SIRON-AW	02700369	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	☐
553100R100Z3.0-SIRON-AW	02700371	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	☐
553100R200Z3.3-SIRON-A	02810422	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	☐
553100R250Z3.3-SIRON-A	02810423	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	☐
553100R310Z3.3-SIRON-A	02810424	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	☐
553120R050Z3.0-SIRON-AW	02700373	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	☐
553120R100Z3.0-SIRON-AW	02700374	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	☐
553120R200Z3.3-SIRON-A	02810425	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	☐
553120R250Z3.3-SIRON-A	02810426	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	☐
553120R310Z3.3-SIRON-A	02810427	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	☐

■ Stocked standard. ☐ Weldon available. Delivery time is 3 days.

JS553

High performance – Universal – Square – 3 Flutes – Weldon – Corner radius



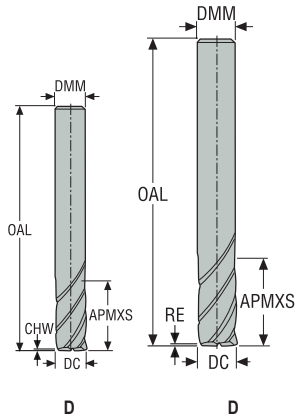
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible

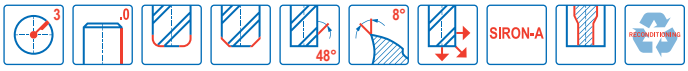
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
553160R050Z3.0-SIRON-AW	02700378	2	D	16,0	16,0	34,0	90,0	0,5	3	☐
553160R100Z3.0-SIRON-AW	02700381	2	D	16,0	16,0	34,0	90,0	1,0	3	☐
553160R200Z3.3-SIRON-A	02810428	2	D	16,0	16,0	34,0	90,0	2,0	3	☐
553160R250Z3.3-SIRON-A	02810429	2	D	16,0	16,0	34,0	90,0	2,5	3	☐
553160R310Z3.3-SIRON-A	02810430	2	D	16,0	16,0	34,0	90,0	3,1	3	☐
553160R400Z3.3-SIRON-A	02810431	2	D	16,0	16,0	34,0	90,0	4,0	3	☐
553200R050Z3.0-SIRON-AW	02700383	2	D	20,0	20,0	42,0	110,0	0,5	3	■
553200R100Z3.0-SIRON-AW	02700384	2	D	20,0	20,0	42,0	110,0	1,0	3	☐
JS553200E2R200.3Z3-SIRA	02881696	2	E	20,0	20,0	42,0	110,0	2,0	3	☐
553250R050Z3.0-SIRON-AW	02700386	2	D	25,0	25,0	52,0	125,0	0,5	3	☐
553250R100Z3.0-SIRON-AW	02700385	2	D	25,0	25,0	52,0	125,0	1,0	3	☐

■ Stocked standard. ☐ Weldon available. Delivery time is 3 days.

JS553

High performance – Universal – Square – 3 Flutes – Cylindrical – Corner radius or chamfer – *Inch*





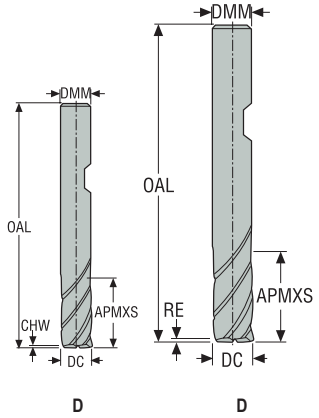
- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø.375

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Cylindrical
				inch	inch	inch	inch	inch	inch		
5530125Z3.0-SIRON-A	02712684	2	D	0.125	0.125	0.250	2.000	0.001	–	3	■
5530187Z3.0-SIRON-A	02712687	2	D	0.188	0.188	0.375	2.000	0.001	–	3	■
5530250Z3.0-SIRON-A	02712688	2	D	0.250	0.250	0.500	2.500	0.003	–	3	■
5530250R015Z3.0-SIRON-A	02712689	2	D	0.250	0.250	0.500	2.500	–	0.015	3	■
5530312Z3.0-SIRON-A	02712690	2	D	0.313	0.313	0.625	2.500	0.004	–	3	■
5530312R015Z3.0-SIRON-A	02712693	2	D	0.313	0.313	0.625	2.500	–	0.015	3	■
5530375Z3.0-SIRON-A	02712694	2	D	0.375	0.375	0.750	3.000	0.005	–	3	■
5530375R015Z3.0-SIRON-A	02712695	2	D	0.375	0.375	0.750	3.000	–	0.015	3	■
5530375R030Z3.0-SIRON-A	02712696	2	D	0.375	0.375	0.750	3.000	–	0.030	3	■
5530500Z3.0-SIRON-A	02712699	2	D	0.500	0.500	1.000	3.500	0.006	–	3	■
5530500R015Z3.0-SIRON-A	02712701	2	D	0.500	0.500	1.000	3.500	–	0.015	3	■
5530500R030Z3.0-SIRON-A	02712703	2	D	0.500	0.500	1.000	3.500	–	0.030	3	■

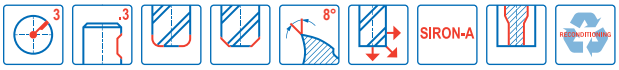
■ Stocked standard.

JS553

High performance – Universal – Square – 3 Flutes – Weldon – Corner radius or chamfer – *Inch*



- Tolerances:
- DMM=h5
- DC=e7



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Weldon
				inch	inch	inch	inch	inch	inch		
5530500Z3.3-SIRON-A	02712697	2	D	0.500	0.500	1.000	3.500	0.006	–	3	■
5530500R015Z3.3-SIRON-A	02712700	2	D	0.500	0.500	1.000	3.500	–	0.015	3	■
5530500R030Z3.3-SIRON-A	02712702	2	D	0.500	0.500	1.000	3.500	–	0.030	3	■

■ Stocked standard.

Cutting data – JS553 Side milling

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	0.400	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	225 (200 — 250)
		0,400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*740 (660 — 820)*
P2	M/A/D/E	0.400	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	220 (190 — 240)
		0,400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*720 (630 — 780)*
P3	M/A/D/E	0.400	1.0	0.019	0.028	0.038	0.048	0.055	0.075	0.095	0.11	0.13	0.14	0.16	0.18	190 (170 — 210)
		0,400	*1,0*	*0,00075*	*0,0011*	*0,0015*	*0,0019*	*0,0022*	*0,0030*	*0,0038*	*0,0044*	*0,0050*	*0,0055*	*0,0065*	*0,0070*	*620 (560 — 680)*
P4	M/A/D/E	0.400	1.0	0.019	0.028	0.038	0.046	0.055	0.075	0.095	0.11	0.13	0.14	0.16	0.18	165 (150 — 190)
		0,400	*1,0*	*0,00075*	*0,0011*	*0,0015*	*0,0018*	*0,0022*	*0,0030*	*0,0038*	*0,0044*	*0,0050*	*0,0055*	*0,0065*	*0,0070*	*540 (500 — 620)*
P5	M/A/D/E	0.400	1.0	0.018	0.028	0.036	0.046	0.055	0.075	0.090	0.11	0.12	0.13	0.16	0.18	160 (140 — 180)
		0,400	*1,0*	*0,00070*	*0,0011*	*0,0014*	*0,0018*	*0,0022*	*0,0030*	*0,0036*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0070*	*520 (460 — 590)*
P6	M/A/D/E	0.400	1.0	0.018	0.028	0.036	0.046	0.055	0.075	0.090	0.11	0.12	0.13	0.15	0.17	180 (160 — 200)
		0,400	*1,0*	*0,00070*	*0,0011*	*0,0014*	*0,0018*	*0,0022*	*0,0030*	*0,0036*	*0,0044*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*590 (530 — 650)*
P7	M/A/D/E	0.400	1.0	0.018	0.028	0.036	0.046	0.055	0.075	0.090	0.11	0.12	0.13	0.15	0.17	170 (150 — 190)
		0,400	*1,0*	*0,00070*	*0,0011*	*0,0014*	*0,0018*	*0,0022*	*0,0030*	*0,0036*	*0,0044*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*560 (500 — 620)*
P8	M/A/D/E	0.400	1.0	0.019	0.028	0.038	0.048	0.055	0.075	0.095	0.11	0.13	0.14	0.16	0.18	160 (140 — 180)
		0,400	*1,0*	*0,00075*	*0,0011*	*0,0015*	*0,0019*	*0,0022*	*0,0030*	*0,0038*	*0,0044*	*0,0050*	*0,0055*	*0,0065*	*0,0070*	*520 (460 — 590)*
P11	M/A/D/E	0.400	1.0	0.018	0.026	0.036	0.044	0.055	0.070	0.090	0.11	0.12	0.13	0.15	0.17	145 (130 — 160)
		0,400	*1,0*	*0,00070*	*0,0010*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0036*	*0,0044*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*475 (430 — 520)*
P12	M/A/D/E	0.400	1.0	0.012	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.080	0.090	0.10	0.12	95 (82 — 100)
		0,400	*1,0*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0048*	*310 (270 — 320)*
M1	E	0.400	1.0	0.013	0.020	0.026	0.034	0.040	0.055	0.065	0.080	0.090	0.10	0.11	0.13	115 (100 — 120)
		0,400	*1,0*	*0,00050*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0022*	*0,0026*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0050*	*375 (330 — 390)*
M2	E	0.400	1.0	0.012	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.080	0.090	0.10	0.12	95 (82 — 100)
		0,400	*1,0*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0048*	*310 (270 — 320)*
M3	E	0.400	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.075	0.085	0.10	60 (47 — 69)
		0,400	*1,0*	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0030*	*0,0034*	*0,0040*	*195 (160 — 220)*
M4	E	0.400	1.0	0.0090	0.013	0.018	0.022	0.026	0.036	0.044	0.055	0.060	0.065	0.075	0.085	45 (36 — 53)
		0,400	*1,0*	*0,00036*	*0,00050*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0022*	*0,0024*	*0,0026*	*0,0030*	*0,0034*	*150 (120 — 170)*
M5	E	0.400	1.0	0.0090	0.013	0.018	0.022	0.026	0.036	0.044	0.055	0.060	0.065	0.075	0.085	37 (30 — 44)
		0,400	*1,0*	*0,00036*	*0,00050*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0022*	*0,0024*	*0,0026*	*0,0030*	*0,0034*	*120 (99 — 140)*
K1	E	0.400	1.2	0.016	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.12	0.14	0.16	165 (160 — 190)
		0,400	*1,2*	*0,00065*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0048*	*0,0055*	*0,0065*	*540 (530 — 620)*
K2	E	0.400	1.2	0.015	0.022	0.030	0.038	0.044	0.060	0.075	0.090	0.10	0.11	0.13	0.14	145 (140 — 170)
		0,400	*1,2*	*0,00060*	*0,00085*	*0,0012*	*0,0015*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0040*	*0,0044*	*0,0050*	*0,0055*	*475 (460 — 550)*
K3	E	0.400	1.2	0.015	0.022	0.030	0.038	0.044	0.060	0.075	0.090	0.10	0.11	0.13	0.14	125 (120 — 140)
		0,400	*1,2*	*0,00060*	*0,00085*	*0,0012*	*0,0015*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0040*	*0,0044*	*0,0050*	*0,0055*	*410 (400 — 450)*
K4	E	0.400	1.2	0.015	0.022	0.030	0.038	0.044	0.060	0.075	0.090	0.10	0.11	0.13	0.14	120 (110 — 140)
		0,400	*1,2*	*0,00060*	*0,00085*	*0,0012*	*0,0015*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0040*	*0,0044*	*0,0050*	*0,0055*	*395 (370 — 450)*
K5	E	0.400	1.1	0.016	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.12	0.14	0.16	155 (140 — 170)
		0,400	*1,1*	*0,00065*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0048*	*0,0055*	*0,0065*	*510 (460 — 550)*
K6	E	0.400	1.1	0.018	0.028	0.036	0.046	0.055	0.070	0.090	0.11	0.12	0.13	0.15	0.17	220 (190 — 250)
		0,400	*1,1*	*0,00070*	*0,0011*	*0,0014*	*0,0018*	*0,0022*	*0,0028*	*0,0036*	*0,0044*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*720 (630 — 820)*
K7	E	0.400	1.1	0.016	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.12	0.14	0.16	195 (170 — 220)
		0,400	*1,1*	*0,00065*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0048*	*0,0055*	*0,0065*	*640 (560 — 720)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JS553 Side milling

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	620 (520 — 720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (340 — 460) *1300 (1200 — 1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	310 (260 — 350) *1025 (860 — 1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	43 (26 — 60) *140 (86 — 190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (78 — 130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (60 — 100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (49 — 72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	290 (180 — 400) *950 (600 — 1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	300 (180 — 410) *980 (600 — 1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS553 Slot milling

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	195 (170 — 220)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*640 (560 — 720)*
P2	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	190 (170 — 210)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*620 (560 — 680)*
P3	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	165 (140 — 180)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*540 (460 — 590)*
P4	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	145 (130 — 160)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*475 (430 — 520)*
P5	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	135 (120 — 150)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*445 (400 — 490)*
P6	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	155 (140 — 170)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*510 (460 — 550)*
P7	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	145 (130 — 160)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*475 (430 — 520)*
P8	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	135 (120 — 150)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*445 (400 — 490)*
P11	M/A/D/E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	130 (120 — 140)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*425 (400 — 450)*
P12	M/A/D/E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.11	80 (69 — 87)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0044*	*260 (230 — 280)*
M1	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	95 (85 — 100)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*310 (280 — 320)*
M2	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.11	80 (69 — 87)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0044*	*260 (230 — 280)*
M3	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.080	0.095	48 (39 — 58)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0032*	*0,0038*	*155 (130 — 190)*
M4	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.075	0.085	36 (30 — 43)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*120 (99 — 140)*
M5	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.075	0.085	30 (25 — 36)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*100 (83 — 110)*
K1	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	145 (140 — 170)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*475 (460 — 550)*
K2	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	125 (120 — 150)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*410 (400 — 490)*
K3	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	110 (110 — 120)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*360 (370 — 390)*
K4	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	105 (96 — 120)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*345 (320 — 390)*
K5	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	135 (120 — 150)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K6	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	200 (180 — 230)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*660 (600 — 750)*
K7	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	175 (150 — 190)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*570 (500 — 620)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Seco

Cutting data – JS553 Slot milling

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.70	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	580 (490 — 670)
		0,70	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*1900 (1700 — 2100)*
N2	E	0.70	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	375 (320 — 430)
		0,70	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*1225 (1100 — 1400)*
N3	E	0.70	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	250 (210 — 290)
		0,70	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*820 (690 — 950)*
N11	E	0.60	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	290 (250 — 330)
		0,60	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*950 (830 — 1000)*
S1	E	0.30	0.0065	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.044	0.050	0.065	0.080	34 (21 — 47)
		0,30	*0,00026*	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0017*	*0,0020*	*0,0026*	*0,0032*	*110 (69 — 150)*
S2	E	0.30	0.0065	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.044	0.050	0.065	0.080	27 (17 — 38)
		0,30	*0,00026*	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0017*	*0,0020*	*0,0026*	*0,0032*	*90 (56 — 120)*
S3	E	0.30	0.0065	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.044	0.050	0.065	0.080	23 (15 — 32)
		0,30	*0,00026*	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0017*	*0,0020*	*0,0026*	*0,0032*	*75 (50 — 100)*
S11	E	0.50	0.012	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.080	0.090	0.10	0.11	85 (63 — 110)
		0,50	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*280 (210 — 360)*
S12	E	0.50	0.012	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.080	0.090	0.10	0.11	65 (48 — 86)
		0,50	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*215 (160 — 280)*
S13	E	0.50	0.010	0.016	0.020	0.026	0.032	0.042	0.050	0.060	0.070	0.075	0.090	0.10	55 (39 — 69)
		0,50	*0,00040*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0017*	*0,0020*	*0,0024*	*0,0028*	*0,0030*	*0,0036*	*0,0040*	*180 (130 — 220)*
H5	M/A/D	0.50	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.025	0.028	0.032	0.040	0.050	65 (52 — 77)
		0,50	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0011*	*0,0013*	*0,0016*	*0,0020*	*215 (180 — 250)*
H8	M/A/D	0.50	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.025	0.028	0.032	0.040	0.050	65 (52 — 77)
		0,50	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0011*	*0,0013*	*0,0016*	*0,0020*	*215 (180 — 250)*
H11	M/A/D	0.50	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.025	0.028	0.032	0.040	0.050	80 (66 — 98)
		0,50	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0011*	*0,0013*	*0,0016*	*0,0020*	*260 (220 — 320)*
H12	M/A/D	1.0	0.0095	0.014	0.019	0.024	0.028	0.038	0.046	0.055	0.060	0.070	0.080	0.090	65 (52 — 77)
		1,0	*0,00038*	*0,00055*	*0,00075*	*0,00095*	*0,0011*	*0,0015*	*0,0018*	*0,0022*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*215 (180 — 250)*
H21	M/A/D	0.50	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.025	0.028	0.032	0.040	0.050	65 (52 — 77)
		0,50	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0011*	*0,0013*	*0,0016*	*0,0020*	*215 (180 — 250)*
TS1	A	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	245 (150 — 340)
		1,0	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*800 (500 — 1100)*
TP1	A	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	250 (160 — 350)
		1,0	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*820 (530 — 1100)*
GR1	A	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	490 (400 — 580)
		1,0	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*1600 (1400 — 1900)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Cutting data – JS553 Side milling – *Inch*

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	220 (190 — 240) *720 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	165 (150 — 190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	160 (140 — 180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82 — 100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	115 (100 — 120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82 — 100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	45 (36 — 53) *150 (120 — 170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	37 (30 — 44) *120 (99 — 140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	165 (160 — 190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	145 (140 — 170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	125 (120 — 140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	120 (110 — 140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	195 (170 — 220) *640 (560 — 720)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Seco

Cutting data – JS553 Side milling – *Inch*

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	620 (520 — 720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	400 (340 — 460) *1300 (1200 — 1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	310 (260 — 350) *1025 (860 — 1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	43 (26 — 60) *140 (86 — 190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	110 (78 — 130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	85 (60 — 100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.020 *0,00080*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	60 (49 — 72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	300 (180 — 410) *980 (600 — 1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	580 (470 — 690) *1900 (1600 — 2200)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Cutting data – JS553 Slot milling – *Inch*

SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 58) *155 (130 — 190)*
M4	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	36 (30 — 43) *120 (99 — 140)*
M5	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	145 (140 — 170) *475 (460 — 550)*
K2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	125 (120 — 150) *410 (400 — 490)*
K3	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	110 (110 — 120) *360 (370 — 390)*
K4	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	105 (96 — 120) *345 (320 — 390)*
K5	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	200 (180 — 230) *660 (600 — 750)*
K7	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	175 (150 — 190) *570 (500 — 620)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Seco

Cutting data – JS553 Slot milling – *Inch*

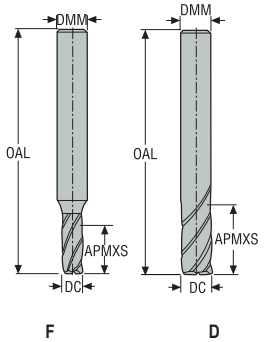
SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	375 (320 — 430) *1225 (1100 — 1400)*
N3	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	34 (21 — 47) *110 (69 — 150)*
S2	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H31	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	49 (39 — 58) *160 (130 — 190)*
TS1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	245 (150 — 340) *800 (500 — 1100)*
TP1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	250 (160 — 350) *820 (530 — 1100)*
GR1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	490 (400 — 580) *1600 (1400 — 1900)*

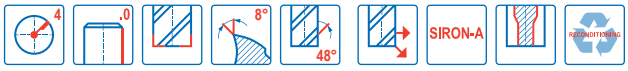
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

JS554

High performance – Universal – Square – 4 Flutes – Cylindrical – Sharp





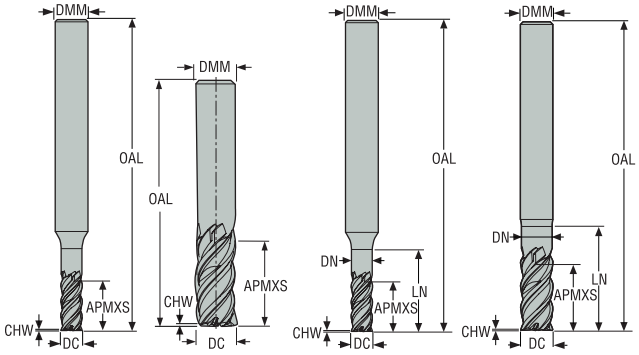
- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
554030SZ4.0-SIRON-A	02733453	2	F	3,0	6,0	7,0	50,0	4	■
554040SZ4.0-SIRON-A	02733458	2	F	4,0	6,0	10,0	55,0	4	■
554050SZ4.0-SIRON-A	02733812	2	F	5,0	6,0	12,0	55,0	4	■
554060SZ4.0-SIRON-A	02733814	2	D	6,0	6,0	14,0	55,0	4	■
554080SZ4.0-SIRON-A	02733815	2	D	8,0	8,0	18,0	60,0	4	■
554100SZ4.0-SIRON-A	02733816	2	D	10,0	10,0	22,0	70,0	4	■

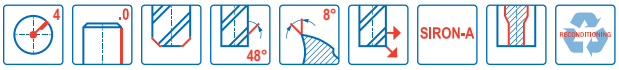
■ Stocked standard.

JS554

High performance – Universal – Square – 4 Flutes – Cylindrical – Chamfer



- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

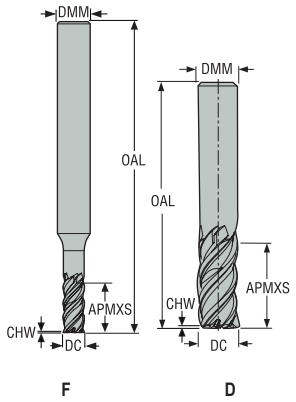


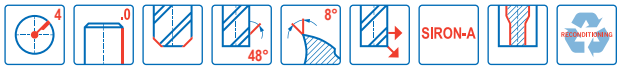
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS554030F1C.0Z4-SIRA	10194615	1	F	3,0	6,0	4,0	40,0	6,0	3,05	0,035	4	■
JS554040F1C.0Z4-SIRA	10041454	1	F	4,0	6,0	6,0	40,0	9,0	4,05	0,045	4	■
JS554050F1C.0Z4-SIRA	10194616	1	F	5,0	6,0	7,0	40,0	10,0	5,05	0,055	4	■
JS554060D1C.0Z4-SIRA	10041455	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	■
JS554080D1C.0Z4-SIRA	10041456	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	■
JS554100D1C.0Z4-SIRA	10041457	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	■
JS554120D1C.0Z4-SIRA	10041458	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	■
JS554160D1C.0Z4-SIRA	10041459	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	■
554030Z4.0-SIRON-A	02733455	2	F	3,0	6,0	7,0	50,0	8,7	3,0	0,035	4	■
JS554030G2C.0Z4-SIRA	03029956	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	■
554040Z4.0-SIRON-A	02733459	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,045	4	■
JS554040G2C.0Z4-SIRA	03029957	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	■
554050Z4.0-SIRON-A	02733813	2	F	5,0	6,0	12,0	55,0	13,7	5,0	0,055	4	■
JS554050G2C.0Z4-SIRA	03029958	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	■
554060Z4.0-SIRON-A	02679503	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	■
JS554060E2C.0Z4-SIRA	03029959	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	■
554080Z4.0-SIRON-A	02679512	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	■
JS554080E2C.0Z4-SIRA	03029961	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	■
554100Z4.0-SIRON-A	02679537	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	■
JS554100E2C.0Z4-SIRA	03029963	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	■
554120Z4.0-SIRON-A	02679548	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	■
JS554120E2C.0Z4-SIRA	03029966	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	■
554160Z4.0-SIRON-A	02679560	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	■
JS554160E2C.0Z4-SIRA	03029970	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	■
554200Z4.0-SIRON-A	02679566	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	■
JS554200E2C.0Z4-SIRA	03029972	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	■
554250Z4.0-SIRON-A	02679573	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	■

■ Stocked standard.

JS554

High performance – Universal – Square – 4 Flutes – Cylindrical – Chamfer





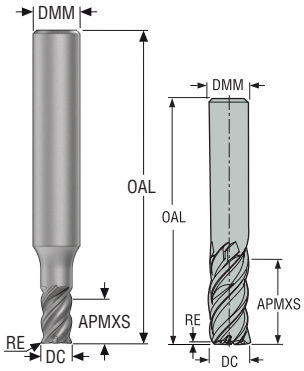
- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
554L030Z4.0-SIRON-A	02733818	3	F	3,0	6,0	12,0	55,0	13,7	3,0	0,035	4	■
554L040Z4.0-SIRON-A	02733823	3	F	4,0	6,0	16,0	60,0	17,7	4,0	0,045	4	■
554L050Z4.0-SIRON-A	02733825	3	F	5,0	6,0	20,0	65,0	21,7	5,0	0,055	4	■
554L060Z4.0-SIRON-A	02733828	3	D	6,0	6,0	23,0	65,0	–	–	0,075	4	■
554L080Z4.0-SIRON-A	02733830	3	D	8,0	8,0	32,0	75,0	–	–	0,1	4	■
554L100Z4.0-SIRON-A	02733832	3	D	10,0	10,0	40,0	85,0	–	–	0,125	4	■
554L120Z4.0-SIRON-A	02733834	3	D	12,0	12,0	45,0	100,0	–	–	0,15	4	■
554L160Z4.0-SIRON-A	02733836	3	D	16,0	16,0	55,0	115,0	–	–	0,2	4	■
554L200Z4.0-SIRON-A	02733838	3	D	20,0	20,0	65,0	125,0	–	–	0,25	4	■
554L250Z4.0-SIRON-A	02733841	3	D	25,0	25,0	85,0	150,0	–	–	0,3	4	■

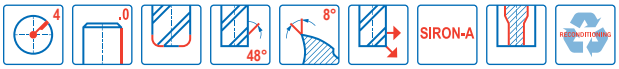
■ Stocked standard.

JS554

High performance – Universal – Square – 4 Flutes – Cylindrical – Corner radius



- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

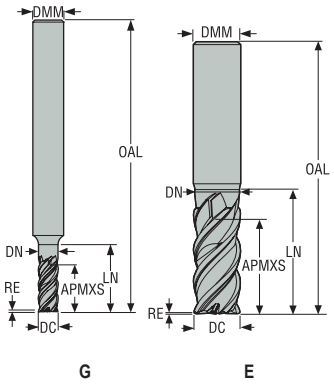


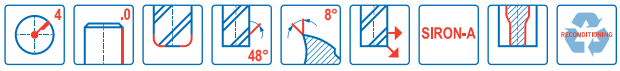
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS554030F1R020.0Z4-SIRA	10194617	1	F	3,0	6,0	4,0	40,0	0,2	4	■
JS554040F1R020.0Z4-SIRA	10194618	1	F	4,0	6,0	6,0	40,0	0,2	4	■
JS554050F1R020.0Z4-SIRA	10194619	1	F	5,0	6,0	7,0	40,0	0,2	4	■
JS554060D1R020.0Z4-SIRA	10194620	1	D	6,0	6,0	8,0	40,0	0,2	4	■
JS554060D1R050.0Z4-SIRA	10194621	1	D	6,0	6,0	8,0	40,0	0,5	4	■
JS554080D1R050.0Z4-SIRA	10194622	1	D	8,0	8,0	11,0	50,0	0,5	4	■
JS554100D1R050.0Z4-SIRA	10194623	1	D	10,0	10,0	13,0	57,0	0,5	4	■
JS554100D1R100.0Z4-SIRA	10194624	1	D	10,0	10,0	13,0	57,0	1,0	4	■
JS554120D1R050.0Z4-SIRA	10194625	1	D	12,0	12,0	15,0	65,0	0,5	4	■
JS554120D1R100.0Z4-SIRA	10194626	1	D	12,0	12,0	15,0	65,0	1,0	4	■
JS554160D1R050.0Z4-SIRA	10194627	1	D	16,0	16,0	19,0	75,0	0,5	4	■
JS554160D1R100.0Z4-SIRA	10194628	1	D	16,0	16,0	19,0	75,0	1,0	4	■
554060R020Z4.0-SIRON-A	02679507	2	D	6,0	6,0	14,0	55,0	0,2	4	■
554080R050Z4.0-SIRON-A	02679514	2	D	8,0	8,0	18,0	60,0	0,5	4	■
554100R050Z4.0-SIRON-A	02679540	2	D	10,0	10,0	22,0	70,0	0,5	4	■
554100R100Z4.0-SIRON-A	02679544	2	D	10,0	10,0	22,0	70,0	1,0	4	■
554120R050Z4.0-SIRON-A	02679552	2	D	12,0	12,0	26,0	80,0	0,5	4	■
554120R100Z4.0-SIRON-A	02679557	2	D	12,0	12,0	26,0	80,0	1,0	4	■
554160R050Z4.0-SIRON-A	02679562	2	D	16,0	16,0	34,0	90,0	0,5	4	■
554160R100Z4.0-SIRON-A	02679564	2	D	16,0	16,0	34,0	90,0	1,0	4	■
554160R200Z4.0-SIRON-A	02810437	2	D	16,0	16,0	34,0	90,0	2,0	4	■
554160R310Z4.0-SIRON-A	02810439	2	D	16,0	16,0	34,0	90,0	3,1	4	■
554160R400Z4.0-SIRON-A	02810441	2	D	16,0	16,0	34,0	90,0	4,0	4	■
554200R050Z4.0-SIRON-A	02679568	2	D	20,0	20,0	42,0	100,0	0,5	4	■
554200R100Z4.0-SIRON-A	02679571	2	D	20,0	20,0	42,0	100,0	1,0	4	■
554200R250Z4.0-SIRON-A	02810443	2	D	20,0	20,0	42,0	100,0	2,5	4	■
554200R310Z4.0-SIRON-A	02810445	2	D	20,0	20,0	42,0	100,0	3,1	4	■
554200R400Z4.0-SIRON-A	02810447	2	D	20,0	20,0	42,0	100,0	4,0	4	■
554250R050Z4.0-SIRON-A	02679575	2	D	25,0	25,0	52,0	125,0	0,5	4	■
554250R100Z4.0-SIRON-A	02679577	2	D	25,0	25,0	52,0	125,0	1,0	4	■
554250R310Z4.0-SIRON-A	02810449	2	D	25,0	25,0	52,0	125,0	3,1	4	■
554250R400Z4.0-SIRON-A	02810452	2	D	25,0	25,0	52,0	125,0	4,0	4	■

■ Stocked standard.

JS554

High performance– Universal – Square – 4 Flutes – Cylindrical – Corner radius





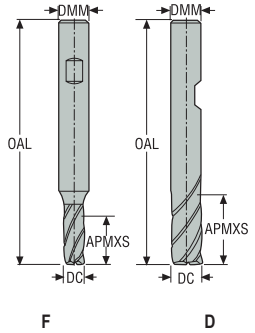
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS554030G2R015.0Z4-SIRA	02881697	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	■
JS554040G2R020.0Z4-SIRA	02881698	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	■
JS554050G2R020.0Z4-SIRA	02881699	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	■
JS554060E2R020.0Z4-SIRA	03029960	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	■
JS554060E2R050.0Z4-SIRA	02881700	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	■
JS554060E2R100.0Z4-SIRA	03029948	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	■
JS554080E2R050.0Z4-SIRA	03029962	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	■
JS554080E2R100.0Z4-SIRA	02881701	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	■
JS554100E2R050.0Z4-SIRA	03029964	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	■
JS554100E2R100.0Z4-SIRA	03029965	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	■
JS554100E2R200.0Z4-SIRA	02881702	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	■
JS554100E2R250.0Z4-SIRA	03029949	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	■
JS554120E2R050.0Z4-SIRA	03029968	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	■
JS554120E2R100.0Z4-SIRA	03029969	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	■
JS554120E2R200.0Z4-SIRA	02881703	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	■
JS554120E2R250.0Z4-SIRA	02881704	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	■
JS554120E2R300.0Z4-SIRA	03029950	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	■
JS554160E2R050.0Z4-SIRA	03029971	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	■
JS554160E2R600.0Z4-SIRA	03093685	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	■
JS554200E2R200.0Z4-SIRA	02881705	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	■
JS554200E2R600.0Z4-SIRA	03029951	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	■
JS554250E2R600.0Z4-SIRA	03093686	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	■

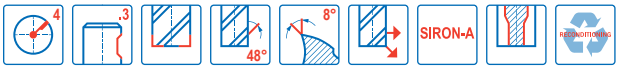
■ Stocked standard.

JS554

High performance – Universal – Square – 4 Flutes – Weldon – Sharp



- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

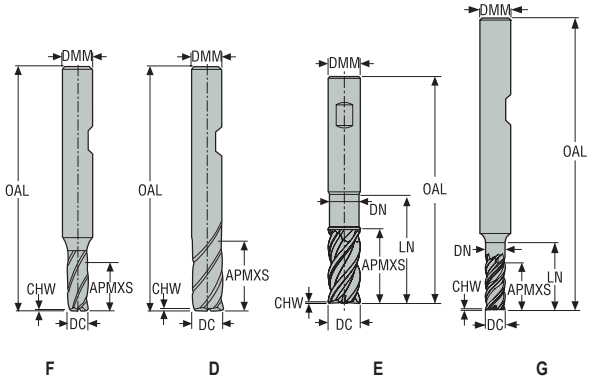


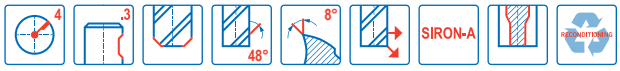
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
554030SZ4.0-SIRON-AW	02733844	2	F	3,0	6,0	7,0	50,0	4	☐
554040SZ4.0-SIRON-AW	02733846	2	F	4,0	6,0	10,0	55,0	4	☐
554050SZ4.0-SIRON-AW	02733847	2	F	5,0	6,0	12,0	55,0	4	☐
554060SZ4.0-SIRON-AW	02733848	2	D	6,0	6,0	14,0	55,0	4	☐
554080SZ4.0-SIRON-AW	02733849	2	D	8,0	8,0	18,0	60,0	4	☐
554100SZ4.0-SIRON-AW	02733850	2	D	10,0	10,0	22,0	70,0	4	☐

☐ Weldon available. Delivery time is 3 days.

JS554

High performance – Universal – Square – 4 Flutes – Weldon – Chamfer





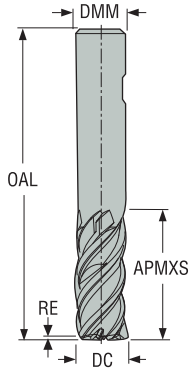
- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS554040F1C.3Z4-SIRA	10041460	1	F	4,0	6,0	6,0	40,0	9,0	4,05	0,045	4	■
JS554060D1C.3Z4-SIRA	10041461	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	■
JS554080D1C.3Z4-SIRA	10041462	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	□
JS554100D1C.3Z4-SIRA	10041463	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	□
JS554120D1C.3Z4-SIRA	10041464	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	□
JS554160D1C.3Z4-SIRA	10041465	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	□
554030Z4.3-SIRON-A	02733450	2	F	3,0	6,0	7,0	50,0	8,7	3,0	0,035	4	■
JS554030G2C.3Z4-SIRA	03029973	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	□
554040Z4.3-SIRON-A	02733456	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,045	4	■
JS554040G2C.3Z4-SIRA	03029974	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	□
554050Z4.3-SIRON-A	02733461	2	F	5,0	6,0	12,0	55,0	13,7	5,0	0,055	4	■
JS554050G2C.3Z4-SIRA	03029975	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	□
554060Z4.3-SIRON-A	02679502	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	■
JS554060E2C.3Z4-SIRA	03029976	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	□
554080Z4.3-SIRON-A	02679511	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	■
JS554080E2C.3Z4-SIRA	03029978	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	□
JS554100E2C.3Z4-SIRA	03029980	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	□
554100Z4.3-SIRON-A	02679535	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	■
JS554120E2C.3Z4-SIRA	03029983	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	□
554120Z4.3-SIRON-A	02679547	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	■
JS554160E2C.3Z4-SIRA	03029986	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	□
554160Z4.3-SIRON-A	02679559	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	■
JS554200E2C.3Z4-SIRA	03029988	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	□
554200Z4.3-SIRON-A	02679565	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	■
554250Z4.3-SIRON-A	02679572	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	■
554L030Z4.3-SIRON-A	02733817	3	F	3,0	6,0	12,0	55,0	13,7	3,0	0,035	4	■
554L040Z4.3-SIRON-A	02733820	3	F	4,0	6,0	16,0	60,0	17,7	4,0	0,045	4	■
554L050Z4.3-SIRON-A	02733824	3	F	5,0	6,0	20,0	65,0	21,7	5,0	0,055	4	■
554L060Z4.3-SIRON-A	02733827	3	D	6,0	6,0	23,0	65,0	–	–	0,075	4	■
554L080Z4.3-SIRON-A	02733829	3	D	8,0	8,0	32,0	75,0	–	–	0,1	4	■
554L100Z4.3-SIRON-A	02733831	3	D	10,0	10,0	40,0	85,0	–	–	0,125	4	■
554L120Z4.3-SIRON-A	02733833	3	D	12,0	12,0	45,0	100,0	–	–	0,15	4	■
554L160Z4.3-SIRON-A	02733835	3	D	16,0	16,0	55,0	115,0	–	–	0,2	4	■
554L200Z4.3-SIRON-A	02733837	3	D	20,0	20,0	65,0	125,0	–	–	0,25	4	■
554L250Z4.3-SIRON-A	02733839	3	D	25,0	25,0	85,0	150,0	–	–	0,3	4	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS554

High performance – Universal – Square – 4 Flutes – Weldon – Corner radius



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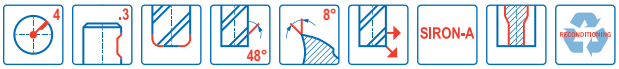


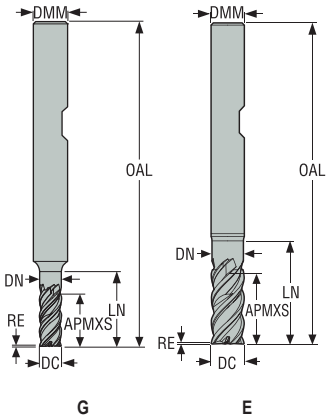
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

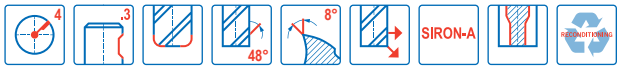
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS554080D1R050.3Z4-SIRA	10194629	1	D	8,0	8,0	11,0	50,0	0,5	4	□
JS554100D1R050.3Z4-SIRA	10194630	1	D	10,0	10,0	13,0	57,0	0,5	4	□
JS554100D1R100.3Z4-SIRA	10194631	1	D	10,0	10,0	13,0	57,0	1,0	4	□
JS554120D1R050.3Z4-SIRA	10194632	1	D	12,0	12,0	15,0	65,0	0,5	4	□
JS554120D1R100.3Z4-SIRA	10194633	1	D	12,0	12,0	15,0	65,0	1,0	4	□
JS554160D1R050.3Z4-SIRA	10194634	1	D	16,0	16,0	19,0	75,0	0,5	4	□
JS554160D1R100.3Z4-SIRA	10194635	1	D	16,0	16,0	19,0	75,0	1,0	4	□
554060R020Z4.3-SIRON-A	02679506	2	D	6,0	6,0	14,0	55,0	0,2	4	■
554080R050Z4.3-SIRON-A	02679513	2	D	8,0	8,0	18,0	60,0	0,5	4	■
554100R050Z4.3-SIRON-A	02679539	2	D	10,0	10,0	22,0	70,0	0,5	4	■
554100R100Z4.3-SIRON-A	02679542	2	D	10,0	10,0	22,0	70,0	1,0	4	■
554120R050Z4.3-SIRON-A	02679549	2	D	12,0	12,0	26,0	80,0	0,5	4	■
554120R100Z4.3-SIRON-A	02679554	2	D	12,0	12,0	26,0	80,0	1,0	4	■
554160R050Z4.3-SIRON-A	02679561	2	D	16,0	16,0	34,0	90,0	0,5	4	■
554160R100Z4.3-SIRON-A	02679563	2	D	16,0	16,0	34,0	90,0	1,0	4	■
554160R200Z4.3-SIRON-A	02810436	2	D	16,0	16,0	34,0	90,0	2,0	4	■
554160R310Z4.3-SIRON-A	02810438	2	D	16,0	16,0	34,0	90,0	3,1	4	■
554160R400Z4.3-SIRON-A	02810440	2	D	16,0	16,0	34,0	90,0	4,0	4	■
554200R050Z4.3-SIRON-A	02679567	2	D	20,0	20,0	42,0	100,0	0,5	4	■
554200R100Z4.3-SIRON-A	02679570	2	D	20,0	20,0	42,0	100,0	1,0	4	■
554200R250Z4.3-SIRON-A	02810442	2	D	20,0	20,0	42,0	100,0	2,5	4	■
554200R310Z4.3-SIRON-A	02810444	2	D	20,0	20,0	42,0	100,0	3,1	4	■
554200R400Z4.3-SIRON-A	02810446	2	D	20,0	20,0	42,0	100,0	4,0	4	■
554250R050Z4.3-SIRON-A	02679574	2	D	25,0	25,0	52,0	125,0	0,5	4	■
554250R100Z4.3-SIRON-A	02679576	2	D	25,0	25,0	52,0	125,0	1,0	4	■
554250R310Z4.3-SIRON-A	02810448	2	D	25,0	25,0	52,0	125,0	3,1	4	■
554250R400Z4.3-SIRON-A	02810451	2	D	25,0	25,0	52,0	125,0	4,0	4	■

■ Stocked standard.

JS554

High performance – Universal – Square – 4 Flutes – Weldon – Corner radius





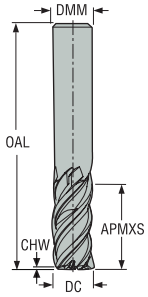
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS554030G2R015.3Z4-SIRA	02881706	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	☐
JS554040G2R020.3Z4-SIRA	02881946	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	☐
JS554050G2R020.3Z4-SIRA	02881708	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	☐
JS554060E2R020.3Z4-SIRA	03029977	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	☐
JS554060E2R050.3Z4-SIRA	02881709	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	☐
JS554060E2R100.3Z4-SIRA	03029952	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	☐
JS554080E2R050.3Z4-SIRA	03029979	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	☐
JS554080E2R100.3Z4-SIRA	02881710	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	☐
JS554100E2R050.3Z4-SIRA	03029981	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	☐
JS554100E2R100.3Z4-SIRA	03029982	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	☐
JS554100E2R200.3Z4-SIRA	02881711	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	☐
JS554100E2R250.3Z4-SIRA	03029953	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	☐
JS554120E2R050.3Z4-SIRA	03029984	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	■
JS554120E2R100.3Z4-SIRA	03029985	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	☐
JS554120E2R200.3Z4-SIRA	02881712	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	☐
JS554120E2R250.3Z4-SIRA	02881713	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	☐
JS554120E2R300.3Z4-SIRA	03029954	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	☐
JS554160E2R050.3Z4-SIRA	03029987	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	☐
JS554160E2R600.3Z4-SIRA	03093687	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	☐
JS554200E2R200.3Z4-SIRA	02881714	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	☐
JS554200E2R600.3Z4-SIRA	03029955	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	☐
JS554250E2R600.3Z4-SIRA	03093688	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	☐

■ Stocked standard. ☐ Weldon available. Delivery time is 3 days.

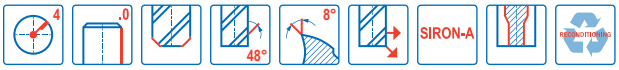
JS554

High performance – Universal – Square – 4 Flutes – Cylindrical – Chamfer – *Inch*



D

- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø.375

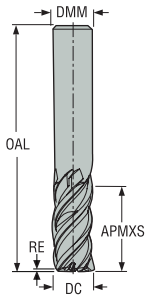


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				inch	inch	inch	inch	inch		
5540250Z4.0-SIRON-A	02711329	2	D	0.250	0.250	0.500	2.500	0.003	4	■
5540312Z4.0-SIRON-A	02711340	2	D	0.313	0.313	0.625	2.500	0.004	4	■
5540375Z4.0-SIRON-A	02711344	2	D	0.375	0.375	0.750	3.000	0.005	4	■
5540500Z4.0-SIRON-A	02711611	2	D	0.500	0.500	1.000	3.500	0.006	4	■
5540625Z4.0-SIRON-A	02711626	2	D	0.625	0.625	1.250	3.750	0.008	4	■
5540750Z4.0-SIRON-A	02711643	2	D	0.750	0.750	1.500	4.000	0.010	4	■
5541000Z4.0-SIRON-A	02711660	2	D	1.000	1.000	2.000	5.000	0.012	4	■

■ Stocked standard.

JS554

High performance – Universal – Square – 4 Flutes – Cylindrical – Corner radius – *Inch*



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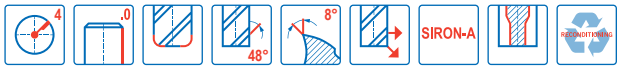


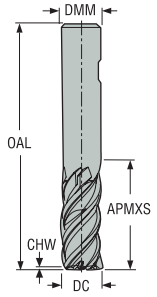
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±.0008 *inch*
- Regrind possible if DC is ≥Ø.375

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				inch	inch	inch	inch	inch		
5540250R015Z4.0-SIRON-A	02711335	2	D	0.250	0.250	0.500	2.500	0.015	4	■
5540312R015Z4.0-SIRON-A	02711341	2	D	0.313	0.313	0.625	2.500	0.015	4	■
5540375R015Z4.0-SIRON-A	02711588	2	D	0.375	0.375	0.750	3.000	0.015	4	■
5540375R030Z4.0-SIRON-A	02711589	2	D	0.375	0.375	0.750	3.000	0.030	4	■
5540500R015Z4.0-SIRON-A	02711614	2	D	0.500	0.500	1.000	3.500	0.015	4	■
5540500R030Z4.0-SIRON-A	02711616	2	D	0.500	0.500	1.000	3.500	0.030	4	■
5540500R125Z4.0-SIRON-A	02842370	2	D	0.500	0.500	1.000	3.500	0.125	4	■
5540625R015Z4.0-SIRON-A	02711629	2	D	0.625	0.625	1.250	3.750	0.015	4	■
5540625R030Z4.0-SIRON-A	02711631	2	D	0.625	0.625	1.250	3.750	0.030	4	■
5540625R125Z4.0-SIRON-A	02842371	2	D	0.625	0.625	1.250	3.750	0.125	4	■
5540750R030Z4.0-SIRON-A	02711647	2	D	0.750	0.750	1.500	4.000	0.030	4	■
5540750R060Z4.0-SIRON-A	02711655	2	D	0.750	0.750	1.500	4.000	0.060	4	■

■ Stocked standard.

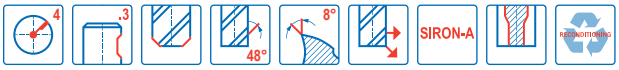
JS554

High performance – Universal – Square – 4 Flutes – Weldon – Chamfer – inch



D

- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible

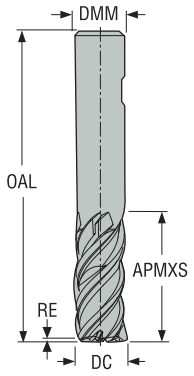


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				inch	inch	inch	inch	inch		
5540500Z4.3-SIRON-A	02711608	2	D	0.500	0.500	1.000	3.500	0.006	4	■
5540750Z4.3-SIRON-A	02711632	2	D	0.750	0.750	1.500	4.000	0.010	4	■

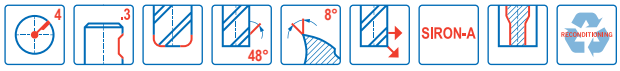
■ Stocked standard.

JS554

High performance – Universal – Square – 4 Flutes – Weldon – Corner radius – *Inch*



D



- Tolerances:
- DMM=h5
- DC=e7
- RE= ±.0008 *inch*
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				inch	inch	inch	inch	inch		
5540500R015Z4.3-SIRON-A	02711613	2	D	0.500	0.500	1.000	3.500	0.015	4	■
5540500R030Z4.3-SIRON-A	02711615	2	D	0.500	0.500	1.000	3.500	0.030	4	■
5540500R125Z4.3-SIRON-A	02856456	2	D	0.500	0.500	1.000	3.500	0.125	4	□
5540625R125Z4.3-SIRON-A	02856457	2	D	0.625	0.625	1.250	3.750	0.125	4	□
5541000R060Z4.3-SIRON-A	02711663	2	D	1.000	1.000	2.000	5.000	0.060	4	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

Cutting data – JS554 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0.400	1.0	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.15	0.17	0.19	215 (190 — 240)
		0,400	*1,0*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0060*	*0,0065*	*0,0075*	*710 (630 — 780)*
P2	M/A/D/E	0.400	1.0	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.15	0.17	0.19	210 (190 — 240)
		0,400	*1,0*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0060*	*0,0065*	*0,0075*	*690 (630 — 780)*
P3	M/A/D/E	0.400	1.0	0.028	0.038	0.048	0.055	0.075	0.095	0.11	0.14	0.16	0.18	185 (160 — 200)
		0,400	*1,0*	*0,0011*	*0,0015*	*0,0019*	*0,0022*	*0,0030*	*0,0038*	*0,0044*	*0,0055*	*0,0065*	*0,0070*	*610 (530 — 650)*
P4	M/A/D/E	0.400	1.0	0.028	0.038	0.046	0.055	0.075	0.095	0.11	0.14	0.16	0.18	160 (140 — 180)
		0,400	*1,0*	*0,0011*	*0,0015*	*0,0018*	*0,0022*	*0,0030*	*0,0038*	*0,0044*	*0,0055*	*0,0065*	*0,0070*	*520 (460 — 590)*
P5	M/A/D/E	0.400	1.0	0.028	0.036	0.046	0.055	0.075	0.090	0.11	0.13	0.16	0.18	155 (140 — 170)
		0,400	*1,0*	*0,0011*	*0,0014*	*0,0018*	*0,0022*	*0,0030*	*0,0036*	*0,0044*	*0,0050*	*0,0065*	*0,0070*	*510 (460 — 550)*
P6	M/A/D/E	0.400	1.0	0.028	0.036	0.046	0.055	0.075	0.090	0.11	0.13	0.15	0.17	175 (160 — 200)
		0,400	*1,0*	*0,0011*	*0,0014*	*0,0018*	*0,0022*	*0,0030*	*0,0036*	*0,0044*	*0,0050*	*0,0060*	*0,0065*	*570 (530 — 650)*
P7	M/A/D/E	0.400	1.0	0.028	0.036	0.046	0.055	0.075	0.090	0.11	0.13	0.15	0.17	165 (150 — 180)
		0,400	*1,0*	*0,0011*	*0,0014*	*0,0018*	*0,0022*	*0,0030*	*0,0036*	*0,0044*	*0,0050*	*0,0060*	*0,0065*	*540 (500 — 590)*
P8	M/A/D/E	0.400	1.0	0.028	0.038	0.048	0.055	0.075	0.095	0.11	0.14	0.16	0.18	155 (140 — 170)
		0,400	*1,0*	*0,0011*	*0,0015*	*0,0019*	*0,0022*	*0,0030*	*0,0038*	*0,0044*	*0,0055*	*0,0065*	*0,0070*	*510 (460 — 550)*
P11	M/A/D/E	0.400	1.0	0.026	0.036	0.044	0.055	0.070	0.090	0.11	0.13	0.15	0.17	140 (130 — 150)
		0,400	*1,0*	*0,0010*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0036*	*0,0044*	*0,0050*	*0,0060*	*0,0065*	*460 (430 — 490)*
P12	M/A/D/E	0.400	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.090	0.10	0.12	90 (79 — 100)
		0,400	*1,0*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0036*	*0,0040*	*0,0048*	*295 (260 — 320)*
M1	E	0.400	1.0	0.020	0.026	0.034	0.040	0.055	0.065	0.080	0.10	0.11	0.13	110 (96 — 120)
		0,400	*1,0*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0022*	*0,0026*	*0,0032*	*0,0040*	*0,0044*	*0,0050*	*360 (320 — 390)*
M2	E	0.400	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.090	0.10	0.12	90 (79 — 100)
		0,400	*1,0*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0036*	*0,0040*	*0,0048*	*295 (260 — 320)*
M3	E	0.400	0.90	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.075	0.085	0.095	55 (45 — 66)
		0,400	*0,90*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*0,0034*	*0,0038*	*180 (150 — 210)*
M4	E	0.400	0.90	0.013	0.018	0.022	0.026	0.036	0.044	0.055	0.065	0.075	0.085	43 (35 — 51)
		0,400	*0,90*	*0,00050*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*140 (120 — 160)*
M5	E	0.400	0.90	0.013	0.018	0.022	0.026	0.036	0.044	0.055	0.065	0.075	0.085	36 (29 — 42)
		0,400	*0,90*	*0,00050*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*120 (96 — 130)*
K1	E	0.400	1.2	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.12	0.14	0.16	175 (160 — 190)
		0,400	*1,2*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0048*	*0,0055*	*0,0065*	*570 (530 — 620)*
K2	E	0.400	1.2	0.022	0.030	0.038	0.044	0.060	0.075	0.090	0.11	0.13	0.14	155 (140 — 170)
		0,400	*1,2*	*0,00085*	*0,0012*	*0,0015*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0044*	*0,0050*	*0,0055*	*510 (460 — 550)*
K3	E	0.400	1.2	0.022	0.030	0.038	0.044	0.060	0.075	0.090	0.11	0.13	0.14	130 (120 — 140)
		0,400	*1,2*	*0,00085*	*0,0012*	*0,0015*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0044*	*0,0050*	*0,0055*	*425 (400 — 450)*
K4	E	0.400	1.2	0.022	0.030	0.038	0.044	0.060	0.075	0.090	0.11	0.13	0.14	125 (110 — 140)
		0,400	*1,2*	*0,00085*	*0,0012*	*0,0015*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0044*	*0,0050*	*0,0055*	*410 (370 — 450)*
K5	E	0.400	1.0	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.12	0.14	0.16	155 (140 — 170)
		0,400	*1,0*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0048*	*0,0055*	*0,0065*	*510 (460 — 550)*
K6	E	0.400	1.0	0.028	0.036	0.046	0.055	0.070	0.090	0.11	0.13	0.15	0.17	220 (190 — 250)
		0,400	*1,0*	*0,0011*	*0,0014*	*0,0018*	*0,0022*	*0,0028*	*0,0036*	*0,0044*	*0,0050*	*0,0060*	*0,0065*	*720 (630 — 820)*
K7	E	0.400	1.0	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.12	0.14	0.16	195 (170 — 220)
		0,400	*1,0*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0048*	*0,0055*	*0,0065*	*640 (560 — 720)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS554 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
N1	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100 — 1400)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890 — 1200)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72 — 120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44 — 78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H11	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	95 (75 — 110) *310 (250 — 360)*
H12	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	90 (73 — 100) *295 (240 — 320)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110 — 190) *510 (370 — 620)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600 — 1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600 — 1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JS554 Slot milling

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	195 (170 — 220)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*640 (560 — 720)*
P2	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	190 (170 — 210)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*620 (560 — 680)*
P3	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	165 (140 — 180)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*540 (460 — 590)*
P4	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	145 (130 — 160)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*475 (430 — 520)*
P5	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	135 (120 — 150)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*445 (400 — 490)*
P6	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	155 (140 — 170)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*510 (460 — 550)*
P7	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	145 (130 — 160)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*475 (430 — 520)*
P8	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	135 (120 — 150)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*445 (400 — 490)*
P11	M/A/D/E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	130 (120 — 140)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*425 (400 — 450)*
P12	M/A/D/E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	80 (69 — 87)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*260 (230 — 280)*
M1	E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	95 (85 — 100)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*310 (280 — 320)*
M2	E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	80 (69 — 87)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*260 (230 — 280)*
M3	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	48 (39 — 57)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*155 (130 — 180)*
M4	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	36 (29 — 43)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*120 (96 — 140)*
M5	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	30 (25 — 36)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*100 (83 — 110)*
K1	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	155 (140 — 170)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*510 (460 — 550)*
K2	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	135 (120 — 150)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K3	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	115 (110 — 120)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*375 (370 — 390)*
K4	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	110 (96 — 120)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*360 (320 — 390)*
K5	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	135 (120 — 150)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K6	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	200 (180 — 220)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*660 (600 — 720)*
K7	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	175 (150 — 190)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*570 (500 — 620)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Cutting data – JS554 Slot milling

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
N1	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	370 (310 — 430) *1225 (1100 — 1400)*
N3	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	30 (25 — 34) *100 (83 — 110)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H11	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 97) *260 (220 — 310)*
H12	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (60 — 89) *245 (200 — 290)*
H21	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	125 (90 — 160) *410 (300 — 520)*
TS1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500 — 1000)*
TP1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500 — 1100)*
GR1	A	0.80 *0,80*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300 — 1900)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Seco

Cutting data – JS554 Side milling roughing – *Inch*

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630 — 780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 240) *690 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	165 (150 — 180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120 — 160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96 — 130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	175 (160 — 190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	155 (140 — 170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (120 — 140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	125 (110 — 140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Cutting data – JS554 Side milling roughing – *Inch*

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890 — 1200)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	38 (32 — 44) *125 (110 — 140)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72 — 120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44 — 78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.15 *0,0060*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110 — 190) *510 (370 — 620)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.080 *0,0032*	0.095 *0,0038*	60 (48 — 71) *195 (160 — 230)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600 — 1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600 — 1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Seco

Cutting data – JS554 Slot milling – *Inch*

SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	48 (39 — 57) *155 (130 — 180)*
M4	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	36 (29 — 43) *120 (96 — 140)*
M5	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	155 (140 — 170) *510 (460 — 550)*
K2	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K3	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	115 (110 — 120) *375 (370 — 390)*
K4	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
K5	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	200 (180 — 220) *660 (600 — 720)*
K7	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	175 (150 — 190) *570 (500 — 620)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Cutting data – JS554 Slot milling – *Inch*

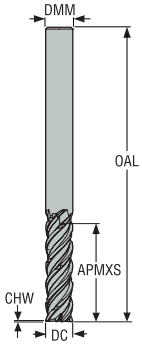
SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	370 (310 — 430) *1225 (1100 — 1400)*
N3	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 34) *100 (83 — 110)*
S2	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H21	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	125 (90 — 160) *410 (300 — 520)*
H31	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 57) *155 (130 — 180)*
TS1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500 — 1000)*
TP1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500 — 1100)*
GR1	A	0.80 *0,80*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300 — 1900)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

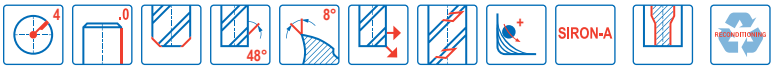
JS554-3C

Advanced roughing – Universal – Square – 4 Flutes – Cylindrical – Chamfer



D

- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible

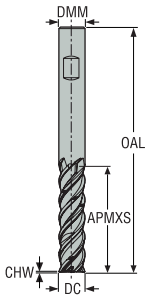


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS554060D3C.0Z4C-SIRA	02810475	3	D	■	6,0	6,0	23,0	65,0	0,075	4	■
JS554080D3C.0Z4C-SIRA	02810477	3	D	■	8,0	8,0	32,0	75,0	0,1	4	■
JS554100D3C.0Z4C-SIRA	02810479	3	D	■	10,0	10,0	40,0	85,0	0,125	4	■
JS554120D3C.0Z4C-SIRA	02810481	3	D	■	12,0	12,0	45,0	100,0	0,15	4	■
JS554160D3C.0Z4C-SIRA	02810483	3	D	■	16,0	16,0	55,0	115,0	0,2	4	■
JS554200D3C.0Z4C-SIRA	02810485	3	D	■	20,0	20,0	65,0	125,0	0,25	4	■
JS554250D3C.0Z4C-SIRA	02810486	3	D	■	25,0	25,0	85,0	150,0	0,3	4	■

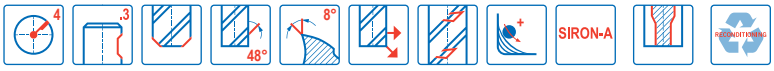
■ Stocked standard.

JS554-3C

Advanced roughing – Universal – Square – 4 Flutes – Weldon – Chamfer



D



- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS554060D3C.3Z4C-SIRA	02810474	3	D	■	6,0	6,0	23,0	65,0	0,075	4	■
JS554080D3C.3Z4C-SIRA	02810476	3	D	■	8,0	8,0	32,0	75,0	0,1	4	■
JS554100D3C.3Z4C-SIRA	02810478	3	D	■	10,0	10,0	40,0	85,0	0,125	4	■
JS554120D3C.3Z4C-SIRA	02810480	3	D	■	12,0	12,0	45,0	100,0	0,15	4	■
JS554160D3C.3Z4C-SIRA	02810482	3	D	■	16,0	16,0	55,0	115,0	0,2	4	■
JS554200D3C.3Z4C-SIRA	02810484	3	D	■	20,0	20,0	65,0	125,0	0,25	4	■
JS554250D3C.3Z4C-SIRA	02810487	3	D	■	25,0	25,0	85,0	150,0	0,3	4	■

■ Stocked standard.

Seco

Cutting data – JS554-3C Advanced roughing

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P1	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	350 (320 — 380) *1150 (1100 — 1200)*
P2	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100 — 1200)*
P3	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	295 (270 — 320) *970 (890 — 1000)*
P4	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	260 (240 — 280) *850 (790 — 910)*
P5	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (230 — 270) *820 (760 — 880)*
P6	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	280 (260 — 300) *920 (860 — 980)*
P7	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	265 (240 — 290) *870 (790 — 950)*
P8	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	250 (230 — 270) *820 (760 — 880)*
P11	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	245 (230 — 270) *800 (760 — 880)*
P12	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (140 — 160) *490 (460 — 520)*
M1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	180 (160 — 210) *590 (530 — 680)*
M2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (130 — 170) *490 (430 — 550)*
M3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	100 (90 — 100) *330 (300 — 320)*
M4	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	75 (70 — 85) *245 (230 — 270)*
M5	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	65 (59 — 71) *215 (200 — 230)*
K1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100 — 1200)*
K2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
K3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	255 (240 — 280) *840 (790 — 910)*
K4	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (220 — 260) *800 (730 — 850)*
K5	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (140 — 160) *490 (460 — 520)*
K6	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (200 — 230) *710 (660 — 750)*
K7	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	190 (180 — 200) *620 (600 — 650)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS554-3C Advanced roughing

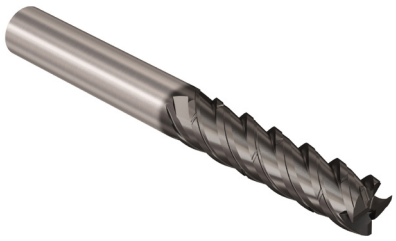
SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	750 (650 — 840) *2450 (2200 — 2700)*
N2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	480 (420 — 540) *1575 (1400 — 1700)*
N3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	320 (280 — 360) *1050 (920 — 1100)*
N11	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	375 (330 — 420) *1225 (1100 — 1300)*
S1	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	50 (40 — 60) *165 (140 — 190)*
S2	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	25 (20 — 29) *80 (66 — 95)*
S11	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	195 (130 — 220) *640 (430 — 720)*
S12	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	150 (100 — 160) *490 (330 — 520)*
S13	E	0.100 *0,100*	3.6 *3,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	120 (80 — 130) *395 (270 — 420)*
H5	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	200 (190 — 220) *660 (630 — 720)*
H8	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630 — 720)*
H11	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	255 (240 — 280) *840 (790 — 910)*
H12	M/A/D	0.100 *0,100*	3.6 *3,6*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	205 (190 — 220) *670 (630 — 720)*
H21	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630 — 720)*

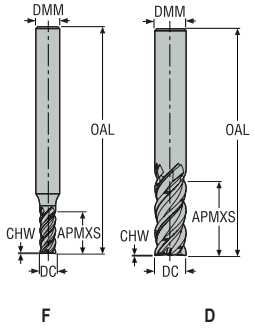
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS564

Advanced roughing – Universal – Square – 4 Flutes – Cylindrical – Chamfer





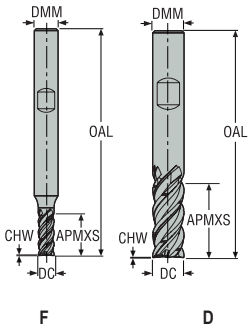
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible if DC is ≥Ø8

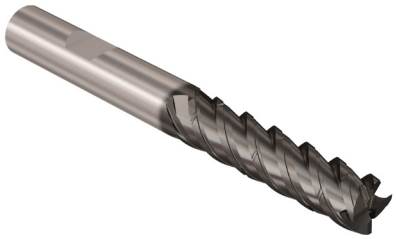
Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS564030F2C.0Z4C-NXT	03067338	2	F	■	3,0	6,0	7,0	57,0	0,04	4	■
JS564040F2C.0Z4C-NXT	03067339	2	F	■	4,0	6,0	10,0	57,0	0,05	4	■
JS564050F2C.0Z4C-NXT	03067340	2	F	■	5,0	6,0	12,5	57,0	0,06	4	■
JS564060D2C.0Z4C-NXT	03067341	2	D	■	6,0	6,0	15,0	57,0	0,075	4	■
JS564080D2C.0Z4C-NXT	03067342	2	D	■	8,0	8,0	20,0	63,0	0,1	4	■
JS564100D2C.0Z4C-NXT	03067343	2	D	■	10,0	10,0	25,0	72,0	0,125	4	■
JS564120D2C.0Z4C-NXT	03067344	2	D	■	12,0	12,0	30,0	83,0	0,15	4	■
JS564160D2C.0Z4C-NXT	03067345	2	D	■	16,0	16,0	40,0	99,0	0,2	4	■
JS564200D2C.0Z4C-NXT	03067346	2	D	■	20,0	20,0	50,0	114,0	0,25	4	■
JS564060D3C.0Z4C-NXT	03067347	3	D	■	6,0	6,0	23,0	64,0	0,075	4	■
JS564080D3C.0Z4C-NXT	03067348	3	D	■	8,0	8,0	32,0	74,0	0,1	4	■
JS564100D3C.0Z4C-NXT	03067349	3	D	■	10,0	10,0	40,0	88,0	0,125	4	■
JS564120D3C.0Z4C-NXT	03067350	3	D	■	12,0	12,0	45,0	99,0	0,15	4	■
JS564160D3C.0Z4C-NXT	03067351	3	D	■	16,0	16,0	55,0	114,0	0,2	4	■
JS564200D3C.0Z4C-NXT	03067352	3	D	■	20,0	20,0	65,0	126,0	0,25	4	■

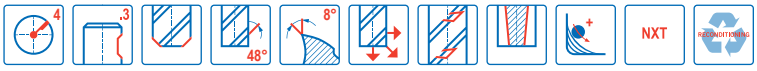
■ Stocked standard.

JS564

Advanced roughing – Universal – Square – 4 Flutes – Weldon – Chamfer







- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible if DC is ≥Ø8

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS564030F2C.3Z4C-NXT	03067353	2	F	■	3,0	6,0	7,0	57,0	0,04	4	■
JS564040F2C.3Z4C-NXT	03067354	2	F	■	4,0	6,0	10,0	57,0	0,05	4	■
JS564050F2C.3Z4C-NXT	03067355	2	F	■	5,0	6,0	12,5	57,0	0,06	4	■
JS564060D2C.3Z4C-NXT	03067356	2	D	■	6,0	6,0	15,0	57,0	0,075	4	■
JS564080D2C.3Z4C-NXT	03067357	2	D	■	8,0	8,0	20,0	63,0	0,1	4	■
JS564100D2C.3Z4C-NXT	03067358	2	D	■	10,0	10,0	25,0	72,0	0,125	4	■
JS564120D2C.3Z4C-NXT	03067359	2	D	■	12,0	12,0	30,0	83,0	0,15	4	■
JS564160D2C.3Z4C-NXT	03067360	2	D	■	16,0	16,0	40,0	99,0	0,2	4	■
JS564200D2C.3Z4C-NXT	03067361	2	D	■	20,0	20,0	50,0	114,0	0,25	4	■
JS564060D3C.3Z4C-NXT	03067362	3	D	■	6,0	6,0	23,0	64,0	0,075	4	■
JS564080D3C.3Z4C-NXT	03067363	3	D	■	8,0	8,0	32,0	74,0	0,1	4	■
JS564100D3C.3Z4C-NXT	03067364	3	D	■	10,0	10,0	40,0	88,0	0,125	4	■
JS564120D3C.3Z4C-NXT	03067365	3	D	■	12,0	12,0	45,0	99,0	0,15	4	■
JS564160D3C.3Z4C-NXT	03067366	3	D	■	16,0	16,0	55,0	114,0	0,2	4	■
JS564200D3C.3Z4C-NXT	03067367	3	D	■	20,0	20,0	65,0	126,0	0,25	4	■

■ Stocked standard.

Seco

Cutting data – JS564 Side milling advanced roughing

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	305 (270 — 340) *1000 (890 — 1100)*
P2	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	295 (260 — 330) *970 (860 — 1000)*
P3	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (230 — 290) *850 (760 — 950)*
P4	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P5	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	215 (190 — 240) *710 (630 — 780)*
P6	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	240 (210 — 270) *790 (690 — 880)*
P7	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P8	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	215 (190 — 240) *710 (630 — 780)*
P11	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	200 (180 — 220) *660 (600 — 720)*
P12	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (120 — 140) *425 (400 — 450)*
M1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	195 (170 — 210) *640 (560 — 680)*
M2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 170) *520 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92 — 120) *360 (310 — 390)*
K1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	260 (230 — 290) *850 (760 — 950)*
K2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
K3	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	195 (170 — 210) *640 (560 — 680)*
K4	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (170 — 200) *610 (560 — 650)*
K5	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	115 (99 — 120) *375 (330 — 390)*
K6	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
K7	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS564 Side milling advanced roughing

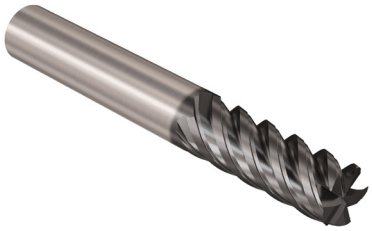
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	700 (600 — 790) *2300 (2000 — 2500)*
N2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	450 (390 — 510) *1475 (1300 — 1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
N11	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	350 (300 — 390) *1150 (990 — 1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	60 (37 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	50 (30 — 69) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	43 (26 — 60) *140 (86 — 190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.018 *0,00070*	0.024 *0,00095*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	125 (110 — 140) *410 (370 — 450)*

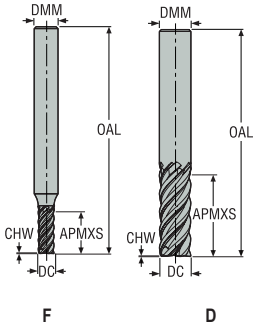
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

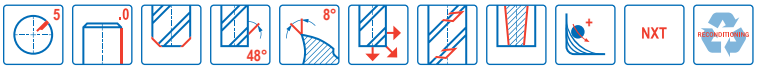
JS565

Advanced roughing – Universal – Square – 5 Flutes – Cylindrical – Chamfer





- Tolerances:
- DMM= h5
- DC= e7
- PCEDC5= no chip splitters
- PCEDC5C= with chip splitters
- Regrind possible if DC is ≥Ø8

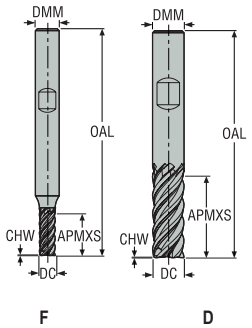


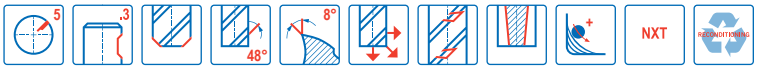
Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS565040F2C.0Z5-NXT	03067369	2	F	–	4,0	6,0	10,0	57,0	0,05	5	■
JS565040F2C.0Z5C-NXT	03067378	2	F	■	4,0	6,0	10,0	57,0	0,05	5	■
JS565050F2C.0Z5-NXT	03067370	2	F	–	5,0	6,0	12,5	57,0	0,06	5	■
JS565050F2C.0Z5C-NXT	03067379	2	F	■	5,0	6,0	12,5	57,0	0,06	5	■
JS565060D2C.0Z5-NXT	03067371	2	D	–	6,0	6,0	15,0	57,0	0,075	5	■
JS565060D2C.0Z5C-NXT	03067380	2	D	■	6,0	6,0	15,0	57,0	0,075	5	■
JS565080D2C.0Z5-NXT	03067372	2	D	–	8,0	8,0	20,0	63,0	0,1	5	■
JS565080D2C.0Z5C-NXT	03067381	2	D	■	8,0	8,0	20,0	63,0	0,1	5	■
JS565100D2C.0Z5-NXT	03067373	2	D	–	10,0	10,0	25,0	72,0	0,125	5	■
JS565100D2C.0Z5C-NXT	03067382	2	D	■	10,0	10,0	25,0	72,0	0,125	5	■
JS565120D2C.0Z5-NXT	03067374	2	D	–	12,0	12,0	30,0	83,0	0,15	5	■
JS565120D2C.0Z5C-NXT	03067383	2	D	■	12,0	12,0	30,0	83,0	0,15	5	■
JS565160D2C.0Z5-NXT	03067375	2	D	–	16,0	16,0	40,0	99,0	0,2	5	■
JS565160D2C.0Z5C-NXT	03067384	2	D	■	16,0	16,0	40,0	99,0	0,2	5	■
JS565200D2C.0Z5-NXT	03067376	2	D	–	20,0	20,0	50,0	114,0	0,25	5	■
JS565200D2C.0Z5C-NXT	03067385	2	D	■	20,0	20,0	50,0	114,0	0,25	5	■
JS565060D3C.0Z5C-NXT	03067386	3	D	■	6,0	6,0	23,0	64,0	0,075	5	■
JS565080D3C.0Z5C-NXT	03067387	3	D	■	8,0	8,0	32,0	74,0	0,1	5	■
JS565100D3C.0Z5C-NXT	03067388	3	D	■	10,0	10,0	40,0	88,0	0,125	5	■
JS565120D3C.0Z5C-NXT	03067389	3	D	■	12,0	12,0	45,0	99,0	0,15	5	■
JS565160D3C.0Z5C-NXT	03067390	3	D	■	16,0	16,0	55,0	114,0	0,2	5	■
JS565200D3C.0Z5C-NXT	03067391	3	D	■	20,0	20,0	65,0	126,0	0,25	5	■

■ Stocked standard.

JS565

Advanced roughing – Universal – Square – 5 Flutes – Weldon – Chamfer





- Tolerances:
- DMM= h5
- DC= e7
- PCEDC5= no chip splitters
- PCEDC5C= with chip splitters
- Regrind possible if DC is ≥Ø8

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS565040F2C.3Z5-NXT	03067393	2	F	–	4,0	6,0	10,0	57,0	0,05	5	■
JS565040F2C.3Z5C-NXT	03067402	2	F	■	4,0	6,0	10,0	57,0	0,05	5	■
JS565050F2C.3Z5-NXT	03067394	2	F	–	5,0	6,0	12,5	57,0	0,06	5	■
JS565050F2C.3Z5C-NXT	03067403	2	F	■	5,0	6,0	12,5	57,0	0,06	5	■
JS565060D2C.3Z5-NXT	03067395	2	D	–	6,0	6,0	15,0	57,0	0,075	5	■
JS565060D2C.3Z5C-NXT	03067404	2	D	■	6,0	6,0	15,0	57,0	0,075	5	■
JS565080D2C.3Z5-NXT	03067396	2	D	–	8,0	8,0	20,0	63,0	0,1	5	■
JS565080D2C.3Z5C-NXT	03067405	2	D	■	8,0	8,0	20,0	63,0	0,1	5	■
JS565100D2C.3Z5-NXT	03067397	2	D	–	10,0	10,0	25,0	72,0	0,125	5	■
JS565100D2C.3Z5C-NXT	03067406	2	D	■	10,0	10,0	25,0	72,0	0,125	5	■
JS565120D2C.3Z5-NXT	03067398	2	D	–	12,0	12,0	30,0	83,0	0,15	5	■
JS565120D2C.3Z5C-NXT	03067407	2	D	■	12,0	12,0	30,0	83,0	0,15	5	■
JS565160D2C.3Z5-NXT	03067399	2	D	–	16,0	16,0	40,0	99,0	0,2	5	■
JS565160D2C.3Z5C-NXT	03067408	2	D	■	16,0	16,0	40,0	99,0	0,2	5	■
JS565200D2C.3Z5-NXT	03067400	2	D	–	20,0	20,0	50,0	114,0	0,25	5	■
JS565200D2C.3Z5C-NXT	03067409	2	D	■	20,0	20,0	50,0	114,0	0,25	5	■
JS565060D3C.3Z5C-NXT	03067410	3	D	■	6,0	6,0	23,0	64,0	0,075	5	■
JS565080D3C.3Z5C-NXT	03067411	3	D	■	8,0	8,0	32,0	74,0	0,1	5	■
JS565100D3C.3Z5C-NXT	03067412	3	D	■	10,0	10,0	40,0	88,0	0,125	5	■
JS565120D3C.3Z5C-NXT	03067413	3	D	■	12,0	12,0	45,0	99,0	0,15	5	■
JS565160D3C.3Z5C-NXT	03067414	3	D	■	16,0	16,0	55,0	114,0	0,2	5	■
JS565200D3C.3Z5C-NXT	03067415	3	D	■	20,0	20,0	65,0	126,0	0,25	5	■

■ Stocked standard.

Seco

Cutting data – JS565 Side milling advanced roughing

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	325 (270 — 340) *1075 (890 — 1100)*
P2	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	315 (260 — 330) *1025 (860 — 1000)*
P3	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	280 (230 — 290) *920 (760 — 950)*
P4	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P5	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	230 (190 — 240) *750 (630 — 780)*
P6	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	260 (210 — 270) *850 (690 — 880)*
P7	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P8	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	230 (190 — 240) *750 (630 — 780)*
P11	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	225 (190 — 230) *740 (630 — 750)*
P12	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	140 (120 — 140) *460 (400 — 450)*
M1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	205 (180 — 210) *670 (600 — 680)*
M2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	170 (140 — 170) *560 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92 — 120) *360 (310 — 390)*
K1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	275 (230 — 290) *900 (760 — 950)*
K2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
K3	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	205 (170 — 210) *670 (560 — 680)*
K4	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	200 (170 — 200) *660 (560 — 650)*
K5	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	120 (98 — 120) *395 (330 — 390)*
K6	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	175 (150 — 180) *570 (500 — 590)*
K7	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (130 — 160) *510 (430 — 520)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS565 Side milling advanced roughing

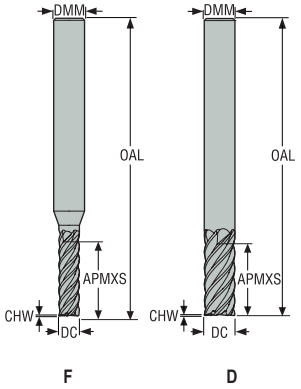
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	740 (600 — 790) *2425 (2000 — 2500)*
N2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	475 (390 — 510) *1550 (1300 — 1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
N11	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	370 (300 — 390) *1225 (990 — 1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	60 (38 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	50 (30 — 70) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	43 (27 — 60) *140 (89 — 190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	155 (140 — 180) *510 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (110 — 140) *395 (370 — 450)*

For cutting data recalculations, see pages 573 - 580

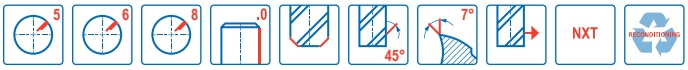
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS520

High performance – Universal – Square – 5-8 Flutes – Cylindrical – Chamfer



- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

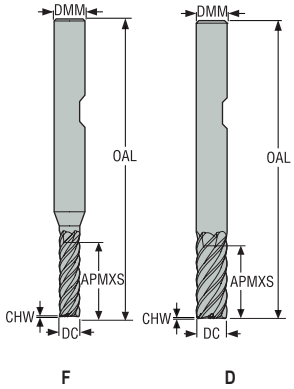


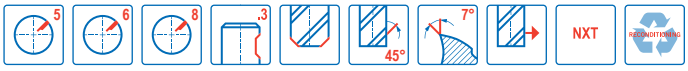
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS520040F2C.0Z5-NXT	02927474	2	F	4,0	6,0	10,0	57,0	0,04	5	■
JS520050F2C.0Z5-NXT	02927476	2	F	5,0	6,0	12,0	57,0	0,05	5	■
JS520060D2C.0Z5-NXT	02927478	2	D	6,0	6,0	15,0	57,0	0,06	5	■
JS520060D2C.0Z6-NXT	02927479	2	D	6,0	6,0	15,0	57,0	0,06	6	■
JS520080D2C.0Z5-NXT	02927482	2	D	8,0	8,0	20,0	63,0	0,08	5	■
JS520080D2C.0Z6-NXT	02927483	2	D	8,0	8,0	20,0	63,0	0,08	6	■
JS520100D2C.0Z6-NXT	02927486	2	D	10,0	10,0	25,0	72,0	0,1	6	■
JS520120D2C.0Z6-NXT	02927488	2	D	12,0	12,0	25,0	83,0	0,12	6	■
JS520140D2C.0Z6-NXT	02927490	2	D	14,0	14,0	30,0	83,0	0,14	6	■
JS520160D2C.0Z6-NXT	02927491	2	D	16,0	16,0	30,0	92,0	0,16	6	■
JS520160D2C.0Z8-NXT	02927492	2	D	16,0	16,0	30,0	92,0	0,16	8	■
JS520200D2C.0Z8-NXT	02927495	2	D	20,0	20,0	35,0	104,0	0,2	8	■
JS520250D2C.0Z8-NXT	02927497	2	D	25,0	25,0	50,0	125,0	0,25	8	■
JS520040F3C.0Z5-NXT	02927475	3	F	4,0	6,0	15,0	57,0	0,04	5	■
JS520050F3C.0Z5-NXT	02927477	3	F	5,0	6,0	19,0	57,0	0,05	5	■
JS520060D3C.0Z5-NXT	02927480	3	D	6,0	6,0	20,0	63,0	0,06	5	■
JS520060D3C.0Z6-NXT	02927481	3	D	6,0	6,0	20,0	63,0	0,06	6	■
JS520080D3C.0Z5-NXT	02927484	3	D	8,0	8,0	30,0	80,0	0,08	5	■
JS520080D3C.0Z6-NXT	02927485	3	D	8,0	8,0	30,0	80,0	0,08	6	■
JS520100D3C.0Z6-NXT	02927487	3	D	10,0	10,0	40,0	89,0	0,1	6	■
JS520120D3C.0Z6-NXT	02927489	3	D	12,0	12,0	45,0	100,0	0,12	6	■
JS520160D3C.0Z6-NXT	02927493	3	D	16,0	16,0	65,0	125,0	0,16	6	■
JS520160D3C.0Z8-NXT	02927494	3	D	16,0	16,0	65,0	125,0	0,16	8	■
JS520200D3C.0Z8-NXT	02927496	3	D	20,0	20,0	65,0	125,0	0,2	8	■
JS520250D3C.0Z8-NXT	02927498	3	D	25,0	25,0	75,0	150,0	0,25	8	■

■ Stocked standard.

JS520

High performance – Universal – Square – 5-8 Flutes – Weldon – Chamfer





- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS520040F2C.3Z5-NXT	02927499	2	F	4,0	6,0	10,0	57,0	0,04	5	☐
JS520050F2C.3Z5-NXT	02927501	2	F	5,0	6,0	12,0	57,0	0,05	5	☐
JS520060D2C.3Z5-NXT	02927503	2	D	6,0	6,0	15,0	57,0	0,06	5	☐
JS520060D2C.3Z6-NXT	02927504	2	D	6,0	6,0	15,0	57,0	0,06	6	☐
JS520080D2C.3Z5-NXT	02927507	2	D	8,0	8,0	20,0	63,0	0,08	5	☐
JS520080D2C.3Z6-NXT	02927508	2	D	8,0	8,0	20,0	63,0	0,08	6	☐
JS520100D2C.3Z6-NXT	02927511	2	D	10,0	10,0	25,0	72,0	0,1	6	☐
JS520120D2C.3Z6-NXT	02927513	2	D	12,0	12,0	25,0	83,0	0,12	6	☐
JS520140D2C.3Z6-NXT	02927515	2	D	14,0	14,0	30,0	83,0	0,14	6	☐
JS520160D2C.3Z6-NXT	02927516	2	D	16,0	16,0	30,0	92,0	0,16	6	☐
JS520160D2C.3Z8-NXT	02927517	2	D	16,0	16,0	30,0	92,0	0,16	8	■
JS520200D2C.3Z8-NXT	02927520	2	D	20,0	20,0	35,0	104,0	0,2	8	■
JS520250D2C.3Z8-NXT	02927522	2	D	25,0	25,0	50,0	125,0	0,25	8	☐
JS520040F3C.3Z5-NXT	02927500	3	F	4,0	6,0	15,0	57,0	0,04	5	☐
JS520050F3C.3Z5-NXT	02927502	3	F	5,0	6,0	19,0	57,0	0,05	5	☐
JS520060D3C.3Z5-NXT	02927505	3	D	6,0	6,0	20,0	63,0	0,06	5	☐
JS520060D3C.3Z6-NXT	02927506	3	D	6,0	6,0	20,0	63,0	0,06	6	☐
JS520080D3C.3Z5-NXT	02927509	3	D	8,0	8,0	30,0	80,0	0,08	5	☐
JS520080D3C.3Z6-NXT	02927510	3	D	8,0	8,0	30,0	80,0	0,08	6	☐
JS520100D3C.3Z6-NXT	02927512	3	D	10,0	10,0	40,0	89,0	0,1	6	☐
JS520120D3C.3Z6-NXT	02927514	3	D	12,0	12,0	45,0	100,0	0,12	6	☐
JS520160D3C.3Z6-NXT	02927518	3	D	16,0	16,0	65,0	125,0	0,16	6	☐
JS520160D3C.3Z8-NXT	02927519	3	D	16,0	16,0	65,0	125,0	0,16	8	☐
JS520200D3C.3Z8-NXT	02927521	3	D	20,0	20,0	65,0	125,0	0,2	8	☐
JS520250D3C.3Z8-NXT	02927523	3	D	25,0	25,0	75,0	150,0	0,25	8	☐

■ Stocked standard. ☐ Weldon available. Delivery time is 3 days.

Seco

Cutting data – JS520 Side milling

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (120 — 250) *590 (400 — 820)*
P2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370 — 780)*
P3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (95 — 210) *510 (320 — 680)*
P4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	135 (84 — 180) *445 (280 — 590)*
P5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	130 (81 — 180) *425 (270 — 590)*
P6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	145 (90 — 200) *475 (300 — 650)*
P7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (85 — 190) *460 (280 — 620)*
P8	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	130 (80 — 170) *425 (270 — 550)*
P11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	195 (160 — 230) *640 (530 — 750)*
P12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100 — 140) *410 (330 — 450)*
M1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (130 — 180) *490 (430 — 590)*
M2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100 — 150) *410 (330 — 490)*
M3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	100 (75 — 120) *330 (250 — 390)*
M4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (58 — 96) *245 (200 — 310)*
M5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (49 — 80) *215 (170 — 260)*
K1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370 — 780)*
K2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	155 (97 — 210) *510 (320 — 680)*
K3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	135 (82 — 180) *445 (270 — 590)*
K4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (79 — 170) *410 (260 — 550)*
K5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (48 — 100) *245 (160 — 320)*
K6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	110 (69 — 150) *360 (230 — 490)*
K7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (62 — 130) *330 (210 — 420)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS520 Side milling

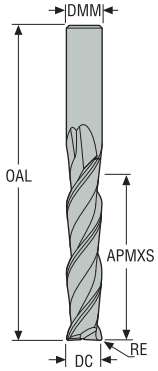
SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*
N2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	320 (290 — 350) *1050 (960 — 1100)*
N3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	215 (200 — 230) *710 (660 — 750)*
N11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	75 (63 — 86) *245 (210 — 280)*
S2	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (50 — 70) *195 (170 — 220)*
S3	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	40 (30 — 49) *130 (99 — 160)*
S11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	105 (92 — 110) *345 (310 — 360)*
S12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	80 (71 — 90) *260 (240 — 290)*
S13	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (56 — 71) *215 (190 — 230)*
H5	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (64 — 180) *410 (210 — 590)*
H8	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66 — 190) *425 (220 — 620)*
H11	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	160 (81 — 240) *520 (270 — 780)*
H12	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	150 (76 — 220) *490 (250 — 720)*
H21	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66 — 190) *425 (220 — 620)*
H31	M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (51 — 150) *330 (170 — 490)*
TS1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*
TP1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	395 (350 — 440) *1300 (1200 — 1400)*
GR1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

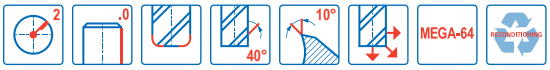
JS522

High performance – Universal – Square – 2 Flutes – High shoulder – Cylindrical – Corner radius



D

- Tolerances:
- Run-out= Ø6-Ø8 <0,01, Ø10-Ø12 <0,015, Ø16-Ø32 <0,02
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= 0,1+0,1 mm, RE= 0,5 ±0,03 mm
  RE= 3,1 ±0,05 mm, RE= 4 ±0,05 mm
  RE= 6 ±0,05 mm



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
522060R010Z2.0-MEGA-64	02747756	4	D	6,0	6,0	30,0	80,0	0,1	2	■
522080R010Z2.0-MEGA-64	02747763	4	D	8,0	8,0	40,0	85,0	0,1	2	■
522100R010Z2.0-MEGA-64	02747765	4	D	10,0	10,0	50,0	100,0	0,1	2	■
522120R010Z2.0-MEGA-64	02747766	4	D	12,0	12,0	60,0	115,0	0,1	2	■
522160R050Z2.0-MEGA-64	02747767	4	D	16,0	16,0	80,0	150,0	0,5	2	■
522160R310Z2.0-MEGA-64	02747768	4	D	16,0	16,0	80,0	150,0	3,1	2	■
JS522160D4R600.0Z2-M64	03093681	4	D	16,0	16,0	80,0	150,0	6,0	2	■
522200R050Z2.0-MEGA-64	02747769	4	D	20,0	20,0	100,0	175,0	0,5	2	■
522200R310Z2.0-MEGA-64	02747770	4	D	20,0	20,0	100,0	175,0	3,1	2	■
JS522200D4R600.0Z2-M64	03093682	4	D	20,0	20,0	100,0	175,0	6,0	2	■
522250R050Z2.0-MEGA-64	02747771	4	D	25,0	25,0	125,0	205,0	0,5	2	■
522250R310Z2.0-MEGA-64	02747772	4	D	25,0	25,0	125,0	205,0	3,1	2	■
522250R400Z2.0-MEGA-64	02747773	4	D	25,0	25,0	125,0	205,0	4,0	2	■
JS522250D4R600.0Z2-M64	03093683	4	D	25,0	25,0	125,0	205,0	6,0	2	■
522320R050Z2.0-MEGA-64	02747774	4	D	32,0	32,0	160,0	245,0	0,5	2	■
522320R400Z2.0-MEGA-64	02747775	4	D	32,0	32,0	160,0	245,0	4,0	2	■
JS522320D4R600.0Z2-M64	03093684	4	D	32,0	32,0	160,0	245,0	6,0	2	■

■ Stocked standard.
*JS522 long flute finisher, with its special geometry designed to machine high shoulders with exellent surface finish and perpendicularity.

Cutting data – JS522 Side milling semi finishing

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
P1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	160 (140 — 170) *520 (460 — 550)*
P2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	155 (140 — 170) *510 (460 — 550)*
P3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	120 (110 — 140) *395 (370 — 450)*
P7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	115 (95 — 130) *375 (320 — 420)*
P8	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	105 (89 — 120) *345 (300 — 390)*
P11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	105 (87 — 120) *345 (290 — 390)*
P12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	65 (55 — 75) *215 (190 — 240)*
M1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	110 (86 — 130) *360 (290 — 420)*
M2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (71 — 110) *295 (240 — 360)*
M3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	80 (61 — 100) *260 (210 — 320)*
M4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	60 (47 — 76) *195 (160 — 240)*
M5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (39 — 63) *165 (130 — 200)*
K1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 98) *280 (240 — 320)*
K5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (81 — 120) *330 (270 — 390)*
K6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (110 — 150) *425 (370 — 490)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JS522 Side milling semi finishing

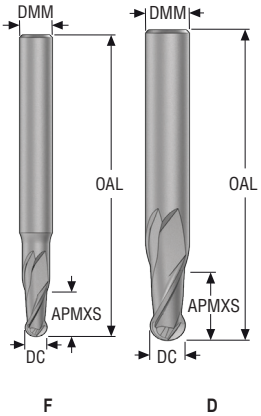
SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
N1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100 — 1600)*
N2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (210 — 400) *980 (690 — 1300)*
N3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	200 (140 — 260) *660 (460 — 850)*
N11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (260 — 350) *980 (860 — 1100)*
S1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	48 (39 — 57) *155 (130 — 180)*
S2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	39 (31 — 46) *130 (110 — 150)*
S3	E/M/A	0.0300 *0,0300*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	42 (32 — 51) *140 (110 — 160)*
S11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	125 (100 — 140) *410 (330 — 450)*
S12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	95 (77 — 110) *310 (260 — 360)*
S13	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (61 — 90) *245 (210 — 290)*
TS1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400 — 1900)*
TP1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100 — 1600)*
GR1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400 — 1900)*

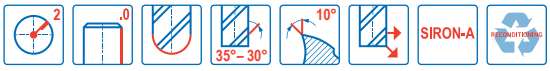
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JSB512

General purpose – Universal – Ball nose – 2 Flutes – Cylindrical





- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø10

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
					mm	mm	mm	mm		
JSB512020F2B.0Z2	SIRA	10053561	2	F	2,0	3,0	3,0	40,0	2	■
JSB512030D2B.0Z2	SIRA	10053562	2	D	3,0	3,0	5,0	40,0	2	■
JSB512040D2B.0Z2	SIRA	10053563	2	D	4,0	4,0	6,0	50,0	2	■
JSB512050F2B.0Z2	SIRA	10053564	2	F	5,0	6,0	8,0	57,0	2	■
JSB512060D2B.0Z2	SIRA	10053565	2	D	6,0	6,0	9,0	57,0	2	■
JSB512080D2B.0Z2	SIRA	10053566	2	D	8,0	8,0	12,0	63,0	2	■
JSB512100D2B.0Z2	SIRA	10053567	2	D	10,0	10,0	15,0	72,0	2	■
JSB512120D2B.0Z2	SIRA	10053568	2	D	12,0	12,0	18,0	83,0	2	■

■ Stocked standard.

Seco

Cutting data – JSB512 Copy milling roughing

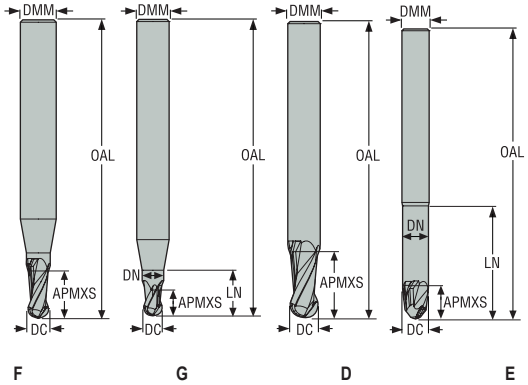
SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P2	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P3	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P4	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P5	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P6	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P7	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P8	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P11	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
P12	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M2	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M3	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M4	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M5	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
K1	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K2	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K3	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K4	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K5	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K6	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K7	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
N1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	500 (380 — 620) *1650 (1300 — 2000)*
N11	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	375 (260 — 500) *1225 (860 — 1600)*
S11	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (66 — 130) *295 (220 — 420)*
S12	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
S13	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*

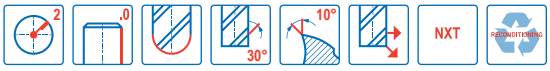
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS532

High performance – Universal – Ball nose – 2 Flutes – Cylindrical





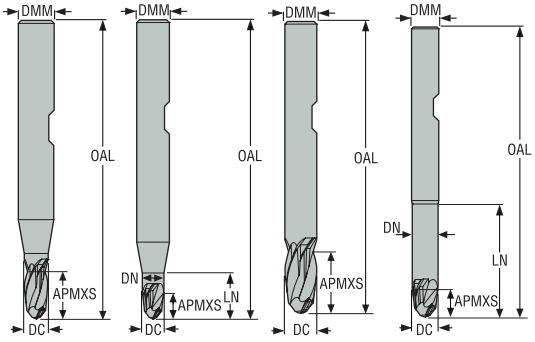
- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS532010F1B.0Z2-NXT	02928193	1	F	1,0	3,0	2,0	38,0	3,1	1,0	0,5	2	■
JS532015F1B.0Z2-NXT	02928194	1	F	1,5	3,0	3,0	38,0	4,6	1,5	0,75	2	■
JS532020F1B.0Z2-NXT	02928195	1	F	2,0	3,0	4,0	38,0	6,1	2,0	1,0	2	■
JS532025F1B.0Z2-NXT	02928197	1	F	2,5	3,0	5,0	38,0	7,1	2,5	1,25	2	■
JS532030D1B.0Z2-NXT	02928199	1	D	3,0	3,0	6,0	38,0	–	–	1,5	2	■
JS532035F1B.0Z2-NXT	02928202	1	F	3,5	6,0	7,0	57,0	9,6	3,5	1,75	2	■
JS532040F1B.0Z2-NXT	02928203	1	F	4,0	6,0	8,0	57,0	10,75	4,0	2,0	2	■
JS532045F1B.0Z2-NXT	02928206	1	F	4,5	6,0	9,0	57,0	11,75	4,5	2,25	2	■
JS532050F1B.0Z2-NXT	02928207	1	F	5,0	6,0	10,0	57,0	12,75	5,0	2,5	2	■
JS532060D1B.0Z2-NXT	02928210	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	■
JS532080D1B.0Z2-NXT	02928213	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	■
JS532100D1B.0Z2-NXT	02928216	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	■
JS532120D1B.0Z2-NXT	02928219	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	■
JS532160D1B.0Z2-NXT	02928222	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	■
JS532200D1B.0Z2-NXT	02928225	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	■
JS532020G2B.0Z2-NXT	02928196	2	G	2,0	3,0	2,0	38,0	8,0	1,9	1,0	2	■
JS532030E2B.0Z2-NXT	02928200	2	E	3,0	3,0	3,0	38,0	10,0	2,85	1,5	2	■
JS532040G2B.0Z2-NXT	02928204	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	2	■
JS532050G2B.0Z2-NXT	02928208	2	G	5,0	6,0	5,0	57,0	20,0	4,8	2,5	2	■
JS532060E2B.0Z2-NXT	02928211	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	■
JS532080E2B.0Z2-NXT	02928214	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	■
JS532100E2B.0Z2-NXT	02928217	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	■
JS532120E2B.0Z2-NXT	02928220	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	■
JS532160E2B.0Z2-NXT	02928223	2	E	16,0	16,0	16,0	125,0	72,0	15,2	8,0	2	■
JS532030E3B.0Z2-NXT	02928201	3	E	3,0	3,0	3,0	52,0	20,0	2,85	1,5	2	■
JS532040G3B.0Z2-NXT	02928205	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	■
JS532050G3B.0Z2-NXT	02928209	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	■
JS532060E3B.0Z2-NXT	02928212	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	■
JS532080E3B.0Z2-NXT	02928215	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	■
JS532100E3B.0Z2-NXT	02928218	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	■
JS532120E3B.0Z2-NXT	02928221	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	■
JS532160E3B.0Z2-NXT	02928224	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	■

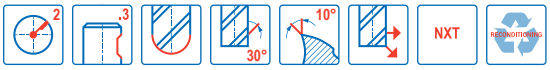
■ Stocked standard.

JS532

High performance – Universal – Ball nose – 2 Flutes – Weldon



- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS532035F1B.3Z2-NXT	02928254	1	F	3,5	6,0	7,0	57,0	9,6	3,5	1,75	2	☐
JS532040F1B.3Z2-NXT	02928255	1	F	4,0	6,0	8,0	57,0	10,75	4,0	2,0	2	☐
JS532045F1B.3Z2-NXT	02928258	1	F	4,5	6,0	9,0	57,0	11,75	4,5	2,25	2	☐
JS532050F1B.3Z2-NXT	02928259	1	F	5,0	6,0	10,0	57,0	12,75	5,0	2,5	2	☐
JS532060D1B.3Z2-NXT	02928263	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	☐
JS532080D1B.3Z2-NXT	02928266	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	☐
JS532100D1B.3Z2-NXT	02928269	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	☐
JS532120D1B.3Z2-NXT	02928272	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	☐
JS532160D1B.3Z2-NXT	02928275	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	☐
JS532200D1B.3Z2-NXT	02928278	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	☐
JS532040G2B.3Z2-NXT	02928256	2	G	4,0	6,0	4,0	57,0	18,0	3,8	2,0	2	☐
JS532050G2B.3Z2-NXT	02928260	2	G	5,0	6,0	5,0	57,0	18,0	4,8	2,5	2	☐
JS532060E2B.3Z2-NXT	02928264	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	☐
JS532080E2B.3Z2-NXT	02928267	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	☐
JS532100E2B.3Z2-NXT	02928270	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	☐
JS532120E2B.3Z2-NXT	02928273	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	☐
JS532160E2B.3Z2-NXT	02928276	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	2	☐
JS532040G3B.3Z2-NXT	02928257	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	☐
JS532050G3B.3Z2-NXT	02928261	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	☐
JS532060E3B.3Z2-NXT	02928265	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	☐
JS532080E3B.3Z2-NXT	02928268	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	☐
JS532100E3B.3Z2-NXT	02928271	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	☐
JS532120E3B.3Z2-NXT	02928274	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	☐
JS532160E3B.3Z2-NXT	02928277	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	☐

☐ Weldon available. Delivery time is 3 days.

Cutting data – JS532 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	205 (140 — 180) *670 (460 — 590)*
P2	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	200 (130 — 180) *660 (430 — 590)*
P3	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	170 (110 — 150) *560 (370 — 490)*
P4	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.10 *0,0040*	150 (97 — 130) *490 (320 — 420)*
P5	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	145 (93 — 130) *475 (310 — 420)*
P6	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	160 (110 — 140) *520 (370 — 450)*
P7	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (98 — 140) *490 (330 — 450)*
P8	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	145 (93 — 130) *475 (310 — 420)*
P11	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	170 (110 — 150) *560 (370 — 490)*
P12	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	100 (64 — 92) *330 (210 — 300)*
M1	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	195 (170 — 220) *640 (560 — 720)*
M2	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	115 (93 — 130) *375 (310 — 420)*
M3	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	95 (73 — 110) *310 (240 — 360)*
M4	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	70 (55 — 85) *230 (190 — 270)*
M5	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	60 (46 — 71) *195 (160 — 230)*
K1	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	195 (180 — 210) *640 (600 — 680)*
K2	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	170 (160 — 180) *560 (530 — 590)*
K3	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	145 (130 — 150) *475 (430 — 490)*
K4	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	140 (130 — 150) *460 (430 — 490)*
K5	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	165 (150 — 180) *540 (500 — 590)*
K6	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	245 (220 — 270) *800 (730 — 880)*
K7	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	210 (190 — 230) *690 (630 — 750)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS532 Copy milling roughing

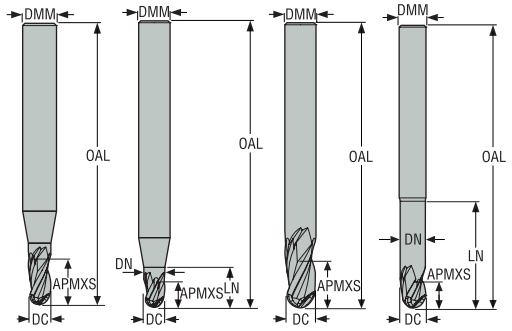
SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.200	0.30	0.0080	0.016	0.024	0.032	0.038	0.046	0.060	0.080	0.095	0.11	0.13	610 (520 — 710)
		0,200	*0,30*	*0,00032*	*0,00065*	*0,00095*	*0,0013*	*0,0015*	*0,0018*	*0,0024*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*2000 (1800 — 2300)*
N2	E	0.200	0.30	0.0080	0.016	0.024	0.032	0.038	0.046	0.060	0.080	0.095	0.11	0.13	395 (330 — 450)
		0,200	*0,30*	*0,00032*	*0,00065*	*0,00095*	*0,0013*	*0,0015*	*0,0018*	*0,0024*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*1300 (1100 — 1400)*
N3	E	0.200	0.30	0.0080	0.016	0.024	0.032	0.038	0.046	0.060	0.080	0.095	0.11	0.13	260 (220 — 300)
		0,200	*0,30*	*0,00032*	*0,00065*	*0,00095*	*0,0013*	*0,0015*	*0,0018*	*0,0024*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*850 (730 — 980)*
N11	E	0.200	0.30	0.0050	0.010	0.016	0.020	0.026	0.032	0.040	0.050	0.060	0.075	0.090	415 (370 — 460)
		0,200	*0,30*	*0,00020*	*0,00040*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*0,0036*	*1350 (1300 — 1500)*
S1	E	0.150	0.10	0.0040	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	60 (52 — 72)
		0,150	*0,10*	*0,00016*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*195 (180 — 230)*
S2	E	0.150	0.10	0.0040	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	50 (42 — 58)
		0,150	*0,10*	*0,00016*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*165 (140 — 190)*
S3	E	0.100	0.10	0.0036	0.0070	0.010	0.014	0.018	0.020	0.028	0.036	0.042	0.055	0.060	32 (22 — 42)
		0,100	*0,10*	*0,00014*	*0,00028*	*0,00040*	*0,00055*	*0,00070*	*0,00080*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0024*	*105 (73 — 130)*
S11	E	0.200	0.20	0.0060	0.012	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.090	0.10	105 (94 — 110)
		0,200	*0,20*	*0,00024*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0036*	*0,0040*	*345 (310 — 360)*
S12	E	0.200	0.20	0.0060	0.012	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.090	0.10	80 (72 — 92)
		0,200	*0,20*	*0,00024*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0036*	*0,0040*	*260 (240 — 300)*
S13	E	0.200	0.20	0.0055	0.011	0.016	0.022	0.026	0.032	0.042	0.055	0.060	0.080	0.090	65 (57 — 72)
		0,200	*0,20*	*0,00022*	*0,00044*	*0,00065*	*0,00085*	*0,0010*	*0,0013*	*0,0017*	*0,0022*	*0,0024*	*0,0032*	*0,0036*	*215 (190 — 230)*
TS1	A	0.200	0.40	0.0075	0.015	0.024	0.030	0.038	0.046	0.065	0.075	0.090	0.12	0.13	610 (570 — 660)
		0,200	*0,40*	*0,00030*	*0,00060*	*0,00095*	*0,0012*	*0,0015*	*0,0018*	*0,0026*	*0,0030*	*0,0036*	*0,0048*	*0,0050*	*2000 (1900 — 2100)*
TP1	A	0.200	0.40	0.0075	0.015	0.024	0.030	0.038	0.046	0.065	0.075	0.090	0.12	0.13	610 (570 — 660)
		0,200	*0,40*	*0,00030*	*0,00060*	*0,00095*	*0,0012*	*0,0015*	*0,0018*	*0,0026*	*0,0030*	*0,0036*	*0,0048*	*0,0050*	*2000 (1900 — 2100)*
GR1	A	0.200	0.40	0.0075	0.015	0.024	0.030	0.038	0.046	0.065	0.075	0.090	0.12	0.13	610 (570 — 660)
		0,200	*0,40*	*0,00030*	*0,00060*	*0,00095*	*0,0012*	*0,0015*	*0,0018*	*0,0026*	*0,0030*	*0,0036*	*0,0048*	*0,0050*	*2000 (1900 — 2100)*

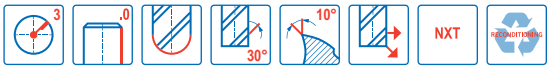
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS533

High performance – Universal – Ball nose – 3 Flutes – Cylindrical





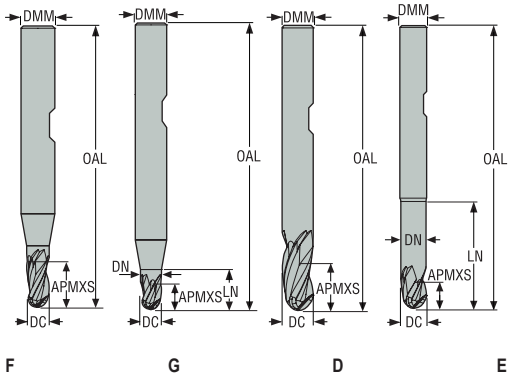
- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS533010F1B.0Z3-NXT	02928284	1	F	1,0	3,0	2,0	38,0	3,0	1,05	0,5	3	■
JS533015F1B.0Z3-NXT	02928286	1	F	1,5	3,0	3,0	38,0	4,6	1,55	0,75	3	■
JS533020F1B.0Z3-NXT	02928287	1	F	2,0	3,0	4,0	38,0	5,6	2,05	1,0	3	■
JS533030D1B.0Z3-NXT	02928289	1	D	3,0	3,0	6,0	38,0	–	–	1,5	3	■
JS533040F1B.0Z3-NXT	02928291	1	F	4,0	6,0	8,0	57,0	10,75	4,05	2,0	3	■
JS533050F1B.0Z3-NXT	02928293	1	F	5,0	6,0	10,0	57,0	13,75	5,05	2,5	3	■
JS533060D1B.0Z3-NXT	02928295	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	■
JS533080D1B.0Z3-NXT	02928297	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	■
JS533100D1B.0Z3-NXT	02928299	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	■
JS533120D1B.0Z3-NXT	02928301	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	■
JS533160D1B.0Z3-NXT	02928303	1	D	16,0	16,0	32,0	110,0	–	–	8,0	3	■
JS533200D1B.0Z3-NXT	02928305	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	■
JS533020G2B.0Z3-NXT	02928288	2	G	2,0	3,0	2,0	38,0	7,0	1,9	1,0	3	■
JS533030E2B.0Z3-NXT	02928290	2	E	3,0	3,0	3,0	38,0	9,0	2,85	1,5	3	■
JS533040G2B.0Z3-NXT	02928292	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	■
JS533050G2B.0Z3-NXT	02928294	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	■
JS533060E2B.0Z3-NXT	02928296	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	■
JS533080E2B.0Z3-NXT	02928298	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	■
JS533100E2B.0Z3-NXT	02928300	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	■
JS533120E2B.0Z3-NXT	02928302	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	■
JS533160E2B.0Z3-NXT	02928304	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	3	■

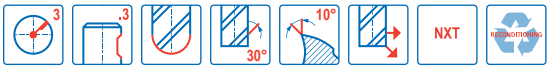
■ Stocked standard.

JS533

High performance – Universal – Ball nose – 3 Flutes – Weldon



- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS533040F1B.3Z3-NXT	02928323	1	F	4,0	6,0	8,0	57,0	10,75	4,05	2,0	3	☐
JS533050F1B.3Z3-NXT	02928325	1	F	5,0	6,0	10,0	57,0	13,75	5,05	2,5	3	☐
JS533060D1B.3Z3-NXT	02928326	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	☐
JS533080D1B.3Z3-NXT	02928328	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	☐
JS533100D1B.3Z3-NXT	02928330	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	☐
JS533120D1B.3Z3-NXT	02928332	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	☐
JS533160D1B.3Z3-NXT	02928334	1	D	16,0	16,0	32,0	109,0	–	–	8,0	3	☐
JS533200D1B.3Z3-NXT	02928336	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	☐
JS533040G2B.3Z3-NXT	02928324	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	☐
JS533050G2B.3Z3-NXT	02928341	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	☐
JS533060E2B.3Z3-NXT	02928327	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	☐
JS533080E2B.3Z3-NXT	02928329	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	☐
JS533100E2B.3Z3-NXT	02928331	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	☐
JS533120E2B.3Z3-NXT	02928333	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	☐
JS533160E2B.3Z3-NXT	02928335	2	E	16,0	16,0	16,0	122,0	70,0	15,2	8,0	3	☐

☐ Weldon available. Delivery time is 3 days.

Cutting data – JS533 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300	0.80	0.0032	0.0065	0.0095	0.013	0.016	0.019	0.026	0.032	0.038	0.048	0.055	200 (180 — 220)
		0,0300	*0,80*	*0,00013*	*0,00026*	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0019*	*0,0022*	*660 (600 — 720)*
P2	M/A/D/E	0.0300	0.80	0.0034	0.0065	0.010	0.013	0.017	0.020	0.026	0.034	0.038	0.048	0.055	195 (170 — 220)
		0,0300	*0,80*	*0,00013*	*0,00026*	*0,00040*	*0,00050*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0015*	*0,0019*	*0,0022*	*640 (560 — 720)*
P3	M/A/D/E	0.0300	0.80	0.0032	0.0060	0.0095	0.013	0.016	0.019	0.025	0.032	0.036	0.046	0.055	165 (150 — 180)
		0,0300	*0,80*	*0,00013*	*0,00024*	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0014*	*0,0018*	*0,0022*	*540 (500 — 590)*
P4	M/A/D/E	0.0300	0.80	0.0030	0.0060	0.0090	0.012	0.015	0.018	0.025	0.030	0.036	0.044	0.050	145 (130 — 160)
		0,0300	*0,80*	*0,00012*	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,0010*	*0,0012*	*0,0014*	*0,0017*	*0,0020*	*475 (430 — 520)*
P5	M/A/D/E	0.0300	0.80	0.0030	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.044	0.050	140 (130 — 160)
		0,0300	*0,80*	*0,00012*	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0020*	*460 (430 — 520)*
P6	M/A/D/E	0.0300	0.80	0.0030	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.034	0.044	0.050	155 (140 — 170)
		0,0300	*0,80*	*0,00012*	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0013*	*0,0017*	*0,0020*	*510 (460 — 550)*
P7	M/A/D/E	0.0300	0.80	0.0030	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.034	0.044	0.050	150 (130 — 160)
		0,0300	*0,80*	*0,00012*	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0013*	*0,0017*	*0,0020*	*490 (430 — 520)*
P8	M/A/D/E	0.0300	0.80	0.0032	0.0060	0.0095	0.013	0.016	0.019	0.025	0.032	0.036	0.046	0.055	140 (120 — 150)
		0,0300	*0,80*	*0,00013*	*0,00024*	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0014*	*0,0018*	*0,0022*	*460 (400 — 490)*
P11	M/A/D/E	0.0300	0.80	0.0044	0.0090	0.013	0.018	0.022	0.026	0.036	0.044	0.050	0.065	0.075	140 (130 — 160)
		0,0300	*0,80*	*0,00017*	*0,00036*	*0,00050*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0020*	*0,0026*	*0,0030*	*460 (430 — 520)*
P12	M/A/D/E	0.0300	0.80	0.0030	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.044	0.050	85 (73 — 97)
		0,0300	*0,80*	*0,00012*	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0020*	*280 (240 — 310)*
M1	E	0.0300	0.80	0.0034	0.0065	0.010	0.013	0.017	0.020	0.026	0.034	0.038	0.048	0.055	125 (99 — 140)
		0,0300	*0,80*	*0,00013*	*0,00026*	*0,00040*	*0,00050*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0015*	*0,0019*	*0,0022*	*410 (330 — 450)*
M2	E	0.0300	0.80	0.0030	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.044	0.050	100 (80 — 120)
		0,0300	*0,80*	*0,00012*	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0020*	*330 (270 — 390)*
M3	E	0.0300	0.80	0.0030	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.044	0.050	70 (50 — 90)
		0,0300	*0,80*	*0,00012*	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0020*	*230 (170 — 290)*
M4	E	0.0300	0.80	0.0026	0.0050	0.0080	0.011	0.013	0.016	0.022	0.026	0.030	0.038	0.044	55 (38 — 67)
		0,0300	*0,80*	*0,00010*	*0,00020*	*0,00032*	*0,00044*	*0,00050*	*0,00065*	*0,00085*	*0,0010*	*0,0012*	*0,0015*	*0,0017*	*180 (130 — 210)*
M5	E	0.0300	0.80	0.0026	0.0050	0.0080	0.011	0.013	0.016	0.022	0.026	0.030	0.038	0.044	44 (32 — 56)
		0,0300	*0,80*	*0,00010*	*0,00020*	*0,00032*	*0,00044*	*0,00050*	*0,00065*	*0,00085*	*0,0010*	*0,0012*	*0,0015*	*0,0017*	*145 (110 — 180)*
K1	E	0.0300	0.80	0.0040	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.046	0.060	0.070	145 (130 — 160)
		0,0300	*0,80*	*0,00016*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0018*	*0,0024*	*0,0028*	*475 (430 — 520)*
K2	E	0.0300	0.80	0.0036	0.0075	0.011	0.015	0.018	0.022	0.030	0.036	0.042	0.055	0.060	125 (110 — 140)
		0,0300	*0,80*	*0,00014*	*0,00030*	*0,00044*	*0,00060*	*0,00070*	*0,00085*	*0,0012*	*0,0014*	*0,0017*	*0,0022*	*0,0024*	*410 (370 — 450)*
K3	E	0.0300	0.80	0.0050	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.075	0.085	105 (91 — 110)
		0,0300	*0,80*	*0,00020*	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*0,0034*	*345 (300 — 360)*
K4	E	0.0300	0.80	0.0050	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.075	0.085	120 (100 — 140)
		0,0300	*0,80*	*0,00020*	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*0,0034*	*395 (330 — 450)*
K5	E	0.0300	0.80	0.0044	0.0090	0.013	0.018	0.022	0.026	0.036	0.044	0.055	0.065	0.075	70 (61 — 84)
		0,0300	*0,80*	*0,00017*	*0,00036*	*0,00050*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0022*	*0,0026*	*0,0030*	*230 (210 — 270)*
K6	E	0.0300	0.80	0.0050	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.075	0.085	105 (89 — 120)
		0,0300	*0,80*	*0,00020*	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*0,0034*	*345 (300 — 390)*
K7	E	0.0300	0.80	0.0044	0.0090	0.013	0.018	0.022	0.026	0.036	0.044	0.055	0.065	0.075	155 (130 — 180)
		0,0300	*0,80*	*0,00017*	*0,00036*	*0,00050*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0022*	*0,0026*	*0,0030*	*510 (430 — 590)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JS533 Copy milling roughing

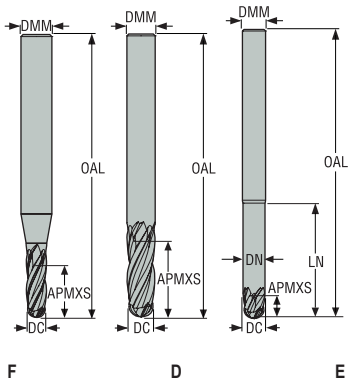
SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	800 (700 — 900) *2625 (2300 — 2900)*
N2	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	510 (450 — 570) *1675 (1500 — 1800)*
N3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	345 (300 — 380) *1125 (990 — 1200)*
N11	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (90 — 110) *330 (300 — 360)*
S2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	80 (73 — 88) *260 (240 — 280)*
S11	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	130 (120 — 140) *425 (400 — 450)*
S12	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (91 — 110) *330 (300 — 360)*
S13	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	80 (70 — 85) *260 (230 — 270)*
TS1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
TP1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
GR1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*

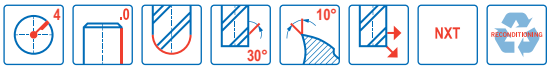
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS534

High performance – Universal – Ball nose – 4 Flutes – Cylindrical





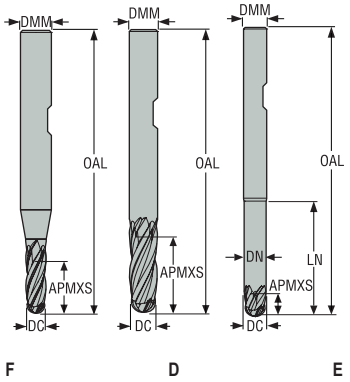
- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS534020F1B.0Z4-NXT	02928366	1	F	2,0	3,0	6,0	38,0	6,7	2,05	1,0	4	■
JS534030D1B.0Z4-NXT	02928367	1	D	3,0	3,0	9,0	38,0	–	–	1,5	4	■
JS534040F1B.0Z4-NXT	02928368	1	F	4,0	6,0	12,0	57,0	14,0	4,05	2,0	4	■
JS534050F1B.0Z4-NXT	02928370	1	F	5,0	6,0	15,0	57,0	17,0	5,05	2,5	4	■
JS534060D1B.0Z4-NXT	02928372	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	■
JS534080D1B.0Z4-NXT	02928375	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	■
JS534100D1B.0Z4-NXT	02928378	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	■
JS534120D1B.0Z4-NXT	02928381	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	■
JS534160D1B.0Z4-NXT	02928384	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	■
JS534200D1B.0Z4-NXT	02928387	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	■
JS534040F2B.0Z4-NXT	02928369	2	F	4,0	6,0	20,0	63,0	22,0	4,05	2,0	4	■
JS534050F2B.0Z4-NXT	02928371	2	F	5,0	6,0	25,0	75,0	27,0	5,05	2,5	4	■
JS534060D2B.0Z4-NXT	02928373	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	■
JS534080D2B.0Z4-NXT	02928376	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	■
JS534100D2B.0Z4-NXT	02928379	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	■
JS534120D2B.0Z4-NXT	02928382	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	■
JS534160D2B.0Z4-NXT	02928385	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	■
JS534060E3B.0Z4-NXT	02928374	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	■
JS534080E3B.0Z4-NXT	02928377	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	■
JS534100E3B.0Z4-NXT	02928380	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	■
JS534120E3B.0Z4-NXT	02928383	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	■
JS534160E3B.0Z4-NXT	02928386	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	■
JS534200E3B.0Z4-NXT	02928388	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	■

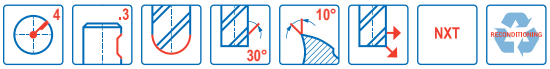
■ Stocked standard.

JS534

High performance – Universal – Ball nose – 4 Flutes – Weldon



- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS534040F1B.3Z4-NXT	02928390	1	F	4,0	6,0	12,0	57,0	14,0	4,05	2,0	4	☐
JS534050F1B.3Z4-NXT	02928392	1	F	5,0	6,0	15,0	57,0	17,0	5,05	2,5	4	☐
JS534060D1B.3Z4-NXT	02928394	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	☐
JS534080D1B.3Z4-NXT	02928397	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	☐
JS534100D1B.3Z4-NXT	02928400	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	☐
JS534120D1B.3Z4-NXT	02928403	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	☐
JS534160D1B.3Z4-NXT	02928406	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	☐
JS534200D1B.3Z4-NXT	02928409	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	☐
JS534040F2B.3Z4-NXT	02928391	2	F	4,0	6,0	20,0	63,0	22,0	4,05	2,0	4	☐
JS534050F2B.3Z4-NXT	02928393	2	F	5,0	6,0	25,0	75,0	27,0	5,05	2,5	4	☐
JS534060D2B.3Z4-NXT	02928395	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	☐
JS534080D2B.3Z4-NXT	02928398	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	☐
JS534100D2B.3Z4-NXT	02928401	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	☐
JS534120D2B.3Z4-NXT	02928404	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	☐
JS534160D2B.3Z4-NXT	02928407	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	☐
JS534060E3B.3Z4-NXT	02928396	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	☐
JS534080E3B.3Z4-NXT	02928399	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	☐
JS534100E3B.3Z4-NXT	02928402	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	☐
JS534120E3B.3Z4-NXT	02928405	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	☐
JS534160E3B.3Z4-NXT	02928408	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	☐
JS534200E3B.3Z4-NXT	02928410	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	☐

☐ Weldon available. Delivery time is 3 days.

Cutting data – JS534 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	345 (310 — 370) *1125 (1100 — 1200)*
P2	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	335 (300 — 360) *1100 (990 — 1100)*
P3	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	290 (260 — 310) *950 (860 — 1000)*
P4	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	255 (230 — 280) *840 (760 — 910)*
P5	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
P6	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	230 (210 — 250) *750 (690 — 820)*
P7	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	220 (200 — 240) *720 (660 — 780)*
P8	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	205 (190 — 220) *670 (630 — 720)*
P11	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	210 (190 — 230) *690 (630 — 750)*
P12	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	125 (120 — 130) *410 (400 — 420)*
M1	E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
M2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (130 — 160) *475 (430 — 520)*
M3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (140 — 180) *510 (460 — 590)*
M4	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	120 (100 — 130) *395 (330 — 420)*
M5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	100 (83 — 110) *330 (280 — 360)*
K1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
K2	E	0.0300 *0,0300*	4.0 *4,0*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	215 (200 — 230) *710 (660 — 750)*
K3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	180 (160 — 190) *590 (530 — 620)*
K4	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	170 (160 — 180) *560 (530 — 590)*
K5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	200 (180 — 220) *660 (600 — 720)*
K6	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	295 (260 — 330) *970 (860 — 1000)*
K7	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	260 (230 — 280) *850 (760 — 910)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JS534 Copy milling roughing

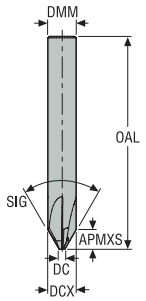
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	1025 (910 — 1100)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*3375 (3000 — 3600)*
N2	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	910 (780 — 1000)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*2975 (2600 — 3200)*
N3	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	600 (520 — 690)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*1975 (1800 — 2200)*
N11	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	500 (440 — 560)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*1650 (1500 — 1800)*
S1	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	110 (88 — 110)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*360 (290 — 360)*
S2	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	90 (71 — 90)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*295 (240 — 290)*
S3	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	85 (63 — 87)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*280 (210 — 280)*
S11	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	185 (150 — 180)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*610 (500 — 590)*
S12	E	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	140 (120 — 140)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*460 (400 — 450)*
S13	E	0.0300	4.0	0.0070	0.010	0.014	0.017	0.020	0.028	0.034	0.042	0.050	0.060	110 (91 — 110)
		0,0300	*4,0*	*0,00028*	*0,00040*	*0,00055*	*0,00065*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0020*	*0,0024*	*360 (300 — 360)*
TS1	A	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	900 (840 — 960)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*2950 (2800 — 3100)*
TP1	A	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	900 (840 — 960)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*2950 (2800 — 3100)*
GR1	A	0.0300	4.0	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	900 (840 — 960)
		0,0300	*4,0*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*2950 (2800 — 3100)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS506

General purpose – Universal – Chamfer – 3-4 Flutes – Cylindrical



N

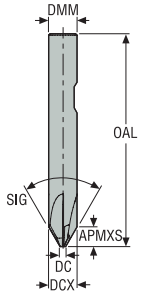
- Tolerances:
- DMM=h5
- SIG= ±0,5°
- Regrind possible if DMM is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm			
JS506030N2CZ3.0-SIRA	02881622	2	N	0,6	3,0	3,0	2,0	50,0	60,0	3	■
JS506040N2CZ3.0-SIRA	02881623	2	N	0,8	4,0	4,0	2,7	50,0	60,0	3	■
JS506060N2CZ4.0-SIRA	02881624	2	N	1,2	6,0	6,0	4,1	57,0	60,0	4	■
JS506080N2CZ4.0-SIRA	02881626	2	N	1,6	8,0	8,0	5,5	63,0	60,0	4	■
JS506100N2CZ4.0-SIRA	02881628	2	N	2,0	10,0	10,0	6,9	72,0	60,0	4	■
JS506120N2CZ4.0-SIRA	02881630	2	N	2,4	12,0	12,0	8,3	83,0	60,0	4	■

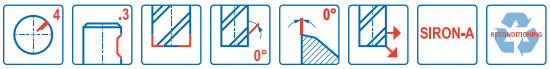
■ Stocked standard.

JS506

General purpose – Universal – Chamfer – 3-4 Flutes – Weldon



- Tolerances:
- DMM=h5
- SIG= ±0,5°
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Weldon
				mm	mm	mm	mm	mm			
JS506060N2CZ4.3-SIRA	02881625	2	N	1,2	6,0	6,0	4,1	57,0	60,0	4	■
JS506080N2CZ4.3-SIRA	02881627	2	N	1,6	8,0	8,0	5,5	63,0	60,0	4	■
JS506100N2CZ4.3-SIRA	02881629	2	N	2,0	10,0	10,0	6,9	72,0	60,0	4	■
JS506120N2CZ4.3-SIRA	02881631	2	N	2,4	12,0	12,0	8,3	83,0	60,0	4	■

■ Stocked standard.

Cutting data – JS506 Chamfering

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	200 (180 — 220) *660 (600 — 720)*
P2	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	195 (180 — 220) *640 (600 — 720)*
P3	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	170 (150 — 190) *560 (500 — 620)*
P4	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	150 (130 — 160) *490 (430 — 520)*
P5	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130 — 160) *460 (430 — 520)*
P6	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P7	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P8	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	140 (130 — 160) *460 (430 — 520)*
P11	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.013 *0,00050*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	85 (75 — 97) *280 (250 — 310)*
M1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	120 (95 — 140) *395 (320 — 450)*
M2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	95 (76 — 110) *310 (250 — 360)*
M3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (43 — 80) *195 (150 — 260)*
M4	E/M/A	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	46 (33 — 60) *150 (110 — 190)*
M5	E/M/A	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	39 (27 — 50) *130 (89 — 160)*
K1	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	200 (180 — 220) *660 (600 — 720)*
K2	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
K3	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (130 — 160) *475 (430 — 520)*
K4	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130 — 150) *460 (430 — 490)*
K5	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.018 *0,00070*	0.024 *0,00095*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	85 (72 — 93) *280 (240 — 300)*
K6	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	125 (110 — 130) *410 (370 — 420)*
K7	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.018 *0,00070*	0.024 *0,00095*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	105 (92 — 120) *345 (310 — 390)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JS506 Chamfering

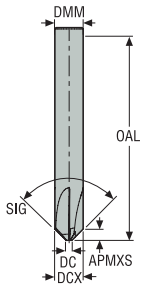
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500 — 1700)*
N2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	305 (280 — 330) *1000 (920 — 1000)*
N3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	205 (190 — 220) *670 (630 — 720)*
N11	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	270 (250 — 290) *890 (830 — 950)*
S1	E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	41 (14 — 68) *135 (46 — 220)*
S2	E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	33 (12 — 55) *110 (40 — 180)*
S3	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	28 (9.5 — 47) *90 (32 — 150)*
S11	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	95 (68 — 110) *310 (230 — 360)*
S12	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	70 (53 — 90) *230 (180 — 290)*
S13	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	55 (41 — 69) *180 (140 — 220)*
H5	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	65 (45 — 83) *215 (150 — 270)*
H8	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	60 (44 — 81) *195 (150 — 260)*
H11	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	80 (57 — 100) *260 (190 — 320)*
H12	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	70 (51 — 94) *230 (170 — 300)*
H21	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	60 (44 — 81) *195 (150 — 260)*
TS1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500 — 1700)*
TP1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500 — 1700)*
GR1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500 — 1700)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS509

General purpose – Universal – Chamfer – 3-4 Flutes – Cylindrical



N

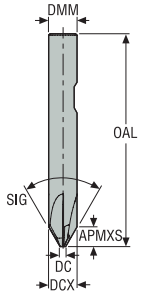
- Tolerances:
- DMM=h5
- SIG= ±0,5°
- Regrind possible if DMM is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm			
JS509030N2CZ3.0-SIRA	02881634	2	N	0,6	3,0	3,0	1,2	50,0	90,0	3	■
JS509040N2CZ3.0-SIRA	02881635	2	N	0,8	4,0	4,0	1,6	50,0	90,0	3	■
JS509060N2CZ4.0-SIRA	02881636	2	N	1,2	6,0	6,0	2,4	57,0	90,0	4	■
JS509080N2CZ4.0-SIRA	02881638	2	N	1,6	8,0	8,0	3,2	63,0	90,0	4	■
JS509100N2CZ4.0-SIRA	02881640	2	N	2,0	10,0	10,0	4,0	72,0	90,0	4	■
JS509120N2CZ4.0-SIRA	02881642	2	N	2,4	12,0	12,0	4,8	83,0	90,0	4	■

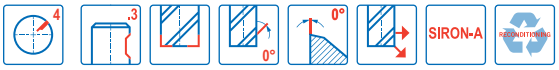
■ Stocked standard.

JS509

General purpose – Universal – Chamfer – 3-4 Flutes – Weldon



- Tolerances:
- DMM=h5
- SIG= ±0,5°
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Weldon
				mm	mm	mm	mm	mm			
JS509060N2CZ4.3-SIRA	02881637	2	N	1,2	6,0	6,0	2,4	57,0	90,0	4	■
JS509080N2CZ4.3-SIRA	02881639	2	N	1,6	8,0	8,0	3,2	63,0	90,0	4	■
JS509100N2CZ4.3-SIRA	02881641	2	N	2,0	10,0	10,0	4,0	72,0	90,0	4	■
JS509120N2CZ4.3-SIRA	02881643	2	N	2,4	12,0	12,0	4,8	83,0	90,0	4	■

■ Stocked standard.

Cutting data – JS509 Chamfering

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	380 (340 — 430) *1250 (1200 — 1400)*
P2	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	370 (330 — 420) *1225 (1100 — 1300)*
P3	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	320 (280 — 360) *1050 (920 — 1100)*
P4	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	280 (250 — 310) *920 (830 — 1000)*
P5	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	270 (240 — 300) *890 (790 — 980)*
P6	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	305 (270 — 340) *1000 (890 — 1100)*
P7	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	285 (250 — 320) *940 (830 — 1000)*
P8	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	270 (240 — 300) *890 (790 — 980)*
P11	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	280 (250 — 310) *920 (830 — 1000)*
P12	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	165 (150 — 180) *540 (500 — 590)*
M1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	115 (81 — 150) *375 (270 — 490)*
M4	E/M/A	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	90 (61 — 110) *295 (210 — 360)*
M5	E/M/A	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	75 (51 — 95) *245 (170 — 310)*
K1	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	375 (330 — 420) *1225 (1100 — 1300)*
K2	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	325 (290 — 360) *1075 (960 — 1100)*
K3	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	275 (240 — 310) *900 (790 — 1000)*
K4	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	265 (230 — 290) *870 (760 — 950)*
K5	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	155 (140 — 170) *510 (460 — 550)*
K6	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	230 (210 — 260) *750 (690 — 850)*
K7	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	200 (180 — 220) *660 (600 — 720)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JS509 Chamfering

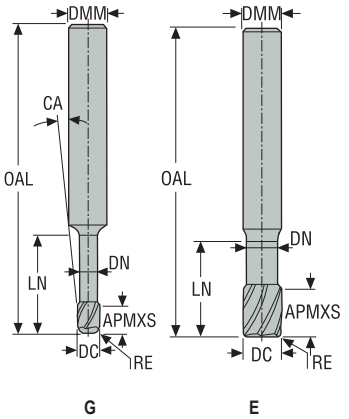
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
N2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	580 (530 — 630) *1900 (1800 — 2000)*
N3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	385 (350 — 420) *1275 (1200 — 1300)*
N11	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	510 (470 — 560) *1675 (1600 — 1800)*
S1	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	70 (24 — 110) *230 (79 — 360)*
S2	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	55 (19 — 94) *180 (63 — 300)*
S3	E	0.100 *0,100*	0.55 *0,55*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	49 (17 — 80) *160 (56 — 260)*
S11	E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	175 (130 — 220) *570 (430 — 720)*
S12	E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	135 (99 — 170) *445 (330 — 550)*
S13	E	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	105 (77 — 130) *345 (260 — 420)*
H5	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	115 (80 — 140) *375 (270 — 450)*
H8	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (78 — 140) *360 (260 — 450)*
H11	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (110 — 190) *475 (370 — 620)*
H12	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (91 — 170) *425 (300 — 550)*
H21	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (78 — 140) *360 (260 — 450)*
TS1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
TP1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
GR1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*

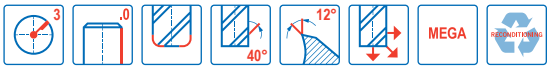
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH910

High speed – Universal – Square – 3 Flutes – Cylindrical – Corner radius





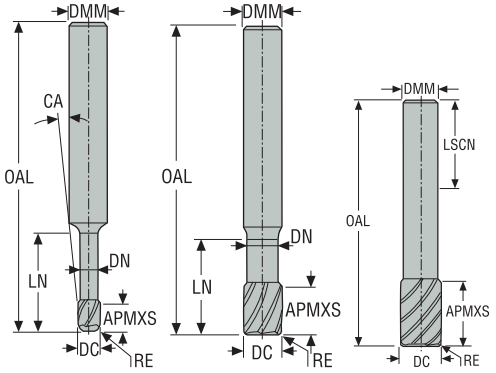
- Tolerances:
- DMM= h5
- DC= -0,02/-0,03 mm
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
910020R020-MEGA	00020058	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	3,5	3	■
910025R020-MEGA	00020065	2	G	2,5	3,0	4,0	40,0	6,0	2,4	0,2	2,0	3	■
910030R010-MEGA	00020073	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,1	–	3	■
910030R020-MEGA	00020142	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,2	–	3	■
910035R020-MEGA	00020144	2	G	3,5	6,0	5,0	50,0	9,0	3,2	0,2	6,0	3	■
910040R020-MEGA	00020151	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,2	5,0	3	■
910040R030-MEGA	00020152	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,3	5,0	3	■
910040R050-MEGA	00020155	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,5	5,0	3	■
910050R020-MEGA	00020159	2	G	5,0	6,0	6,0	50,0	11,0	4,6	0,2	2,5	3	■
910060R020-MEGA	00020160	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,2	–	3	■
910060R030-MEGA	00020161	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,3	–	3	■
910060R050-MEGA	00020162	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,5	–	3	■
910080R020-MEGA	00020163	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,2	–	3	■
910080R050-MEGA	00020164	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,5	–	3	■
910100R020-MEGA	00020165	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,2	–	3	■
910100R050-MEGA	00020166	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,5	–	3	■
910100R100-MEGA	00020167	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	3	■
910120R050-MEGA	00020168	2	E	12,0	12,0	15,0	80,0	30,0	11,4	0,5	–	3	■
910120R100-MEGA	00020169	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,0	–	3	■

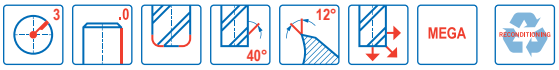
■ Stocked standard.

JH910

High speed – Universal – Square – 3 Flutes – Cylindrical – Corner radius



- Tolerances:
- DMM= h5
- DC= -0,02/-0,03 mm
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	LSCN	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		mm		
910L020-MEGA	00022002	3	G	2,0	3,0	3,0	60,0	10,0	1,9	0,2	2,5	28,0	3	■
910L030-MEGA	00022003	3	E	3,0	3,0	4,0	60,0	14,0	2,8	0,2	–	28,0	3	■
910L040-MEGA	00022004	3	G	4,0	6,0	5,0	65,0	18,0	3,7	0,2	3,0	36,0	3	■
910L050-MEGA	00022005	3	G	5,0	6,0	6,0	65,0	22,0	4,6	0,2	1,5	36,0	3	■
910L060-MEGA	00022006	3	E	6,0	6,0	7,0	80,0	26,0	5,6	0,3	–	36,0	3	■
910L080-MEGA	00022007	3	E	8,0	8,0	9,0	85,0	36,0	7,4	0,5	–	36,0	3	■
910L100-MEGA	00022009	3	E	10,0	10,0	12,0	100,0	45,0	9,4	0,5	–	40,0	3	■
910L120-MEGA	00022011	3	E	12,0	12,0	15,0	125,0	54,0	11,4	0,5	–	45,0	3	■
910L160-MEGA	00022013	3	E	16,0	16,0	18,0	125,0	65,0	15,4	1,0	–	48,0	3	■
910RS070-MEGA	00021772	4	P	7,0	6,0	8,0	100,0	–	–	0,3	–	36,0	3	■
910RS090-MEGA	00021781	4	P	9,0	8,0	11,0	100,0	–	–	0,5	–	36,0	3	■
910RS110-MEGA	00021782	4	P	11,0	10,0	13,0	125,0	–	–	0,5	–	40,0	3	■
910RS130-MEGA	00021784	4	P	13,0	12,0	16,0	150,0	–	–	0,6	–	45,0	3	■
910RS170-MEGA	00021800	4	P	17,0	16,0	20,0	150,0	–	–	0,6	–	48,0	3	■

■ Stocked standard.

Cutting data – JH910 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z														v_c
				2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	455 (410 — 500)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1500 (1400 — 1600)*
P2	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	445 (400 — 490)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1450 (1400 — 1600)*
P3	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	385 (350 — 420)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1275 (1200 — 1300)*
P4	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	335 (300 — 370)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1100 (990 — 1200)*
P5	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	320 (290 — 350)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1050 (960 — 1100)*
P6	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	360 (330 — 400)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1175 (1100 — 1300)*
P7	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	340 (310 — 370)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1125 (1100 — 1200)*
P8	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	320 (290 — 350)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1050 (960 — 1100)*
P11	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	330 (300 — 360)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1075 (990 — 1100)*
P12	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	195 (180 — 210)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*640 (600 — 680)*
M1	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	200 (180 — 220)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*660 (600 — 720)*
M2	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	160 (150 — 170)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*520 (500 — 550)*
M3	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	110 (91 — 120)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*360 (300 — 390)*
M4	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	80 (68 — 94)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*260 (230 — 300)*
M5	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	70 (57 — 78)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*230 (190 — 250)*
K1	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	315 (270 — 350)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1025 (890 — 1100)*
K2	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	270 (240 — 310)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*890 (790 — 1000)*
K3	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	230 (200 — 260)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*750 (660 — 850)*
K4	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	220 (190 — 250)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*720 (630 — 820)*
K5	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	280 (240 — 320)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*920 (790 — 1000)*
K6	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	415 (350 — 480)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1350 (1200 — 1500)*
K7	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	355 (300 — 410)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1175 (990 — 1300)*
S1	E/M/A	0.0300	0.70	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	115 (93 — 130)
		0,0300	*0,70*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*375 (310 — 420)*
S2	E/M/A	0.0300	0.70	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	95 (75 — 110)
		0,0300	*0,70*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*310 (250 — 360)*
S3	E/M/A	0.0200	0.50	0.016	0.024	0.032	0.040	0.048	0.055	0.065	0.070	0.080	0.090	0.095	0.10	0.13	0.14	50 (40 — 59)
		0,0200	*0,50*	*0,00065*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0022*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*0,0050*	*0,0055*	*165 (140 — 190)*
S11	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	175 (160 — 190)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*570 (530 — 620)*
S12	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	135 (120 — 150)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*445 (400 — 490)*
S13	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	105 (90 — 110)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*345 (300 — 360)*
TP1	A	0.150	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.15	0.15	205 (180 — 240)
		0,150	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0060*	*0,0060*	*670 (600 — 780)*
GR1	A	0.500	1.0	0.024	0.036	0.048	0.060	0.070	0.085	0.095	0.11	0.12	0.13	0.14	0.15	0.18	0.18	610 (510 — 710)
		0,500	*1,0*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0034*	*0,0038*	*0,0044*	*0,0048*	*0,0050*	*0,0055*	*0,0060*	*0,0070*	*0,0070*	*2000 (1700 — 2300)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JH910 Slot milling

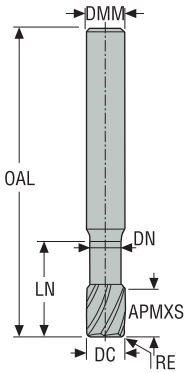
SMG		a_p/DC	f_z														v_c
			2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	255 (230 — 280)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*840 (760 — 910)*
P2	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	250 (230 — 270)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*820 (760 — 880)*
P3	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	215 (200 — 230)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*710 (660 — 750)*
P4	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	190 (170 — 200)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*620 (560 — 650)*
P5	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	180 (170 — 190)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*590 (560 — 620)*
P6	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	200 (180 — 220)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*660 (600 — 720)*
P7	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	190 (170 — 210)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*620 (560 — 680)*
P8	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	180 (170 — 190)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*590 (560 — 620)*
P11	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	195 (180 — 210)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*640 (600 — 680)*
P12	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	115 (110 — 120)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*375 (370 — 390)*
M1	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	120 (110 — 130)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*395 (370 — 420)*
M2	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	95 (86 — 100)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*310 (290 — 320)*
M3	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	60 (51 — 70)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*195 (170 — 220)*
M4	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	45 (38 — 52)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*150 (130 — 170)*
M5	M/E/A	0.10	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	38 (32 — 43)
		0,10	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*125 (110 — 140)*
K1	A/E	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	175 (160 — 200)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*570 (530 — 650)*
K2	A/E	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	150 (140 — 170)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*490 (460 — 550)*
K3	A/E	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	130 (120 — 140)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*425 (400 — 450)*
K4	A/E	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	125 (110 — 140)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*410 (370 — 450)*
K5	A/E	0.16	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	150 (130 — 170)
		0,16	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*490 (430 — 550)*
K6	A/E	0.16	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	220 (190 — 250)
		0,16	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*720 (630 — 820)*
K7	A/E	0.16	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	190 (170 — 220)
		0,16	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*620 (560 — 720)*
S1	E/M/A	0.15	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	60 (50 — 74)
		0,15	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*195 (170 — 240)*
S2	E/M/A	0.15	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	50 (41 — 60)
		0,15	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*165 (140 — 190)*
S3	E/M/A	0.080	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	25 (21 — 30)
		0,080	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*80 (69 — 98)*
S11	E/M/A	0.24	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	100 (85 — 110)
		0,24	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*330 (280 — 360)*
S12	E/M/A	0.24	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	75 (65 — 84)
		0,24	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*245 (220 — 270)*
S13	E/M/A	0.24	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	60 (51 — 65)
		0,24	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*0,0032*	*0,0034*	*195 (170 — 210)*
TP1	A	0.24	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.095	0.10	150 (130 — 170)
		0,24	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0038*	*0,0040*	*490 (430 — 550)*
GR1	A	0.36	0.014	0.022	0.028	0.036	0.042	0.050	0.055	0.065	0.070	0.075	0.085	0.090	0.11	0.12	600 (510 — 700)
		0,36	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0020*	*0,0022*	*0,0026*	*0,0028*	*0,0030*	*0,0034*	*0,0036*	*0,0044*	*0,0048*	*1975 (1700 — 2200)*

For cutting data recalculations, see pages 573 - 580

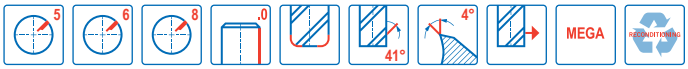
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

JH930

High speed – Universal – Square – 5-8 Flutes – Cylindrical – Corner radius



E



- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	■

■ Stocked standard.

Seco

Cutting data – JH930 Side milling

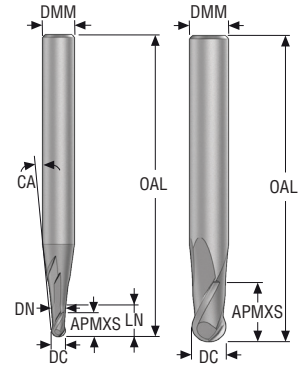
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300 — 1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200 — 1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100 — 1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920 — 1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990 — 1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920 — 1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890 — 1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920 — 1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530 — 720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760 — 1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660 — 1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62 — 100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110 — 160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110 — 140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81 — 110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860 — 1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730 — 1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130 — 180) *510 (430 — 590)*

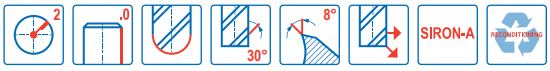
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHB970

High speed – Universal – Ball nose – 2 Flutes – Cylindrical





- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm			
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	2,5	2	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	–	2	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	–	2	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	–	2	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	–	2	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	8,0	2	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	7,5	2	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	5,5	2	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	4,5	2	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	3,0	2	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,0	2	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	2,5	2	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	–	2	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	–	2	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	–	2	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	–	2	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	8,0	2	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	5,5	2	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	3,0	2	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	2,5	2	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	–	2	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	–	2	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	–	2	■

■ Stocked standard.

Cutting data – JHB970 Copy milling roughing

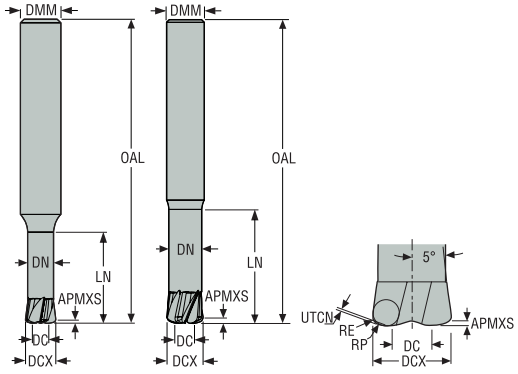
SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200	1.0	0.011	0.014	0.016	0.019	0.022	0.028	0.032	0.044	0.055	0.065	0.080	210 (190 — 230)
		0,200	*1,0*	*0,00044*	*0,00055*	*0,00065*	*0,00075*	*0,00085*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0026*	*0,0032*	*690 (630 — 750)*
P2	M	0.200	1.0	0.011	0.014	0.017	0.019	0.022	0.028	0.034	0.044	0.055	0.065	0.080	205 (180 — 230)
		0,200	*1,0*	*0,00044*	*0,00055*	*0,00065*	*0,00075*	*0,00085*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0026*	*0,0032*	*670 (600 — 750)*
P3	M	0.200	1.0	0.010	0.013	0.016	0.018	0.020	0.026	0.032	0.042	0.050	0.060	0.075	180 (160 — 200)
		0,200	*1,0*	*0,00040*	*0,00050*	*0,00065*	*0,00070*	*0,00080*	*0,0010*	*0,0013*	*0,0017*	*0,0020*	*0,0024*	*0,0030*	*590 (530 — 650)*
P4	M	0.200	1.0	0.010	0.013	0.015	0.018	0.020	0.026	0.030	0.040	0.050	0.060	0.075	155 (140 — 170)
		0,200	*1,0*	*0,00040*	*0,00050*	*0,00060*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*510 (460 — 550)*
P5	M	0.200	1.0	0.010	0.012	0.015	0.018	0.020	0.025	0.030	0.040	0.050	0.060	0.075	150 (140 — 170)
		0,200	*1,0*	*0,00040*	*0,00048*	*0,00060*	*0,00065*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*490 (460 — 550)*
P6	M	0.200	1.0	0.010	0.012	0.015	0.017	0.020	0.025	0.030	0.040	0.050	0.060	0.075	170 (150 — 190)
		0,200	*1,0*	*0,00040*	*0,00048*	*0,00060*	*0,00065*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*560 (500 — 620)*
P7	M	0.200	1.0	0.010	0.012	0.015	0.017	0.020	0.025	0.030	0.040	0.050	0.060	0.075	160 (140 — 180)
		0,200	*1,0*	*0,00040*	*0,00048*	*0,00060*	*0,00065*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*520 (460 — 590)*
P8	M	0.200	1.0	0.010	0.013	0.016	0.018	0.020	0.026	0.032	0.042	0.050	0.060	0.075	150 (140 — 170)
		0,200	*1,0*	*0,00040*	*0,00050*	*0,00065*	*0,00070*	*0,00080*	*0,0010*	*0,0013*	*0,0017*	*0,0020*	*0,0024*	*0,0030*	*490 (460 — 550)*
P11	M	0.200	1.0	0.010	0.012	0.015	0.017	0.020	0.025	0.030	0.040	0.050	0.060	0.075	75 (67 — 86)
		0,200	*1,0*	*0,00040*	*0,00048*	*0,00060*	*0,00065*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*245 (220 — 280)*
P12	M	0.200	1.0	0.0070	0.0085	0.010	0.012	0.014	0.017	0.020	0.028	0.034	0.040	0.050	48 (42 — 53)
		0,200	*1,0*	*0,00028*	*0,00034*	*0,00040*	*0,00048*	*0,00055*	*0,00065*	*0,00080*	*0,0011*	*0,0013*	*0,0016*	*0,0020*	*155 (140 — 170)*
M1	E	0.200	1.0	0.0090	0.011	0.013	0.015	0.018	0.022	0.026	0.036	0.044	0.050	0.065	90 (80 — 100)
		0,200	*1,0*	*0,00036*	*0,00044*	*0,00050*	*0,00060*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0020*	*0,0026*	*295 (270 — 320)*
M2	E	0.200	1.0	0.0080	0.010	0.012	0.014	0.016	0.020	0.024	0.032	0.040	0.048	0.060	75 (65 — 85)
		0,200	*1,0*	*0,00032*	*0,00040*	*0,00048*	*0,00055*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*245 (220 — 270)*
M3	E	0.150	1.0	0.0060	0.0075	0.0090	0.010	0.012	0.015	0.018	0.024	0.030	0.036	0.044	65 (55 — 75)
		0,150	*1,0*	*0,00024*	*0,00030*	*0,00036*	*0,00040*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*215 (190 — 240)*
M4	E	0.150	1.0	0.0050	0.0065	0.0080	0.0090	0.010	0.013	0.016	0.020	0.026	0.032	0.038	49 (42 — 56)
		0,150	*1,0*	*0,00020*	*0,00026*	*0,00032*	*0,00036*	*0,00040*	*0,00050*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0015*	*160 (140 — 180)*
M5	E	0.150	1.0	0.0050	0.0065	0.0080	0.0090	0.010	0.013	0.016	0.020	0.026	0.032	0.038	41 (35 — 47)
		0,150	*1,0*	*0,00020*	*0,00026*	*0,00032*	*0,00036*	*0,00040*	*0,00050*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0015*	*135 (120 — 150)*
S1	E	0.100	0.80	0.0060	0.0075	0.0090	0.010	0.012	0.015	0.018	0.024	0.030	0.036	0.044	50 (40 — 59)
		0,100	*0,80*	*0,00024*	*0,00030*	*0,00036*	*0,00040*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*165 (140 — 190)*
S2	E	0.100	0.80	0.0060	0.0075	0.0090	0.010	0.012	0.015	0.018	0.024	0.030	0.036	0.044	40 (33 — 48)
		0,100	*0,80*	*0,00024*	*0,00030*	*0,00036*	*0,00040*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*130 (110 — 150)*
S3	E	0.100	0.60	0.0040	0.0050	0.0060	0.0070	0.0080	0.010	0.012	0.016	0.020	0.024	0.028	30 (20 — 39)
		0,100	*0,60*	*0,00016*	*0,00020*	*0,00024*	*0,00028*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0011*	*100 (66 — 120)*
S11	E	0.200	1.0	0.010	0.012	0.015	0.018	0.020	0.025	0.030	0.040	0.050	0.060	0.075	90 (79 — 100)
		0,200	*1,0*	*0,00040*	*0,00048*	*0,00060*	*0,00065*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*295 (260 — 320)*
S12	E	0.200	1.0	0.010	0.012	0.015	0.018	0.020	0.025	0.030	0.040	0.050	0.060	0.075	70 (61 — 80)
		0,200	*1,0*	*0,00040*	*0,00048*	*0,00060*	*0,00065*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*230 (210 — 260)*
S13	E	0.200	1.0	0.0085	0.011	0.013	0.015	0.017	0.022	0.026	0.034	0.044	0.050	0.065	55 (48 — 63)
		0,200	*1,0*	*0,00034*	*0,00044*	*0,00050*	*0,00060*	*0,00065*	*0,00085*	*0,0010*	*0,0013*	*0,0017*	*0,0020*	*0,0026*	*180 (160 — 200)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHF980

High feed – Universal – 2-5 Flutes – Cylindrical – Corner radius



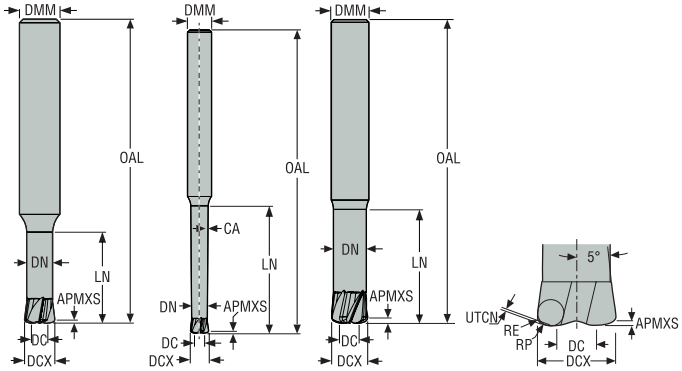
- Tolerances:
- DMM= h5
- DC= -0,02/-0,05 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm			
980K080Z3-MEGA	02587115	1	E	8,0	4,0	8,0	0,4	70,0	12,0	3,0	0,6	0,935	0,198	–	3	■
JHF980080E1H.0Z5-MEGA	03003384	1	E	8,0	4,0	8,0	0,4	70,0	12,0	7,0	0,6	0,935	0,198	–	5	■
980K100Z3-MEGA	02587117	1	E	10,0	5,0	10,0	0,45	80,0	15,0	3,8	0,8	1,176	0,232	–	3	■
JHF980100E1H.0Z5-MEGA	03003385	1	E	10,0	5,0	10,0	0,45	80,0	15,0	8,8	0,8	1,176	0,232	–	5	■
980K120Z3-MEGA	02587118	1	E	12,0	6,0	12,0	0,5	80,0	18,0	4,6	1,0	1,417	0,265	–	3	■
JHF980120E1H.0Z5-MEGA	03003386	1	E	12,0	6,0	12,0	0,5	80,0	18,0	10,6	1,0	1,417	0,265	–	5	■
980010-MEGA	02587111	2	G	1,0	0,5	6,0	0,07	40,0	3,0	0,7	0,07	0,127	0,028	19,5	2	■
980015-MEGA	02511199	2	G	1,5	0,75	6,0	0,1	40,0	4,5	1,2	0,1	0,183	0,043	14,0	2	■
980020-MEGA	02511221	2	G	2,0	1,0	6,0	0,15	40,0	6,0	1,7	0,15	0,269	0,055	11,0	2	■
980030-MEGA	02511224	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,0	2	■
JHF980030G2H.0Z4-MEGA	03003387	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,12	4	■
980040-MEGA	02511229	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	2	■
JHF980040G2H.0Z4-MEGA	03003388	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	4	■
980050-MEGA	02511233	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	2,0	2	■
JHF980050G2H.0Z4-MEGA	03003389	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	1,77	4	■
980060-MEGA	02511314	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	3,0	2	■
JHF980060G2H.0Z4-MEGA	03003390	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	2,86	4	■
980080-MEGA	02511322	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	2	■
JHF980080E2H.0Z5-MEGA	03003391	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	5	■
980100-MEGA	02511341	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	2	■
980100Z3-MEGA	02511342	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	3	■
JHF980100E2H.0Z5-MEGA	03003392	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	5	■
980120-MEGA	02511346	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	2	■
980120Z3-MEGA	02511347	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	3	■
JHF980120E2H.0Z5-MEGA	03003393	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	5	■

■ Stocked standard.
*UTCN=uncut-thickness

JHF980

High feed – Universal – 2-5 Flutes – Cylindrical – Corner radius



- Tolerances:
- DMM= h5
- DC= -0,02/-0,05 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	NA	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm		mm		
980ML010-MEGA	02587113	3	G	1,0	0,5	6,0	0,07	40,0	5,0	0,7	0,07	0,127	0,028	15,5	0,0	2	■
980ML015-MEGA	02511219	3	G	1,5	0,75	6,0	0,1	40,0	7,5	1,2	0,1	0,183	0,043	10,5	0,0	2	■
980ML020-MEGA	02511222	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,0	0,0	2	■
JHF980020G3H.0Z4-MEGA	03003394	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,46	0,0	4	■
980ML030-MEGA	02511225	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	5,0	0,0	2	■
JHF980030G3H.0Z4-MEGA	03003395	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	4,79	0,0	4	■
980ML040-MEGA	02511231	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,5	0,0	2	■
JHF980040G3H.0Z4-MEGA	03003396	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,59	0,0	4	■
980ML050-MEGA	02511234	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,5	0,0	2	■
JHF980050G3H.0Z4-MEGA	03003397	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,12	0,0	4	■
980ML060-MEGA	02511315	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	2,0	0,0	2	■
JHF980060G3H.0Z4-MEGA	03003398	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	1,8	0,0	4	■
980ML080-MEGA	02511338	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	0,0	2	■
JHF980080E3H.0Z5-MEGA	03003399	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	0,0	5	■
980ML100-MEGA	02511344	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	0,0	2	■
JHF980100E3H.0Z5-MEGA	03003400	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	0,0	5	■
980ML120-MEGA	02511348	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	0,0	2	■
JHF980120E3H.0Z5-MEGA	03003401	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	0,0	5	■
980TL010-MEGA	02587114	4	J	1,0	0,5	6,0	0,07	40,0	7,0	0,7	0,07	0,127	0,028	13,0	0,5	2	■
980TL015-MEGA	02511220	4	J	1,5	0,75	6,0	0,1	40,0	10,5	1,2	0,1	0,183	0,043	8,5	0,5	2	■
980TL020-MEGA	02511223	4	J	2,0	1,0	6,0	0,15	50,0	14,0	1,7	0,15	0,269	0,055	6,5	0,5	2	■
980TL030-MEGA	02511226	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,5	0,5	2	■
JHF980030J4H.0Z4-MEGA	03003402	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,63	0,5	4	■
980TL040-MEGA	02511232	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	2,0	0,5	2	■
JHF980040J4H.0Z4-MEGA	03003403	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	1,93	0,5	4	■
980TL050-MEGA	02511240	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	1,0	0,5	2	■
JHF980050J4H.0Z4-MEGA	03003404	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	0,82	0,5	4	■
980TL060-MEGA	02511321	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,5	0,5	2	■
JHF980060J4H.0Z4-MEGA	03003405	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,33	0,5	4	■
980TL080-MEGA	02511340	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	0,5	2	■
JHF980080E4H.0Z5-MEGA	03003406	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	0,0	5	■
980TL100-MEGA	02511345	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	0,5	2	■
JHF980100E4H.0Z5-MEGA	03003407	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	0,0	5	■
980TL120-MEGA	02511349	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	0,5	2	■
JHF980120E4H.0Z5-MEGA	03003408	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	0,0	5	■

■ Stocked standard. *UTCN=uncut-thickness

Cutting data – JHF980 Side milling

SMG		a_e/DCX	a_p/DCX	f_z										v_c
				1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	385 (350 — 430) *1275 (1200 — 1400)*
P2	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	375 (340 — 410) *1225 (1200 — 1300)*
P3	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	325 (290 — 360) *1075 (960 — 1100)*
P4	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	285 (260 — 310) *940 (860 — 1000)*
P5	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	275 (250 — 300) *900 (830 — 980)*
P6	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	215 (190 — 240) *710 (630 — 780)*
P7	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	205 (180 — 230) *670 (600 — 750)*
P8	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	190 (170 — 210) *620 (560 — 680)*
P11	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	195 (170 — 220) *640 (560 — 720)*
P12	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	120 (110 — 130) *395 (370 — 420)*
M1	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
M4	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	70 (61 — 83) *230 (210 — 270)*
K1	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	195 (170 — 220) *640 (560 — 720)*
K3	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	165 (150 — 180) *540 (500 — 590)*
K4	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	155 (140 — 170) *510 (460 — 550)*
K5	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	165 (140 — 190) *540 (460 — 620)*
K6	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	245 (200 — 290) *800 (660 — 950)*
K7	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	210 (170 — 250) *690 (560 — 820)*
S1	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	60 (50 — 74) *195 (170 — 240)*
S2	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	50 (41 — 60) *165 (140 — 190)*
S3	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	37 (25 — 49) *120 (83 — 160)*
S11	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	175 (160 — 190) *570 (530 — 620)*
S12	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	135 (120 — 150) *445 (400 — 490)*
S13	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	105 (90 — 110) *345 (300 — 360)*
H5	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H8	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H21	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H31	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	90 (74 — 100) *295 (250 — 320)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JHF980 Slot milling

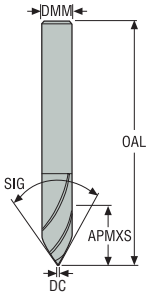
SMG		a_p/DCX	f_z										v_c
			1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	340 (310 — 370) *1125 (1100 — 1200)*
P2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	330 (300 — 360) *1075 (990 — 1100)*
P3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	285 (260 — 310) *940 (860 — 1000)*
P4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	250 (230 — 270) *820 (760 — 880)*
P5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	165 (150 — 180) *540 (500 — 590)*
P11	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	105 (90 — 110) *345 (300 — 360)*
M1	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	65 (53 — 72) *215 (180 — 230)*
K1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	130 (120 — 140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	135 (110 — 150) *445 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	195 (160 — 230) *640 (530 — 750)*
K7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	50 (42 — 62) *165 (140 — 200)*
S2	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	42 (34 — 50) *140 (120 — 160)*
S3	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	31 (21 — 41) *100 (69 — 130)*
S11	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	155 (140 — 170) *510 (460 — 550)*
S12	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	120 (110 — 130) *395 (370 — 420)*
S13	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	95 (82 — 100) *310 (270 — 320)*
H5	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H8	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H21	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H31	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (65 — 88) *245 (220 — 280)*

For cutting data recalculations, see pages 573 - 580

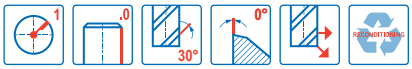
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

J29

General purpose – Universal – Engraving – 1 Flute – Cylindrical



D



- Tolerances:
- DMM=h5
- Regrind possible if DMM is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	SIG°	PCEDC	Cylindrical
				mm	mm	mm	mm			
29030	00029373	2	D	0,2	3,0	2,6	40,0	60,0	1	■
29040	00029381	2	D	0,2	4,0	3,5	50,0	60,0	1	■
29060	00029396	2	D	0,2	6,0	5,2	50,0	60,0	1	■

■ Stocked standard.

Cutting data – J29 Slot milling

SMG		a_p/DC	f_z			v_c
			3	4	6	
P1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	42 (32 — 63) *140 (110 — 200)*
P2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.30 *0,012*	41 (32 — 61) *135 (110 — 200)*
P3	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	36 (28 — 54) *120 (92 — 170)*
P4	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 47) *100 (79 — 150)*
P5	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
P6	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	34 (26 — 51) *110 (86 — 160)*
P7	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	32 (25 — 48) *105 (83 — 150)*
P8	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	30 (23 — 45) *100 (76 — 140)*
P11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 46) *100 (79 — 150)*
P12	E	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.18 *0,0070*	19 (15 — 29) *60 (50 — 95)*
M1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
M2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
M3	E	0.50 *0,50*	0.18 *0,0070*	0.19 *0,0075*	0.22 *0,0085*	24 (18 — 35) *80 (60 — 110)*
M4	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	18 (14 — 27) *60 (46 — 88)*
M5	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	15 (12 — 22) *49 (40 — 72)*
K1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
K2	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	26 (21 — 40) *85 (69 — 130)*
K3	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	22 (17 — 33) *70 (56 — 100)*
K4	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	21 (17 — 32) *70 (56 — 100)*
K5	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	13 (9.8 — 19) *43 (33 — 62)*
K6	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	19 (15 — 28) *60 (50 — 91)*
K7	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	16 (13 — 25) *50 (43 — 82)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

Cutting data – J29 Slot milling

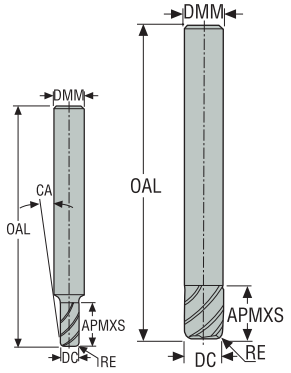
SMG		a_p/DC	f_z			v_c
			3	4	6	
N1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
N2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	19 (15 — 29) *60 (50 — 95)*
N3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	13 (9.8 — 19) *43 (33 — 62)*
N11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	17 (14 — 26) *55 (46 — 85)*
S1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	43 (33 — 64) *140 (110 — 200)*
S2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	34 (27 — 51) *110 (89 — 160)*
S3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
S11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 59) *130 (99 — 190)*
S12	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
S13	E	0.50 *0,50*	0.19 *0,0075*	0.20 *0,0080*	0.24 *0,0095*	24 (18 — 35) *80 (60 — 110)*
H5	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
H8	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79 — 150)*
H11	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 58) *130 (99 — 190)*
H12	M/A/D	0.50 *0,50*	0.12 *0,0048*	0.12 *0,0048*	0.14 *0,0055*	12 (9.1 — 18) *39 (30 — 59)*
H21	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79 — 150)*
H31	M/A/D	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.17 *0,0065*	24 (19 — 36) *80 (63 — 110)*
TS1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
TP1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
GR1	D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*

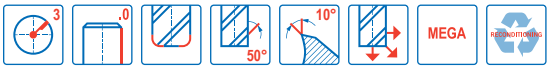
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

J36

General purpose – Universal – Square – 3 Flutes – Cylindrical – Corner radius





- Tolerances:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- RE= Ø2-Ø12= +0,05 mm
- RE= Ø14-Ø20= +0,1 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
36020-MEGA	00025621	2	F	2,0	3,0	9,0	40,0	0,1	2,5	3	■
36030-MEGA	00025626	2	D	3,0	3,0	12,0	40,0	0,1	–	3	■
36040-MEGA	00025628	2	D	4,0	4,0	14,0	50,0	0,1	–	3	■
36050-MEGA	00025651	2	D	5,0	5,0	20,0	50,0	0,1	–	3	■
36060-MEGA	00025663	2	D	6,0	6,0	20,0	65,0	0,1	–	3	■
36080-MEGA	00025674	2	D	8,0	8,0	20,0	65,0	0,2	–	3	■
36100-MEGA	00025680	2	D	10,0	10,0	25,0	75,0	0,2	–	3	■
36120-MEGA	00025681	2	D	12,0	12,0	25,0	75,0	0,2	–	3	■
36160-MEGA	00025689	2	D	16,0	16,0	30,0	90,0	0,5	–	3	■
36200-MEGA	00025692	2	D	20,0	20,0	40,0	100,0	0,5	–	3	■

■ Stocked standard.

Cutting data – J36 Side milling

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
P2	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	190 (170 — 210) *620 (560 — 680)*
P3	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
P4	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130 — 160) *490 (430 — 520)*
P5	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130 — 160) *460 (430 — 520)*
P6	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	160 (140 — 180) *520 (460 — 590)*
P7	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
P8	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	140 (130 — 160) *460 (430 — 520)*
P11	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	145 (130 — 160) *475 (430 — 520)*
P12	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	115 (92 — 140) *375 (310 — 450)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	95 (76 — 110) *310 (250 — 360)*
M3	E	0.100 *0,100*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	75 (56 — 95) *245 (190 — 310)*
M4	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (43 — 73) *195 (150 — 230)*
M5	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	48 (36 — 60) *155 (120 — 190)*
K1	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130 — 160) *460 (430 — 520)*
K2	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	125 (110 — 140) *410 (370 — 450)*
K3	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	105 (91 — 120) *345 (300 — 390)*
K4	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	100 (87 — 110) *330 (290 — 360)*
K5	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	60 (53 — 69) *195 (180 — 220)*
K6	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	90 (76 — 100) *295 (250 — 320)*
K7	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	80 (67 — 89) *260 (220 — 290)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – J36 Side milling

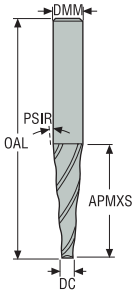
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.300	1.2	0.022	0.032	0.042	0.055	0.065	0.085	0.11	0.13	0.16	0.18	650 (540 — 750)
		0,300	*1,2*	*0,00085*	*0,0013*	*0,0017*	*0,0022*	*0,0026*	*0,0034*	*0,0044*	*0,0050*	*0,0065*	*0,0070*	*2125 (1800 — 2400)*
N2	E	0.300	1.2	0.022	0.032	0.042	0.055	0.065	0.085	0.11	0.13	0.16	0.18	415 (350 — 480)
		0,300	*1,2*	*0,00085*	*0,0013*	*0,0017*	*0,0022*	*0,0026*	*0,0034*	*0,0044*	*0,0050*	*0,0065*	*0,0070*	*1350 (1200 — 1500)*
N3	E	0.300	1.2	0.022	0.032	0.042	0.055	0.065	0.085	0.11	0.13	0.16	0.18	275 (240 — 320)
		0,300	*1,2*	*0,00085*	*0,0013*	*0,0017*	*0,0022*	*0,0026*	*0,0034*	*0,0044*	*0,0050*	*0,0065*	*0,0070*	*900 (790 — 1000)*
N11	E	0.300	1.0	0.012	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.090	0.10	305 (260 — 350)
		0,300	*1,0*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0036*	*0,0040*	*1000 (860 — 1100)*
S1	E	0.120	0.90	0.0055	0.0080	0.011	0.014	0.016	0.022	0.028	0.032	0.040	0.046	70 (60 — 83)
		0,120	*0,90*	*0,00022*	*0,00032*	*0,00044*	*0,00055*	*0,00065*	*0,00085*	*0,0011*	*0,0013*	*0,0016*	*0,0018*	*230 (200 — 270)*
S2	E	0.120	0.90	0.0055	0.0080	0.011	0.014	0.016	0.022	0.028	0.032	0.040	0.046	60 (48 — 67)
		0,120	*0,90*	*0,00022*	*0,00032*	*0,00044*	*0,00055*	*0,00065*	*0,00085*	*0,0011*	*0,0013*	*0,0016*	*0,0018*	*195 (160 — 210)*
S3	E	0.120	0.90	0.0036	0.0055	0.0075	0.0090	0.011	0.015	0.018	0.022	0.028	0.032	39 (30 — 48)
		0,120	*0,90*	*0,00014*	*0,00022*	*0,00030*	*0,00036*	*0,00044*	*0,00060*	*0,00070*	*0,00085*	*0,0011*	*0,0013*	*130 (99 — 150)*
S11	E	0.300	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.075	0.085	100 (89 — 110)
		0,300	*0,90*	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*0,0034*	*330 (300 — 360)*
S12	E	0.300	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.075	0.085	80 (68 — 87)
		0,300	*0,90*	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0030*	*0,0034*	*260 (230 — 280)*
S13	E	0.300	1.0	0.0085	0.013	0.017	0.022	0.026	0.034	0.044	0.050	0.065	0.075	60 (54 — 69)
		0,300	*0,90*	*0,00036*	*0,00050*	*0,00070*	*0,00085*	*0,0010*	*0,0014*	*0,0017*	*0,0020*	*0,0026*	*0,0030*	*195 (180 — 220)*
TS1	A	0.400	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.15	0.17	500 (460 — 550)
		0,400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0060*	*0,0065*	*1650 (1600 — 1800)*
TP1	A	0.400	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.15	0.17	500 (460 — 550)
		0,400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0060*	*0,0065*	*1650 (1600 — 1800)*

For cutting data recalculations, see pages 573 - 580

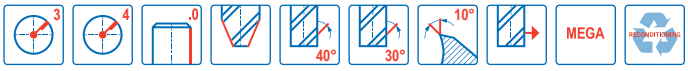
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

HK

General purpose – Universal – Conical – 3-4 Flutes – Cylindrical – Tapered sharp



N



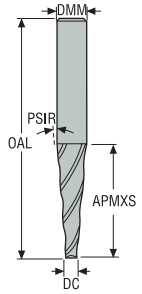
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK020-040-MEGA	00028666	2	N	4,0	6,0	20,0	65,0	2,0	3	■
HK020-050-MEGA	00028669	2	N	5,0	8,0	30,0	75,0	2,0	3	■
HK020-100-MEGA	00028694	2	N	10,0	12,0	28,0	80,0	2,0	4	■

■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

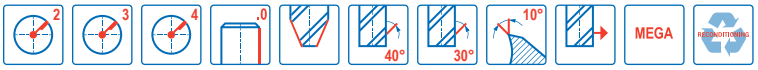
HKM-HK

General purpose – Universal – Conical – 2-4 Flutes – Cylindrical – Tapered sharp



N

- Tolerances:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DC is ≥Ø6

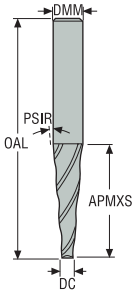


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HKM030-015-MEGA	00028738	2	N	1,5	3,0	6,0	40,0	3,0	2	■
HK030-025-MEGA	00028741	2	N	2,5	6,0	20,0	65,0	3,0	3	■
HK030-033-MEGA	00028744	2	N	3,0	8,0	30,0	75,0	3,0	3	■
HK030-065-MEGA	00028759	2	N	6,0	12,0	55,0	110,0	3,0	3	■
HK030-083-MEGA	00028771	2	N	8,0	12,0	30,0	80,0	3,0	4	■

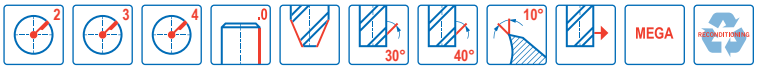
■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HKM-HK

General purpose – Universal – Conical – 2-4 Flutes – Cylindrical – Tapered sharp



N



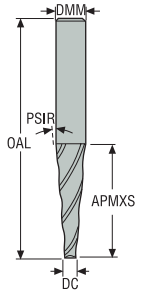
- Tolerances:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HKM050-010-MEGA	00028947	2	N	1,0	3,0	4,0	40,0	5,0	2	■
HKM050-015-MEGA	00028952	2	N	1,5	3,0	6,0	40,0	5,0	2	■
HKM050-020-MEGA	00028954	2	N	2,0	4,0	10,0	50,0	5,0	2	■
HKM050-025-MEGA	00028958	2	N	2,5	5,0	10,0	50,0	5,0	2	■
HK050-025-MEGA	00028960	2	N	2,5	6,0	20,0	65,0	5,0	3	■
HK050-032-MEGA	00028972	2	N	3,0	8,0	28,0	70,0	5,0	3	■
HK050-0420-MEGA	00028998	2	N	4,0	8,0	22,0	65,0	5,0	3	■
HK050-050-MEGA	00029012	2	N	5,0	12,0	40,0	100,0	5,0	3	■
HK050-063-MEGA	00029014	2	N	6,0	12,0	32,0	90,0	5,0	3	■
HK050-065-MEGA	00029017	2	N	6,0	16,0	55,0	110,0	5,0	3	■
HK050-103-MEGA	00029020	2	N	10,0	16,0	32,0	90,0	5,0	4	■
HK050-105-MEGA	00029025	2	N	10,0	20,0	55,0	115,0	5,0	4	■

■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

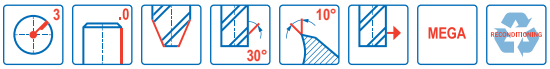
HK

General purpose – Universal – Conical – 3 Flutes – Cylindrical – Tapered sharp



N

- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

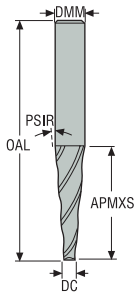


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK070-025-MEGA	00029030	2	N	2,5	8,0	22,0	65,0	7,0	3	■
HK070-050-MEGA	00029034	2	N	5,0	12,0	28,0	80,0	7,0	3	■

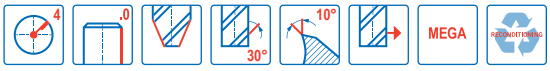
■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HK

General purpose – Universal – Conical – 4 Flutes – Cylindrical – Tapered sharp



N



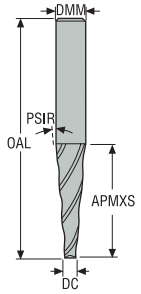
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK080-083-MEGA	00029041	2	N	8,0	18,0	35,0	90,0	8,0	4	■

■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HK

General purpose – Universal – Conical – 3-4 Flutes – Cylindrical – Tapered sharp



N

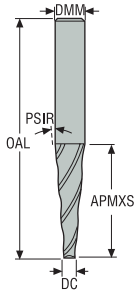
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK100-025-MEGA	00029052	2	N	2,5	10,0	20,0	75,0	10,0	3	■
HK100-030-MEGA	00029066	2	N	3,0	14,0	30,0	90,0	10,0	3	■
HK100-050-MEGA	00029069	2	N	5,0	16,0	30,0	90,0	10,0	3	■
HK100-080-MEGA	00029083	2	N	8,0	20,0	32,0	90,0	10,0	4	■

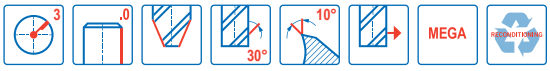
■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HK

General purpose – Universal – Conical – 3 Flutes – Cylindrical – Tapered sharp



N



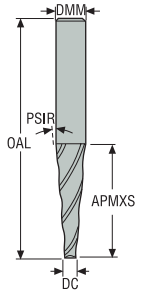
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK110-020-MEGA	00029110	2	N	2,0	10,0	20,0	75,0	11,0	3	■
HK110-050-MEGA	00029117	2	N	5,0	14,0	20,0	80,0	11,0	3	■

■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HK

General purpose – Universal – Conical – 3-4 Flutes – Cylindrical – Tapered sharp



N

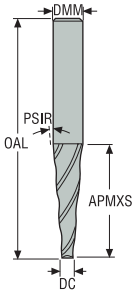
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK150-025	00029119	2	N	2,5	14,0	20,0	80,0	15,0	3	■
HK150-025-MEGA	00029151	2	N	2,5	14,0	20,0	80,0	15,0	3	■
HK150-040	00029124	2	N	4,0	12,0	15,0	65,0	15,0	3	■
HK150-040-MEGA	00029154	2	N	4,0	12,0	15,0	65,0	15,0	3	■
HK150-0651	00029133	2	N	6,5	12,0	10,0	65,0	15,0	3	■
HK150-0651-MEGA	00029160	2	N	6,5	12,0	10,0	65,0	15,0	3	■
HK150-0652	00029138	2	N	6,5	20,0	25,0	90,0	15,0	3	■
HK150-0652-MEGA	00029161	2	N	6,5	20,0	25,0	90,0	15,0	3	■
HK150-080	00029149	2	N	8,0	20,0	20,0	80,0	15,0	4	■
HK150-080-MEGA	00029162	2	N	8,0	20,0	20,0	80,0	15,0	4	■

■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HK

General purpose – Universal – Conical – 3-4 Flutes – Cylindrical – Tapered sharp



N

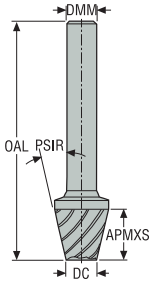
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK200-025	00029165	2	N	2,5	10,0	10,0	75,0	20,0	3	■
HK200-025-MEGA	00029168	2	N	2,5	10,0	10,0	75,0	20,0	3	■
HK200-045	00029166	2	N	4,5	16,0	15,0	90,0	20,0	4	■
HK200-045-MEGA	00029203	2	N	4,5	16,0	15,0	90,0	20,0	4	■

■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HK

General purpose – Universal – Conical – 3-4 Flutes – Cylindrical – Tapered sharp



N

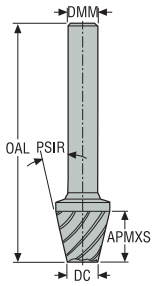
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK300-025	00029208	2	N	2,5	10,0	10,0	75,0	30,0	3	■
HK300-025-MEGA	00029211	2	N	2,5	10,0	10,0	75,0	30,0	3	■
HK300-045	00029210	2	N	4,5	16,0	16,0	90,0	30,0	4	■
HK300-045-MEGA	00029212	2	N	4,5	16,0	16,0	90,0	30,0	4	■

■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HK

General purpose – Universal – Conical – 3-4 Flutes – Cylindrical – Tapered sharp



N

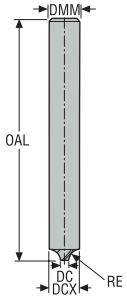
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK450-025	00029215	2	N	2,5	12,0	10,0	75,0	45,0	3	■
HK450-025-MEGA	00029229	2	N	2,5	12,0	10,0	75,0	45,0	3	■
HK450-045	00029217	2	N	4,5	16,0	16,0	90,0	45,0	4	■
HK450-045-MEGA	00029232	2	N	4,5	16,0	16,0	90,0	45,0	4	■

■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

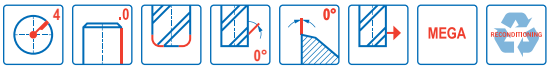
V31

General purpose – Universal – Concave – 4 Flutes – Cylindrical



D

- Tolerances:
- DMM= h5
- DC= ±0,04 mm
- RE= ±0,02 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DCX	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
31100-MEGA	00029307	2	D	4,0	6,0	6,0	1,0	64,0	1,0	4	■
31200-MEGA	00029315	2	D	4,0	8,0	8,0	2,0	75,0	2,0	4	■
31300-MEGA	00029326	2	D	4,0	10,0	10,0	3,0	75,0	3,0	4	■
31400-MEGA	00029328	2	D	4,0	12,0	12,0	4,0	75,0	4,0	4	■
31050-MEGA	00029285	2	D	5,0	6,0	6,0	0,5	64,0	0,5	4	■
31150-MEGA	00029313	2	D	5,0	8,0	8,0	1,5	75,0	1,5	4	■
31250-MEGA	00029324	2	D	5,0	10,0	10,0	2,5	75,0	2,5	4	■
31350-MEGA	00029327	2	D	5,0	12,0	12,0	3,5	75,0	3,5	4	■
31500-MEGA	00029330	2	D	6,0	16,0	16,0	5,0	75,0	5,0	4	■
31600-MEGA	00029331	2	D	8,0	20,0	20,0	6,0	80,0	6,0	4	■
31999-MEGA	00029335	2	D	8,0	28,0	25,0	10,0	80,0	10,0	4	■
31800-MEGA	00029333	2	D	9,0	25,0	25,0	8,0	75,0	8,0	4	■

■ Stocked standard.

Cutting data – V31 Side milling roughing

SMG		a_p/DC	f_z								v_c
			6	8	10	12	16	20	25	28	
P1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0034*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	105 (70 — 115) *345 (220 — 375)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – V31 Side milling roughing

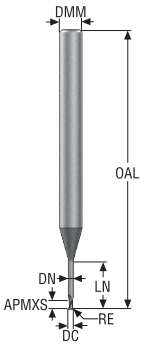
SMG		a_p/DC	f_z								v_c
			6	8	10	12	16	20	25	28	
N1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460 — 730)*
S2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460 — 730)*
S3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	265 (180 — 285) *870 (590 — 940)*
S12	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S13	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	0,075 *0,003*	0,080 *0,0032*	155 (105 — 165) *510 (345 — 540)*
H5	M/A	0,24 *0,24*	0,034 *0,0013*	0,046 *0,0018*	0,055 *0,0022*	0,070 *0,0028*	0,090 *0,0036*	0,11 *0,0044*	0,13 *0,0050*	0,14 *0,0055*	275 (185 — 295) *900 (610 — 950)*
H8	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H21	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H31	M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
TS1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*

For cutting data recalculations, see pages 573 - 580

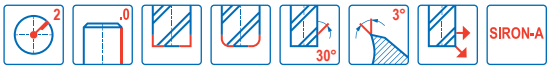
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JME542

Miniature – Universal – Square – 2 Flutes – DMM 4 – Cylindrical – Sharp or corner radius



G



- Tolerances:
- Run-out= <0,007 mm
- DMM= h5
- DC= Ø0,2-Ø0,4= 0,-0,01 mm
- DC= Ø0,5-Ø3,0= 0,-0,013 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JME542002G1S.0Z2-SIRA	03171095	1	G	0,2	4,0	0,3	45,0	0,4	0,18	–	14,41	2	■
JME542003G1S.0Z2-SIRA	03171096	1	G	0,3	4,0	0,45	45,0	0,6	0,28	–	14,0	2	■
JME542004G1S.0Z2-SIRA	03171128	1	G	0,4	4,0	0,6	45,0	0,8	0,37	–	13,5	2	■
JME542005G1R005.0Z2-SIRA	03171097	1	G	0,5	4,0	0,8	45,0	1,0	0,46	0,05	13,17	2	■
JME542006G1R005.0Z2-SIRA	03171098	1	G	0,6	4,0	0,9	45,0	1,2	0,56	0,05	12,76	2	■
JME542008G1R005.0Z2-SIRA	03171129	1	G	0,8	4,0	1,2	45,0	1,6	0,76	0,05	11,96	2	■
JME542010G1R010.0Z2-SIRA	03171099	1	G	1,0	4,0	1,5	50,0	2,0	0,95	0,1	11,22	2	■
JME542012G1R010.0Z2-SIRA	03171100	1	G	1,2	4,0	1,8	50,0	2,4	1,15	0,1	10,43	2	■
JME542015G1R015.0Z2-SIRA	03171130	1	G	1,5	4,0	2,3	50,0	3,0	1,45	0,15	9,2	2	■
JME542005G3R005.0Z2-SIRA	03171102	3	G	0,5	4,0	0,8	45,0	2,5	0,46	0,05	11,03	2	■
JME542006G3R005.0Z2-SIRA	03171103	3	G	0,6	4,0	0,9	45,0	3,0	0,56	0,05	10,36	2	■
JME542008G3R005.0Z2-SIRA	03171131	3	G	0,8	4,0	1,2	45,0	4,0	0,76	0,05	9,14	2	■
JME542010G3R010.0Z2-SIRA	03171104	3	G	1,0	4,0	1,5	50,0	5,0	0,95	0,1	8,09	2	■
JME542012G3R010.0Z2-SIRA	03171105	3	G	1,2	4,0	1,8	50,0	6,0	1,15	0,1	7,13	2	■
JME542015G3R015.0Z2-SIRA	03171132	3	G	1,5	4,0	2,3	50,0	7,5	1,45	0,15	5,89	2	■
JME542020G3R015.0Z2-SIRA	03171106	3	G	2,0	4,0	3,0	50,0	10,0	1,94	0,15	4,14	2	■
JME542025G3R015.0Z2-SIRA	03171108	3	G	2,5	4,0	3,8	50,0	12,5	2,4	0,15	2,79	2	■
JME542030G3R015.0Z2-SIRA	03171134	3	G	3,0	4,0	4,5	60,0	15,0	2,85	0,15	1,67	2	■
JME542005G4R005.0Z2-SIRA	03171109	4	G	0,5	4,0	0,8	45,0	4,0	0,46	0,05	9,49	2	■
JME542006G4R005.0Z2-SIRA	03171110	4	G	0,6	4,0	0,9	45,0	5,0	0,56	0,05	8,56	2	■
JME542008G4R005.0Z2-SIRA	03171135	4	G	0,8	4,0	1,2	45,0	7,0	0,76	0,05	7,05	2	■
JME542010G4R010.0Z2-SIRA	03171111	4	G	1,0	4,0	1,5	50,0	8,5	0,95	0,1	6,1	2	■
JME542012G4R010.0Z2-SIRA	03171112	4	G	1,2	4,0	1,8	50,0	10,0	1,15	0,1	5,27	2	■
JME542015G4R015.0Z2-SIRA	03171136	4	G	1,5	4,0	2,3	50,0	12,0	1,45	0,15	4,29	2	■
JME542020G4R015.0Z2-SIRA	03171113	4	G	2,0	4,0	3,0	60,0	16,0	1,94	0,15	2,9	2	■
JME542030G4R015.0Z2-SIRA	03171137	4	G	3,0	4,0	4,5	70,0	24,0	2,85	0,15	1,1	2	■
JME542015G5R015.0Z2-SIRA	03171115	5	G	1,5	4,0	2,3	60,0	15,0	1,45	0,15	3,64	2	■
JME542020G5R015.0Z2-SIRA	03171116	5	G	2,0	4,0	3,0	60,0	20,0	1,94	0,15	2,41	2	■
JME542030G5R015.0Z2-SIRA	03171117	5	G	3,0	4,0	4,5	70,0	30,0	2,85	0,15	0,9	2	■
JME542015G6R015.0Z2-SIRA	03171118	6	G	1,5	4,0	2,3	70,0	22,5	1,45	0,15	2,64	2	■
JME542020G6R015.0Z2-SIRA	03171139	6	G	2,0	4,0	3,0	70,0	30,0	1,94	0,15	1,7	2	■
JME542030G6R015.0Z2-SIRA	03171120	6	G	3,0	4,0	4,5	90,0	45,0	2,85	0,15	0,61	2	■

■ Stocked standard.

Seco

Cutting data – JME542 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	415 (370 — 460)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1350 (1300 — 1500)*
P2	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	405 (360 — 440)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1325 (1200 — 1400)*
P3	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (310 — 380)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (1100 — 1200)*
P4	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	305 (280 — 340)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1000 (920 — 1100)*
P5	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 320)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P6	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	330 (300 — 360)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (990 — 1100)*
P7	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	310 (280 — 340)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1025 (920 — 1100)*
P8	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 320)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P11	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	300 (270 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*980 (890 — 1000)*
P12	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (160 — 190)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (530 — 620)*
M1	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	220 (190 — 260)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*720 (630 — 850)*
M2	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (150 — 210)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (500 — 680)*
M3	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (150 — 210)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (500 — 680)*
M4	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	135 (110 — 150)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*445 (370 — 490)*
M5	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	110 (92 — 130)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*360 (310 — 420)*
N1	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	570 (500 — 640)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1875 (1700 — 2000)*
N2	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	570 (500 — 640)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1875 (1700 — 2000)*
N3	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	380 (340 — 420)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1250 (1200 — 1300)*
N11	E/M/A	0.100	0.75	0.0050	0.0075	0.010	0.012	0.015	0.020	0.025	0.030	0.046	0.050	0.060	0.075	510 (440 — 580)
		0,100	*0,75*	*0,00020*	*0,00030*	*0,00040*	*0,00048*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0018*	*0,0020*	*0,0024*	*0,0030*	*1675 (1500 — 1900)*
S11	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	295 (260 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*970 (860 — 1000)*
S12	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	225 (200 — 250)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*740 (660 — 820)*
S13	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (160 — 200)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (530 — 650)*
H3	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H5	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H8	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H11	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	325 (290 — 360)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (960 — 1100)*
H12	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	295 (270 — 330)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*970 (890 — 1000)*
H21	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H31	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	195 (170 — 210)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*640 (560 — 680)*
GR1	A	0.500	0.50	0.0030	0.0044	0.0060	0.0075	0.0090	0.012	0.015	0.018	0.024	0.025	0.028	0.032	405 (350 — 460)
		0,500	*0,50*	*0,00012*	*0,00017*	*0,00024*	*0,00030*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0010*	*0,0011*	*0,0013*	*1325 (1200 — 1500)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JME542 Slot milling

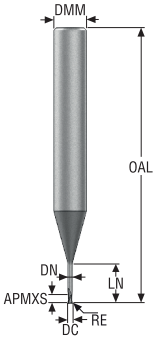
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.022	0.022	0.026	0.028	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00085*	*0,00085*	*0,0010*	*0,0011*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.048	0.050	350 (300 — 400)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0019*	*0,0020*	*1150 (990 — 1300)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	110 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*360 (310 — 390)*
H3	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 400)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1300)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JME562

Miniature – Universal – Square – 2 Flutes – DMM 6 – Cylindrical – Corner radius



G

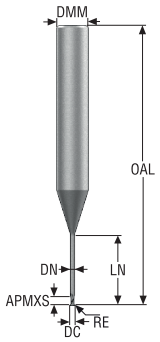
- Tolerances:
- Run-out= <0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JME562005G2R005.0Z2-SIRA	03171145	2	G	0,5	6,0	0,8	50,0	1,5	0,46	0,05	13,48	2	■
JME562006G2R005.0Z2-SIRA	03171146	2	G	0,6	6,0	0,9	50,0	2,0	0,56	0,05	12,9	2	■
JME562008G2R005.0Z2-SIRA	03171147	2	G	0,8	6,0	1,2	50,0	2,5	0,76	0,05	12,28	2	■
JME562010G2R010.0Z2-SIRA	03171148	2	G	1,0	6,0	1,5	50,0	4,0	0,95	0,1	10,85	2	■
JME562012G2R010.0Z2-SIRA	03171150	2	G	1,2	6,0	1,8	50,0	4,5	1,15	0,1	10,31	2	■
JME562015G2R015.0Z2-SIRA	03171151	2	G	1,5	6,0	2,3	50,0	5,0	1,45	0,15	9,67	2	■
JME562018G2R015.0Z2-SIRA	03171152	2	G	1,8	6,0	2,7	50,0	5,4	1,75	0,15	9,12	2	■
JME562020G2R015.0Z2-SIRA	03171153	2	G	2,0	6,0	3,0	50,0	6,0	1,94	0,15	8,53	2	■
JME562025G2R015.0Z2-SIRA	03171154	2	G	2,5	6,0	3,8	60,0	7,5	2,4	0,15	7,15	2	■
JME562030G2R015.0Z2-SIRA	03171155	2	G	3,0	6,0	4,5	60,0	9,0	2,85	0,15	5,81	2	■
JME562005G4R005.0Z2-SIRA	03171156	4	G	0,5	6,0	0,8	50,0	3,5	0,46	0,05	11,54	2	■
JME562006G4R005.0Z2-SIRA	03171157	4	G	0,6	6,0	0,9	50,0	4,2	0,56	0,05	10,93	2	■
JME562008G4R005.0Z2-SIRA	03171158	4	G	0,8	6,0	1,2	50,0	5,6	0,76	0,05	9,81	2	■
JME562010G4R010.0Z2-SIRA	03171159	4	G	1,0	6,0	1,5	50,0	7,0	0,95	0,1	8,86	2	■
JME562012G4R010.0Z2-SIRA	03171160	4	G	1,2	6,0	1,8	50,0	8,4	1,15	0,1	8,0	2	■
JME562015G4R015.0Z2-SIRA	03171162	4	G	1,5	6,0	2,3	50,0	10,5	1,45	0,15	6,86	2	■
JME562020G4R015.0Z2-SIRA	03171163	4	G	2,0	6,0	3,0	60,0	14,0	1,94	0,15	5,36	2	■
JME562030G4R015.0Z2-SIRA	03171165	4	G	3,0	6,0	4,5	70,0	21,0	2,85	0,15	3,22	2	■
JME562005G5R005.0Z2-SIRA	03171166	5	G	0,5	6,0	0,8	50,0	5,0	0,46	0,05	10,42	2	■
JME562006G5R005.0Z2-SIRA	03171167	5	G	0,6	6,0	0,9	50,0	6,0	0,56	0,05	9,71	2	■
JME562008G5R005.0Z2-SIRA	03171168	5	G	0,8	6,0	1,2	50,0	8,0	0,76	0,05	8,48	2	■
JME562010G5R010.0Z2-SIRA	03171169	5	G	1,0	6,0	1,5	50,0	10,0	0,95	0,1	7,48	2	■
JME562012G5R010.0Z2-SIRA	03171170	5	G	1,2	6,0	1,8	50,0	12,0	1,15	0,1	6,62	2	■
JME562015G5R015.0Z2-SIRA	03171171	5	G	1,5	6,0	2,3	60,0	15,0	1,45	0,15	5,54	2	■
JME562020G5R015.0Z2-SIRA	03171172	5	G	2,0	6,0	3,0	60,0	20,0	1,94	0,15	4,19	2	■
JME562030G5R015.0Z2-SIRA	03171174	5	G	3,0	6,0	4,5	70,0	30,0	2,85	0,15	2,41	2	■

■ Stocked standard.

JME562

Miniature – Universal – Square – 2 Flutes – DMM 6 – Cylindrical – Corner radius



G

- Tolerances:
- Run-out= <0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JME562010G6R010.0Z2-SIRA	03171175	6	G	1,0	6,0	1,5	60,0	15,0	0,95	0,1	5,94	2	■
JME562012G6R010.0Z2-SIRA	03171176	6	G	1,2	6,0	1,8	60,0	18,0	1,15	0,1	5,14	2	■
JME562015G6R015.0Z2-SIRA	03171177	6	G	1,5	6,0	2,3	70,0	22,5	1,45	0,15	4,2	2	■
JME562020G6R015.0Z2-SIRA	03171178	6	G	2,0	6,0	3,0	80,0	30,0	1,94	0,15	3,07	2	■
JME562030G6R015.0Z2-SIRA	03171180	6	G	3,0	6,0	4,5	90,0	45,0	2,85	0,15	1,7	2	■
JME562010G7R010.0Z2-SIRA	03171181	7	G	1,0	6,0	1,5	60,0	20,0	0,95	0,1	4,93	2	■
JME562012G7R010.0Z2-SIRA	03171182	7	G	1,2	6,0	1,8	80,0	24,0	1,15	0,1	4,2	2	■
JME562015G7R015.0Z2-SIRA	03171183	7	G	1,5	6,0	2,3	80,0	30,0	1,45	0,15	3,38	2	■
JME562020G7R015.0Z2-SIRA	03171184	7	G	2,0	6,0	3,0	80,0	40,0	1,94	0,15	2,42	2	■
JME562030G7R015.0Z2-SIRA	03171186	7	G	3,0	6,0	4,5	100,0	60,0	2,85	0,15	1,31	2	■

■ Stocked standard.

Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

Cutting data – JME562 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	415 (370 — 460)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1350 (1300 — 1500)*
P2	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	405 (360 — 440)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1325 (1200 — 1400)*
P3	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (310 — 380)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (1100 — 1200)*
P4	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	305 (280 — 340)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1000 (920 — 1100)*
P5	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 320)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P6	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	330 (300 — 360)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (990 — 1100)*
P7	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	310 (280 — 340)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1025 (920 — 1100)*
P8	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 320)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P11	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	300 (270 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*980 (890 — 1000)*
P12	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (160 — 190)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (530 — 620)*
M1	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	220 (190 — 260)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*720 (630 — 850)*
M2	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (150 — 210)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (500 — 680)*
M3	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (150 — 210)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (500 — 680)*
M4	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	135 (110 — 150)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*445 (370 — 490)*
M5	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	110 (92 — 130)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*360 (310 — 420)*
N1	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	570 (500 — 640)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1875 (1700 — 2000)*
N2	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	570 (500 — 640)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1875 (1700 — 2000)*
N3	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	380 (340 — 420)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1250 (1200 — 1300)*
N11	E/M/A	0.100	0.75	0.0050	0.0075	0.010	0.012	0.015	0.020	0.025	0.030	0.046	0.050	0.060	0.075	510 (440 — 580)
		0,100	*0,75*	*0,00020*	*0,00030*	*0,00040*	*0,00048*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0018*	*0,0020*	*0,0024*	*0,0030*	*1675 (1500 — 1900)*
S11	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	295 (260 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*970 (860 — 1000)*
S12	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	225 (200 — 250)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*740 (660 — 820)*
S13	E/M/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (160 — 200)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (530 — 650)*
H3	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H5	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H8	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H11	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	325 (290 — 360)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (960 — 1100)*
H12	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	295 (270 — 330)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*970 (890 — 1000)*
H21	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
H31	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	195 (170 — 210)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*640 (560 — 680)*
GR1	A	0.500	0.50	0.0030	0.0044	0.0060	0.0075	0.0090	0.012	0.015	0.018	0.024	0.025	0.028	0.032	405 (350 — 460)
		0,500	*0,50*	*0,00012*	*0,00017*	*0,00024*	*0,00030*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0010*	*0,0011*	*0,0013*	*1325 (1200 — 1500)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JME562 Slot milling

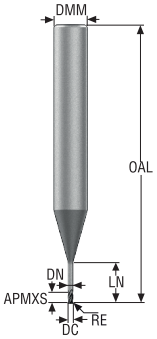
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.022	0.022	0.026	0.028	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00085*	*0,00085*	*0,0010*	*0,0011*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.048	0.050	350 (300 — 400)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0019*	*0,0020*	*1150 (990 — 1300)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	110 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*360 (310 — 390)*
H3	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 400)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1300)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JME564

Miniature – Universal – Square – 4 Flutes – DMM 6 – Cylindrical – Corner radius



G

- Tolerances:
- Run-out= <0-0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JME564005G2R005.0Z4-SIRA	03227166	2	G	0,5	6,0	1,0	50,0	1,5	0,46	0,05	13,48	4	■
JME564006G2R005.0Z4-SIRA	03227271	2	G	0,6	6,0	1,2	50,0	2,0	0,56	0,05	12,9	4	■
JME564008G2R005.0Z4-SIRA	03171194	2	G	0,8	6,0	1,6	50,0	2,5	0,76	0,05	12,28	4	■
JME564010G2R010.0Z4-SIRA	03171195	2	G	1,0	6,0	2,0	50,0	4,0	0,95	0,1	10,85	4	■
JME564012G2R010.0Z4-SIRA	03171196	2	G	1,2	6,0	2,4	50,0	4,5	1,15	0,1	10,31	4	■
JME564015G2R015.0Z4-SIRA	03171197	2	G	1,5	6,0	3,0	50,0	5,0	1,45	0,15	9,67	4	■
JME564020G2R015.0Z4-SIRA	03171198	2	G	2,0	6,0	4,0	50,0	6,0	1,94	0,15	8,53	4	■
JME564025G2R015.0Z4-SIRA	03171199	2	G	2,5	6,0	5,0	60,0	7,5	2,4	0,15	7,15	4	■
JME564030G2R015.0Z4-SIRA	03171200	2	G	3,0	6,0	6,0	60,0	9,0	2,85	0,15	5,81	4	■
JME564005G4R005.0Z4-SIRA	03171201	4	G	0,5	6,0	1,0	50,0	3,5	0,46	0,05	11,54	4	■
JME564006G4R005.0Z4-SIRA	03171202	4	G	0,6	6,0	1,2	50,0	4,2	0,56	0,05	10,93	4	■
JME564008G4R005.0Z4-SIRA	03171203	4	G	0,8	6,0	1,6	50,0	5,6	0,76	0,05	9,81	4	■
JME564010G4R010.0Z4-SIRA	03171204	4	G	1,0	6,0	2,0	50,0	7,0	0,95	0,1	8,86	4	■
JME564012G4R010.0Z4-SIRA	03171205	4	G	1,2	6,0	2,4	50,0	8,4	1,15	0,1	8,0	4	■
JME564015G4R015.0Z4-SIRA	03171206	4	G	1,5	6,0	3,0	50,0	10,5	1,45	0,15	6,86	4	■
JME564020G4R015.0Z4-SIRA	03171207	4	G	2,0	6,0	4,0	60,0	14,0	1,94	0,15	5,36	4	■
JME564030G4R015.0Z4-SIRA	03171209	4	G	3,0	6,0	6,0	70,0	21,0	2,85	0,15	3,22	4	■

■ Stocked standard.

Cutting data – JME564 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z									v_c
				0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (360 — 430) *1300 (1200 — 1400)*
P2	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200 — 1300)*
P3	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990 — 1100)*
P4	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P5	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P6	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920 — 1100)*
P7	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 320) *970 (890 — 1000)*
P8	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P11	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (260 — 310) *940 (860 — 1000)*
P12	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (160 — 180) *560 (530 — 590)*
M1	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (200 — 280) *770 (660 — 910)*
M2	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
M3	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
M4	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	145 (120 — 160) *475 (400 — 520)*
M5	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (99 — 140) *395 (330 — 450)*
N1	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 410) *1200 (1100 — 1300)*
N11	E/M/A	0.100 *0,100*	0.90 *0,90*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	490 (430 — 560) *1600 (1500 — 1800)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (250 — 320) *940 (830 — 1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 250) *720 (630 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (150 — 190) *560 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95 — 150) *410 (320 — 490)*
H5	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	240 (210 — 260) *790 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95 — 150) *410 (320 — 490)*
H8	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (270 — 340) *1000 (890 — 1100)*
H12	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	275 (250 — 310) *900 (830 — 1000)*
H21	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.048 *0,0019*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.65 *0,50*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	390 (340 — 440) *1300 (1200 — 1400)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JME564 Slot milling

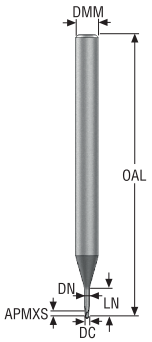
SMG		a_p/DC	f_z									v_c
			0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P2	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	245 (220 — 270) *800 (730 — 880)*
P3	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	210 (190 — 230) *690 (630 — 750)*
P4	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P5	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160 — 190) *570 (530 — 620)*
P6	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P8	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160 — 190) *570 (530 — 620)*
P11	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P12	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.026 *0,0010*	0.030 *0,0012*	105 (96 — 110) *345 (320 — 360)*
M1	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (110 — 150) *445 (370 — 490)*
M2	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89 — 120) *360 (300 — 390)*
M3	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89 — 120) *360 (300 — 390)*
M4	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (67 — 95) *260 (220 — 310)*
M5	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (56 — 79) *215 (190 — 250)*
N1	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200 — 1400)*
N2	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200 — 1400)*
N3	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	260 (230 — 290) *850 (760 — 950)*
N11	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.055 *0,0022*	345 (300 — 390) *1125 (990 — 1200)*
S11	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 150) *445 (400 — 490)*
S13	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	105 (92 — 120) *345 (310 — 390)*
H3	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H5	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (140 — 170) *520 (460 — 550)*
H7	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H8	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140 — 170) *520 (460 — 550)*
H11	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
H12	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	185 (170 — 200) *610 (560 — 650)*
H21	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140 — 170) *520 (460 — 550)*
H31	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.20 *0,20*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.024 *0,00095*	0.026 *0,0010*	325 (280 — 370) *1075 (920 — 1200)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JMB542

Miniature – Universal – Ball nose – 2 Flutes – DMM 4 – Cylindrical



G

- Tolerances:
- Run-out=<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JMB542002G1B.0Z2-SIRA	03171221	1	G	0,2	4,0	0,2	45,0	0,4	0,18	0,1	14,57	2	■
JMB542003G1B.0Z2-SIRA	03171222	1	G	0,3	4,0	0,3	45,0	0,6	0,28	0,15	14,24	2	■
JMB542004G1B.0Z2-SIRA	03171223	1	G	0,4	4,0	0,4	45,0	0,8	0,37	0,2	13,81	2	■
JMB542005G1B.0Z2-SIRA	03171224	1	G	0,5	4,0	0,5	45,0	1,0	0,46	0,25	13,47	2	■
JMB542006G1B.0Z2-SIRA	03171225	1	G	0,6	4,0	0,6	45,0	1,2	0,56	0,3	13,14	2	■
JMB542008G1B.0Z2-SIRA	03171226	1	G	0,8	4,0	0,8	45,0	1,6	0,76	0,4	12,46	2	■
JMB542010G1B.0Z2-SIRA	03171228	1	G	1,0	4,0	1,0	50,0	2,0	0,95	0,5	11,77	2	■
JMB542012G1B.0Z2-SIRA	03171229	1	G	1,2	4,0	1,2	50,0	2,4	1,15	0,6	11,07	2	■
JMB542015G1B.0Z2-SIRA	03171230	1	G	1,5	4,0	1,5	50,0	3,0	1,45	0,75	9,88	2	■
JMB542005G3B.0Z2-SIRA	03171231	3	G	0,5	4,0	0,5	45,0	2,5	0,46	0,25	11,25	2	■
JMB542006G3B.0Z2-SIRA	03171233	3	G	0,6	4,0	0,6	45,0	3,0	0,56	0,3	10,61	2	■
JMB542008G3B.0Z2-SIRA	03171234	3	G	0,8	4,0	0,8	45,0	4,0	0,76	0,4	9,44	2	■
JMB542010G3B.0Z2-SIRA	03171235	3	G	1,0	4,0	1,0	50,0	5,0	0,95	0,5	8,38	2	■
JMB542012G3B.0Z2-SIRA	03171236	3	G	1,2	4,0	1,2	50,0	6,0	1,15	0,6	7,44	2	■
JMB542015G3B.0Z2-SIRA	03171237	3	G	1,5	4,0	1,5	50,0	7,5	1,45	0,75	6,13	2	■
JMB542020G3B.0Z2-SIRA	03171238	3	G	2,0	4,0	2,0	50,0	10,0	1,94	1,0	4,4	2	■
JMB542030G3B.0Z2-SIRA	03171240	3	G	3,0	4,0	3,0	60,0	15,0	2,85	1,5	1,81	2	■
JMB542005G4B.0Z2-SIRA	03171241	4	G	0,5	4,0	0,5	45,0	4,0	0,46	0,25	9,65	2	■
JMB542006G4B.0Z2-SIRA	03171242	4	G	0,6	4,0	0,6	45,0	5,0	0,56	0,3	8,74	2	■
JMB542008G4B.0Z2-SIRA	03171243	4	G	0,8	4,0	0,8	45,0	7,0	0,76	0,4	7,23	2	■
JMB542010G4B.0Z2-SIRA	03171244	4	G	1,0	4,0	1,0	50,0	8,5	0,95	0,5	6,27	2	■
JMB542012G4B.0Z2-SIRA	03171245	4	G	1,2	4,0	1,2	50,0	10,0	1,15	0,6	5,44	2	■
JMB542015G4B.0Z2-SIRA	03171246	4	G	1,5	4,0	1,5	50,0	12,0	1,45	0,75	4,44	2	■
JMB542020G4B.0Z2-SIRA	03171247	4	G	2,0	4,0	2,0	60,0	16,0	1,94	1,0	3,02	2	■
JMB542030G4B.0Z2-SIRA	03171249	4	G	3,0	4,0	3,0	70,0	24,0	2,85	1,5	1,16	2	■
JMB542015G5B.0Z2-SIRA	03171250	5	G	1,5	4,0	1,5	60,0	15,0	1,45	0,75	3,75	2	■
JMB542020G5B.0Z2-SIRA	03171251	5	G	2,0	4,0	2,0	60,0	20,0	1,94	1,0	2,5	2	■
JMB542030G5B.0Z2-SIRA	03171253	5	G	3,0	4,0	3,0	70,0	30,0	2,85	1,5	0,93	2	■
JMB542015G6B.0Z2-SIRA	03171254	6	G	1,5	4,0	1,5	70,0	22,5	1,45	0,75	2,7	2	■
JMB542020G6B.0Z2-SIRA	03171255	6	G	2,0	4,0	2,0	70,0	30,0	1,94	1,0	1,74	2	■
JMB542030G6B.0Z2-SIRA	03171257	6	G	3,0	4,0	3,0	90,0	45,0	2,85	1,5	0,63	2	■

■ Stocked standard.

Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

Cutting data – JMB542 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	365 (330 — 400)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1200 (1100 — 1300)*
P2	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	355 (320 — 390)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1175 (1100 — 1200)*
P3	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	305 (280 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1000 (920 — 1100)*
P4	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	270 (240 — 290)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*890 (790 — 950)*
P5	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
P6	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 310)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P7	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	270 (250 — 300)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*890 (830 — 980)*
P8	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
P11	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	265 (240 — 290)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*870 (790 — 950)*
P12	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	155 (140 — 170)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*510 (460 — 550)*
M1	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	215 (180 — 250)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*710 (600 — 820)*
M2	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 200)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 650)*
M3	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 200)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 650)*
M4	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	130 (110 — 150)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*425 (370 — 490)*
M5	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	110 (90 — 120)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*360 (300 — 390)*
N1	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	485 (430 — 540)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1600 (1500 — 1700)*
N2	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	485 (430 — 540)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1600 (1500 — 1700)*
N3	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	325 (290 — 360)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (960 — 1100)*
N11	E/M/A	0.100	0.75	0.0050	0.0075	0.010	0.012	0.015	0.020	0.025	0.030	0.046	0.050	0.060	0.075	430 (370 — 480)
		0,100	*0,75*	*0,00020*	*0,00030*	*0,00040*	*0,00048*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0018*	*0,0020*	*0,0024*	*0,0030*	*1400 (1300 — 1500)*
S11	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (250 — 330)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (830 — 1000)*
S12	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	225 (200 — 250)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*740 (660 — 820)*
S13	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 190)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 620)*
H3	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H5	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H8	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H11	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	300 (270 — 330)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*980 (890 — 1000)*
H12	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	275 (240 — 300)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*900 (790 — 980)*
H21	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H31	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (160 — 200)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (530 — 650)*
GR1	A	0.500	0.50	0.0030	0.0044	0.0060	0.0075	0.0090	0.012	0.015	0.018	0.028	0.030	0.038	0.040	405 (350 — 460)
		0,500	*0,50*	*0,00012*	*0,00017*	*0,00024*	*0,00030*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,0011*	*0,0012*	*0,0015*	*0,0016*	*1325 (1200 — 1500)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JMB542 Slot milling

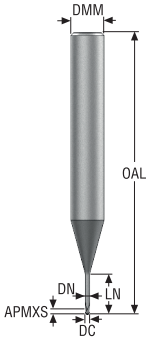
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (300 — 390)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (990 — 1200)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	105 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*345 (310 — 390)*
H3	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 390)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1200)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JMB562

Miniature – Universal – Ball nose – 2 Flutes – DMM 6 – Cylindrical



G

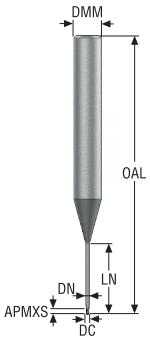
- Tolerances:
- Run-out=<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JMB562005G2B.0Z2-SIRA	03171261	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	13,69	2	■
JMB562006G2B.0Z2-SIRA	03171262	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	13,13	2	■
JMB562008G2B.0Z2-SIRA	03171263	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	12,6	2	■
JMB562010G2B.0Z2-SIRA	03171264	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	11,15	2	■
JMB562012G2B.0Z2-SIRA	03171265	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	2	■
JMB562015G2B.0Z2-SIRA	03171266	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	2	■
JMB562018G2B.0Z2-SIRA	03171267	2	G	1,8	6,0	1,8	50,0	5,4	1,75	0,9	9,61	2	■
JMB562020G2B.0Z2-SIRA	03171268	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	2	■
JMB562025G2B.0Z2-SIRA	03171269	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	2	■
JMB562030G2B.0Z2-SIRA	03171270	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	2	■
JMB562005G4B.0Z2-SIRA	03171271	4	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	11,7	2	■
JMB562006G4B.0Z2-SIRA	03171272	4	G	0,6	6,0	0,6	50,0	4,2	0,56	0,3	11,1	2	■
JMB562008G4B.0Z2-SIRA	03171273	4	G	0,8	6,0	0,8	50,0	5,6	0,76	0,4	10,02	2	■
JMB562010G4B.0Z2-SIRA	03171274	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	2	■
JMB562012G4B.0Z2-SIRA	03171275	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	2	■
JMB562015G4B.0Z2-SIRA	03171276	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	2	■
JMB562020G4B.0Z2-SIRA	03171277	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	2	■
JMB562030G4B.0Z2-SIRA	03171279	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	2	■
JMB562005G5B.0Z2-SIRA	03171280	5	G	0,5	6,0	0,5	50,0	5,0	0,46	0,25	10,54	2	■
JMB562006G5B.0Z2-SIRA	03171281	5	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	9,85	2	■
JMB562008G5B.0Z2-SIRA	03171282	5	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	8,64	2	■
JMB562010G5B.0Z2-SIRA	03171283	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,63	2	■
JMB562012G5B.0Z2-SIRA	03171284	5	G	1,2	6,0	1,2	50,0	12,0	1,15	0,6	6,77	2	■
JMB562015G5B.0Z2-SIRA	03171285	5	G	1,5	6,0	1,5	60,0	15,0	1,45	0,75	5,68	2	■
JMB562020G5B.0Z2-SIRA	03171287	5	G	2,0	6,0	2,0	60,0	20,0	1,94	1,0	4,32	2	■
JMB562030G5B.0Z2-SIRA	03171289	5	G	3,0	6,0	3,0	70,0	30,0	2,85	1,5	2,5	2	■

■ Stocked standard.

JMB562

Miniature – Universal – Ball nose – 2 Flutes – DMM 6 – Cylindrical



G

- Tolerances:
- Run-out=<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JMB562010G6B.0Z2-SIRA	03171290	6	G	1,0	6,0	1,0	60,0	15,0	0,95	0,5	6,04	2	■
JMB562012G6B.0Z2-SIRA	03171291	6	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	5,24	2	■
JMB562015G6B.0Z2-SIRA	03171292	6	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	4,28	2	■
JMB562020G6B.0Z2-SIRA	03171293	6	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	3,14	2	■
JMB562030G6B.0Z2-SIRA	03171295	6	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	1,74	2	■
JMB562010G7B.0Z2-SIRA	03171296	7	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	4,99	2	■
JMB562012G7B.0Z2-SIRA	03171297	7	G	1,2	6,0	1,2	80,0	24,0	1,15	0,6	4,27	2	■
JMB562015G7B.0Z2-SIRA	03171298	7	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	3,43	2	■
JMB562020G7B.0Z2-SIRA	03171299	7	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2,47	2	■
JMB562030G7B.0Z2-SIRA	03171301	7	G	3,0	6,0	3,0	100,0	60,0	2,85	1,5	1,34	2	■

■ Stocked standard.

Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

Cutting data – JMB562 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	365 (330 — 400)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1200 (1100 — 1300)*
P2	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	355 (320 — 390)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1175 (1100 — 1200)*
P3	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	305 (280 — 330)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1000 (920 — 1100)*
P4	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	270 (240 — 290)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*890 (790 — 950)*
P5	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
P6	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (260 — 310)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (860 — 1000)*
P7	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	270 (250 — 300)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*890 (830 — 980)*
P8	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	255 (230 — 280)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*840 (760 — 910)*
P11	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	265 (240 — 290)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*870 (790 — 950)*
P12	M/E/A	0.0500	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	155 (140 — 170)
		0,0500	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*510 (460 — 550)*
M1	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	215 (180 — 250)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*710 (600 — 820)*
M2	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 200)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 650)*
M3	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 200)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 650)*
M4	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	130 (110 — 150)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*425 (370 — 490)*
M5	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	110 (90 — 120)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*360 (300 — 390)*
N1	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	485 (430 — 540)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1600 (1500 — 1700)*
N2	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	485 (430 — 540)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1600 (1500 — 1700)*
N3	E/M/A	0.100	0.75	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	325 (290 — 360)
		0,100	*0,75*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1075 (960 — 1100)*
N11	E/M/A	0.100	0.75	0.0050	0.0075	0.010	0.012	0.015	0.020	0.025	0.030	0.046	0.050	0.060	0.075	430 (370 — 480)
		0,100	*0,75*	*0,00020*	*0,00030*	*0,00040*	*0,00048*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0018*	*0,0020*	*0,0024*	*0,0030*	*1400 (1300 — 1500)*
S11	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	290 (250 — 330)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*950 (830 — 1000)*
S12	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	225 (200 — 250)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*740 (660 — 820)*
S13	E/M/A	0.0250	0.60	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	175 (150 — 190)
		0,0250	*0,60*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*570 (500 — 620)*
H3	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H5	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.032	0.036	0.044	0.055	120 (90 — 140)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*395 (300 — 450)*
H8	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H11	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	300 (270 — 330)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*980 (890 — 1000)*
H12	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	275 (240 — 300)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*900 (790 — 980)*
H21	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	235 (210 — 260)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*770 (690 — 850)*
H31	M/A	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	180 (160 — 200)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*590 (530 — 650)*
GR1	A	0.500	0.50	0.0030	0.0044	0.0060	0.0075	0.0090	0.012	0.015	0.018	0.028	0.030	0.038	0.040	405 (350 — 460)
		0,500	*0,50*	*0,00012*	*0,00017*	*0,00024*	*0,00030*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,0011*	*0,0012*	*0,0015*	*0,0016*	*1325 (1200 — 1500)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JMB562 Slot milling

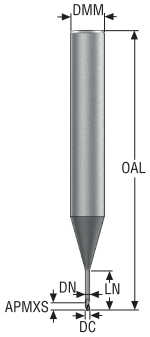
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (300 — 390)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (990 — 1200)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	105 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*345 (310 — 390)*
H3	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 390)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1200)*

Table based on LV1, please recalc based on length version chosen. See page(s) 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JMB563

Miniature – Universal – Ball nose – 3 Flutes – DMM 6 – Cylindrical



G

- Tolerances:
- Run-out=<0,007 mm
- DMM= h5
- DC= 0,-0,02 mm
- RE= ±0,01 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JMB563010G2B.0Z3-SIRA	03171307	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	11,15	3	■
JMB563012G2B.0Z3-SIRA	03171308	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	3	■
JMB563015G2B.0Z3-SIRA	03171309	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	3	■
JMB563020G2B.0Z3-SIRA	03171310	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	3	■
JMB563025G2B.0Z3-SIRA	03171311	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	3	■
JMB563030G2B.0Z3-SIRA	03171312	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	3	■
JMB563010G4B.0Z3-SIRA	03171316	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	3	■
JMB563012G4B.0Z3-SIRA	03171317	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	3	■
JMB563015G4B.0Z3-SIRA	03171318	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	3	■
JMB563020G4B.0Z3-SIRA	03171319	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	3	■
JMB563030G4B.0Z3-SIRA	03171321	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	3	■

■ Stocked standard.

Cutting data – JMB563 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z						v_c
				1	1.2	1.5	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	460 (410 — 500) *1500 (1400 — 1600)*
P2	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	445 (400 — 490) *1450 (1400 — 1600)*
P3	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200 — 1300)*
P4	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 370) *1125 (1100 — 1200)*
P5	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960 — 1100)*
P6	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P7	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 380) *1125 (1100 — 1200)*
P8	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960 — 1100)*
P11	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	230 (190 — 270) *750 (630 — 880)*
P12	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
M1	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (230 — 320) *890 (760 — 1000)*
M2	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M3	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M4	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	165 (140 — 190) *540 (460 — 620)*
M5	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
N1	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N2	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N3	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (350 — 440) *1300 (1200 — 1400)*
N11	E/M/A	0.100 *0,100*	0.65 *0,65*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	520 (450 — 590) *1700 (1500 — 1900)*
S11	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (300 — 390) *1125 (990 — 1200)*
S12	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (230 — 300) *870 (760 — 980)*
S13	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (180 — 230) *670 (600 — 750)*
H3	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120 — 190) *510 (400 — 620)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H7	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120 — 190) *510 (400 — 620)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	375 (330 — 420) *1225 (1100 — 1300)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (310 — 380) *1125 (1100 — 1200)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	450 (390 — 510) *1475 (1300 — 1600)*

Table based on LV1, please recalc based on length version chosen. See page(s)

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

STEEL AND CAST IRON

Seco offers a complete range of high performance solid carbide square shoulder end mills, ballnose cutters and finish end mills for high productivity in steel and cast iron.

- JHP993, JHP951 and JH142 for chamfer or radius type.
- JHB970, JH112, JH150, JH160 for ball-nose type.

Tool selection Steel and cast iron

Name		JHP993	JHP951	JH142	JHB970
Page(s)		193	199	203, 395	145, 206
Family name		HPM	HPM	HSM/TORNADO	HSM/TORNADO
Type of mill					
Shank	Cylindrical	■	■	■	■
	Weldon	■	■		
Number of Flutes		3,4,5	3,4,5	2-4-5-6	2
ICC					
Diameter range	Metric	4-25	3-20	2-12	2-16
	Inch				
Length availability		2,3	2	2,3,6	1,2,3
Operation					
SMG					
P1		●	●	●	●
P2		●	●	●	●
P3		●	●	●	●
P4		●	●	●	●
P5		●	●	●	●
P6		●	●	●	●
P7		●	●	●	●
P8		●	●	●	●
P11-12		○	○	●	○
K1		●	●	●	
K2		●	●	●	
K3		●	●	●	
K4		●	●	●	
K5		●	●	●	
K6		●	●	●	
K7		●	●	●	

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

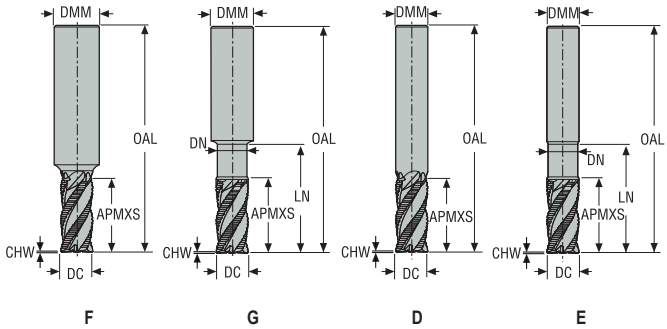
Tool selection Steel and cast iron

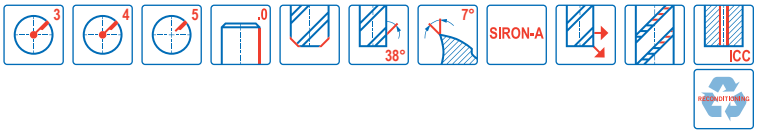
Name		JH112	JH150	JH160
Page(s)		208, 398	401	403
Family name		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Type of mill				
Shank	Cylindrical	■	■	■
	Weldon			
Number of Flutes		2	4	4
ICC				
Diameter range	Metric	2-12	6-12	3-12
	Inch			
Length availability		1,2,3,4,5,6	2	2
Operation				
SMG				
P1				●
P2				●
P3				●
P4				●
P5				●
P6				●
P7				●
P8				●
P11-12				○
K1		●	●	
K2		●	●	
K3		●	●	
K4		●	●	
K5		●	●	
K6		●	●	
K7		●	●	

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

JHP993

High performance – Steel – Square – 3-5 Flutes – Cylindrical – Chamfer





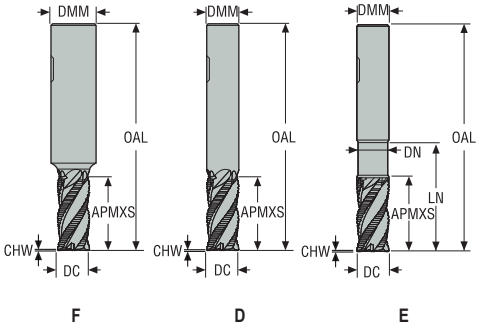
- Tolerances:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JHP993040F2C.0Z3-SIRA	02826806	2	F	–	4,0	6,0	10,0	50,0	12,56	4,0	0,15	3	■
JHP993050F2C.0Z4-SIRA	02826808	2	F	–	5,0	6,0	12,0	55,0	14,75	5,0	0,15	4	■
JHP993060D2C.0Z4-SIRA	02826809	2	D	–	6,0	6,0	14,0	55,0	–	–	0,2	4	■
JHP993075F2C.0Z4-SIRA	02826811	2	F	–	7,5	8,0	17,0	60,0	20,0	7,5	0,2	4	■
JHP993080D2C.0Z4A-SIRA	02826814	2	D	■	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993080D2C.0Z4-SIRA	02826812	2	D	–	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993095F2C.0Z4-SIRA	02826816	2	F	–	9,5	10,0	20,0	70,0	23,0	9,5	0,2	4	■
JHP993100D2C.0Z4A-SIRA	02826818	2	D	■	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993100D2C.0Z4-SIRA	02826817	2	D	–	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993115F2C.0Z4-SIRA	02826820	2	F	–	11,5	12,0	25,0	80,0	28,0	11,5	0,2	4	■
JHP993120D2C.0Z4A-SIRA	02826822	2	D	■	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993120D2C.0Z4-SIRA	02826821	2	D	–	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993140D2C.0Z4-SIRA	02826824	2	D	–	14,0	14,0	30,0	80,0	–	–	0,3	4	■
JHP993160D2C.0Z4A-SIRA	02856501	2	D	■	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.0Z4-SIRA	02856499	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.0Z5-SIRA	02826825	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	5	■
JHP993200D2C.0Z4A-SIRA	02856506	2	D	■	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.0Z4-SIRA	02856505	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.0Z5-SIRA	02826828	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	5	■
JHP993250D2C.0Z4A-SIRA	02856510	2	D	■	25,0	25,0	52,0	125,0	–	–	0,5	4	■
JHP993040G3C.0Z3-SIRA	02826807	3	G	–	4,0	6,0	10,0	55,0	15,0	3,7	0,15	3	■
JHP993060E3C.0Z4-SIRA	02826810	3	E	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	■
JHP993080E3C.0Z4-SIRA	02826815	3	E	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	■
JHP993100E3C.0Z4-SIRA	02826819	3	E	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	■
JHP993120E3C.0Z4-SIRA	02826823	3	E	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	■
JHP993160E3C.0Z4-SIRA	02856502	3	E	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	■
JHP993200E3C.0Z4-SIRA	02856507	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	■

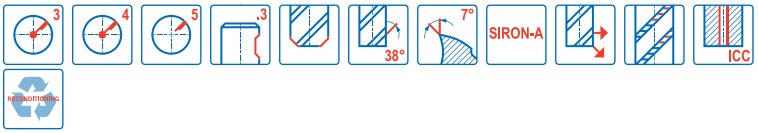
■ Stocked standard.

JHP993

High performance – Steel – Square – 3-5 Flutes – Weldon – Chamfer



- Tolerances:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Regrind possible if DC is ≥Ø6



Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP993040F2C.3Z3-SIRA	02828150	2	F	–	4,0	6,0	10,0	50,0	12,56	4,0	0,15	3	■
JHP993050F2C.3Z4-SIRA	02828152	2	F	–	5,0	6,0	12,0	55,0	14,75	5,0	0,15	4	■
JHP993060D2C.3Z4-SIRA	02828153	2	D	–	6,0	6,0	14,0	55,0	–	–	0,2	4	■
JHP993075F2C.3Z4-SIRA	02828155	2	F	–	7,5	8,0	17,0	60,0	20,0	7,5	0,2	4	■
JHP993080D2C.3Z4A-SIRA	02828246	2	D	■	8,0	8,0	16,0	60,0	–	–	0,2	4	□
JHP993080D2C.3Z4-SIRA	02828156	2	D	–	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993095F2C.3Z4-SIRA	02828158	2	F	–	9,5	10,0	20,0	70,0	23,0	9,5	0,2	4	■
JHP993100D2C.3Z4A-SIRA	02828247	2	D	■	10,0	10,0	22,0	70,0	–	–	0,2	4	□
JHP993100D2C.3Z4-SIRA	02828159	2	D	–	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993120D2C.3Z4A-SIRA	02828248	2	D	■	12,0	12,0	26,0	80,0	–	–	0,2	4	□
JHP993120D2C.3Z4-SIRA	02828162	2	D	–	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993140D2C.3Z4-SIRA	02828164	2	D	–	14,0	14,0	30,0	80,0	–	–	0,3	4	■
JHP993160D2C.3Z4A-SIRA	02856512	2	D	■	16,0	16,0	34,0	90,0	–	–	0,3	4	□
JHP993160D2C.3Z4-SIRA	02856500	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.3Z5-SIRA	02828165	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	5	■
JHP993200D2C.3Z4A-SIRA	02856513	2	D	■	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.3Z4-SIRA	02856504	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.3Z5-SIRA	02828167	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	5	■
JHP993250D2C.3Z4A-SIRA	02856514	2	D	■	25,0	25,0	52,0	125,0	–	–	0,5	4	□
JHP993250D2C.3Z4-SIRA	02856509	2	D	–	25,0	25,0	52,0	125,0	–	–	0,5	4	■
JHP993060E3C.3Z4-SIRA	02828154	3	E	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	■
JHP993080E3C.3Z4-SIRA	02828157	3	E	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	■
JHP993100E3C.3Z4-SIRA	02828160	3	E	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	■
JHP993120E3C.3Z4-SIRA	02828163	3	E	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	■
JHP993160E3C.3Z4-SIRA	02856503	3	E	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	■
JHP993200E3C.3Z4-SIRA	02856508	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	■
JHP993200E3C.3Z5-SIRA	02828168	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	5	■
JHP993250E3C.3Z4-SIRA	02856511	3	E	–	25,0	25,0	52,0	150,0	90,0	24,0	0,5	4	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

Cutting data – JHP993 Side milling PCEDC=3 and PCEDC=4

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	175 (150 — 190) *570 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	165 (150 — 190) *540 (500 — 620)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	110 (95 — 120) *360 (320 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	200 (180 — 220) *660 (600 — 720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	170 (150 — 190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	100 (86 — 110) *330 (290 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	125 (110 — 140) *410 (370 — 450)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JHP993 Side milling PCEDC=5

SMG		a_e/DC	a_p/DC	f_z		v_c
				16	20	
P1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.22 *0,0085*	205 (180 — 230) *670 (600 — 750)*
P2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	165 (150 — 180) *540 (500 — 590)*
P7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140 — 170) *510 (460 — 550)*
P8	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A	0.376 *0,376*	1.0 *1,0*	0.11 *0,0044*	0.13 *0,0050*	100 (85 — 110) *330 (280 — 360)*
K1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	175 (160 — 200) *570 (530 — 650)*
K3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130 — 170) *490 (430 — 550)*
K4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
K5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	85 (75 — 99) *280 (250 — 320)*
K6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	110 (96 — 120) *360 (320 — 390)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JHP993 Slot milling PCEDC=3 and PCEDC=4

SMG		a_p/DC	f_z										v_c
			4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	200 (180 — 220)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*660 (600 — 720)*
P2	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	195 (170 — 220)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*640 (560 — 720)*
P3	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	165 (150 — 190)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*540 (500 — 620)*
P4	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	145 (130 — 160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*475 (430 — 520)*
P5	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	140 (130 — 160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*460 (430 — 520)*
P6	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	155 (140 — 170)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*510 (460 — 550)*
P7	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	150 (130 — 160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*490 (430 — 520)*
P8	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	140 (130 — 160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*460 (430 — 520)*
P11	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	145 (130 — 160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*475 (430 — 520)*
P12	E/M/A	1.5	0.028	0.034	0.040	0.055	0.070	0.080	0.090	0.10	0.12	0.13	90 (76 — 100)
		1,5	*0,0011*	*0,0013*	*0,0016*	*0,0022*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0048*	*0,0050*	*295 (250 — 320)*
K1	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	195 (170 — 220)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*640 (560 — 720)*
K2	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	170 (150 — 190)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*560 (500 — 620)*
K3	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	145 (130 — 160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*475 (430 — 520)*
K4	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	135 (120 — 150)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*445 (400 — 490)*
K5	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.15	0.17	80 (70 — 93)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0060*	*0,0065*	*260 (230 — 300)*
K6	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	120 (110 — 130)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*395 (370 — 420)*
K7	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.15	0.17	105 (90 — 110)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0060*	*0,0065*	*345 (300 — 360)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JHP993 Slot milling PCEDC=5

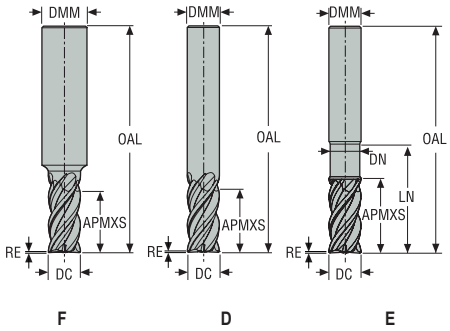
SMG		a_p/DC	f_z		v_c
			16	20	
P1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
P2	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	155 (140 — 170) *510 (460 — 550)*
P3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (99 — 130) *375 (330 — 420)*
P6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	130 (120 — 140) *425 (400 — 450)*
P7	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
P8	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	115 (99 — 130) *375 (330 — 420)*
P11	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
P12	E/M/A	0.44 *0,44*	0.11 *0,0044*	0.13 *0,0050*	80 (68 — 89) *260 (230 — 290)*
K1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	140 (120 — 150) *460 (400 — 490)*
K3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
K4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (97 — 120) *375 (320 — 390)*
K5	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	70 (60 — 79) *230 (200 — 250)*
K6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	90 (77 — 100) *295 (260 — 320)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHP951

High performance – Square – Steel – 3-5 Flutes – Cylindrical – Corner radius or chamfer



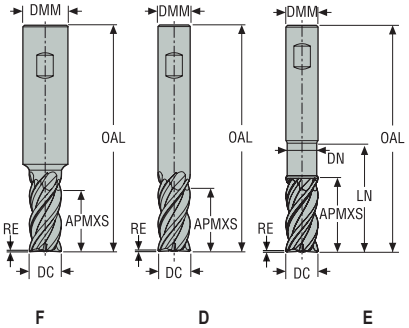
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm		
JHP951030F2C.0Z3-SIRA	02828192	2	F	3,0	6,0	8,0	50,0	10,25	3,0	0,1	–	3	■
JHP951030F2R020.0Z3-SIRA	02828191	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,2	3	■
JHP951030F2R050.0Z3-SIRA	02828190	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,5	3	■
JHP951040F2C.0Z4-SIRA	02828197	2	F	4,0	6,0	10,0	55,0	13,25	4,0	0,15	–	4	■
JHP951040F2R020.0Z4-SIRA	02828194	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,2	4	■
JHP951040F2R050.0Z4-SIRA	02828195	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,5	4	■
JHP951050F2C.0Z4-SIRA	02828201	2	F	5,0	6,0	12,0	55,0	15,25	5,0	0,2	–	4	■
JHP951050F2R020.0Z4-SIRA	02828199	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,2	4	■
JHP951050F2R050.0Z4-SIRA	02828198	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,5	4	■
JHP951060D2C.0Z4-SIRA	02828205	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	■
JHP951060D2R020.0Z4-SIRA	02828203	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	■
JHP951060D2R050.0Z4-SIRA	02828202	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	■
JHP951080D2C.0Z4-SIRA	02828212	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	■
JHP951080D2R020.0Z4-SIRA	02828209	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	■
JHP951080D2R050.0Z4-SIRA	02828207	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	■
JHP951080D2R100.0Z4-SIRA	02828208	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	■
JHP951100E2C.0Z4-SIRA	02828218	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	■
JHP951100E2R050.0Z4-SIRA	02828216	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	■
JHP951100E2R100.0Z4-SIRA	02828214	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	■
JHP951120E2C.0Z4-SIRA	02828226	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	■
JHP951120E2R050.0Z4-SIRA	02828224	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	■
JHP951120E2R100.0Z4-SIRA	02828222	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	■
JHP951160E2C.0Z4-SIRA	02927873	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	■
JHP951160E2C.0Z5-SIRA	02828232	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	■
JHP951160E2R050.0Z4-SIRA	02927875	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	■
JHP951160E2R050.0Z5-SIRA	02828230	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	■
JHP951160E2R100.0Z4-SIRA	02927876	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	■
JHP951160E2R100.0Z5-SIRA	02828231	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	■

■ Stocked standard.

JHP951

High performance – Square – Steel – 3-5 Flutes – Weldon – Corner radius or chamfer



- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JHP951030F2C.3Z3-SIRA	02828193	2	F	3,0	6,0	8,0	50,0	10,25	3,0	0,1	–	3	■
JHP951030F2R020.3Z3-SIRA	02828260	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,2	3	■
JHP951030F2R050.3Z3-SIRA	02828259	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,5	3	□
JHP951040F2C.3Z4-SIRA	02828196	2	F	4,0	6,0	10,0	55,0	13,25	4,0	0,15	–	4	■
JHP951040F2R020.3Z4-SIRA	02828261	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,2	4	□
JHP951040F2R050.3Z4-SIRA	02828262	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,5	4	□
JHP951050F2C.3Z4-SIRA	02828200	2	F	5,0	6,0	12,0	55,0	15,25	5,0	0,2	–	4	■
JHP951050F2R020.3Z4-SIRA	02828264	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,2	4	□
JHP951050F2R050.3Z4-SIRA	02828263	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,5	4	□
JHP951060D2C.3Z4-SIRA	02828206	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	■
JHP951060D2R020.3Z4-SIRA	02828266	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	□
JHP951060D2R050.3Z4-SIRA	02828265	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	□
JHP951080D2C.3Z4-SIRA	02828210	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	■
JHP951080D2R020.3Z4-SIRA	02828269	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	□
JHP951080D2R050.3Z4-SIRA	02828267	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	■
JHP951080D2R100.3Z4-SIRA	02828268	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	□
JHP951100E2C.3Z4-SIRA	02828220	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	■
JHP951100E2R050.3Z4-SIRA	02828271	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	□
JHP951100E2R100.3Z4-SIRA	02828270	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	□
JHP951120E2C.3Z4-SIRA	02828228	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	■
JHP951120E2R050.3Z4-SIRA	02828273	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	□
JHP951120E2R100.3Z4-SIRA	02828272	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	□
JHP951160E2C.3Z4-SIRA	02927874	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	■
JHP951160E2C.3Z5-SIRA	02828233	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	■
JHP951160E2R050.3Z4-SIRA	02927879	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	□
JHP951160E2R050.3Z5-SIRA	02828275	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	□
JHP951160E2R100.3Z4-SIRA	02927880	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	□
JHP951160E2R100.3Z5-SIRA	02828276	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	□
JHP951200E2R050.3Z4-SIRA	02927877	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	0,5	4	■
JHP951200E2R050.3Z5-SIRA	02828235	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	0,5	5	■
JHP951200E2R100.3Z4-SIRA	02927878	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	1,0	4	■
JHP951200E2R100.3Z5-SIRA	02828234	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	1,0	5	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

Cutting data – JHP951 Side milling

SMG		a_e/DC	a_p/DC	f_z									v_c
				3	4	5	6	8	10	12	16	20	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	220 (200 — 250) *720 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	170 (150 — 190) *560 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	175 (150 — 190) *570 (500 — 620)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	110 (94 — 120) *360 (310 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	200 (180 — 220) *660 (600 — 720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	100 (85 — 110) *330 (280 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 160) *460 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	125 (110 — 140) *410 (370 — 450)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JHP951 Slot milling

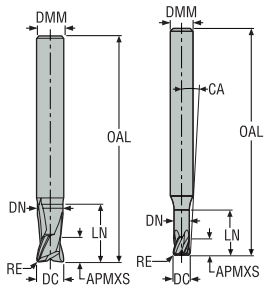
SMG		a_p/DC	f_z									v_c
			3	4	5	6	8	10	12	16	20	
P1	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	195 (170 — 220)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*640 (560 — 720)*
P2	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	190 (170 — 210)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*620 (560 — 680)*
P3	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	165 (150 — 180)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*540 (500 — 590)*
P4	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	145 (130 — 160)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*475 (430 — 520)*
P5	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	140 (120 — 150)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*460 (400 — 490)*
P6	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	155 (140 — 170)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*510 (460 — 550)*
P7	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	145 (130 — 160)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*475 (430 — 520)*
P8	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	140 (120 — 150)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*460 (400 — 490)*
P11	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	145 (130 — 160)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*475 (430 — 520)*
P12	E/M/A	1.5	0.020	0.028	0.034	0.040	0.055	0.070	0.080	0.10	0.12	85 (75 — 99)
		1,5	*0,00080*	*0,0011*	*0,0013*	*0,0016*	*0,0022*	*0,0028*	*0,0032*	*0,0040*	*0,0048*	*280 (250 — 320)*
K1	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	195 (170 — 220)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*640 (560 — 720)*
K2	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	170 (150 — 190)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*560 (500 — 620)*
K3	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	140 (130 — 160)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*460 (430 — 520)*
K4	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	135 (120 — 150)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*445 (400 — 490)*
K5	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.15	80 (70 — 92)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0060*	*260 (230 — 300)*
K6	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.16	120 (110 — 130)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0065*	*395 (370 — 420)*
K7	E/M/A	1.5	0.024	0.032	0.040	0.048	0.065	0.080	0.095	0.13	0.15	105 (89 — 110)
		1,5	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0050*	*0,0060*	*345 (300 — 360)*

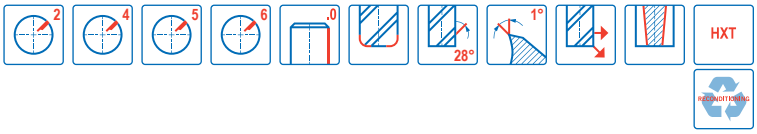
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH142

High speed – High precision – Torical – Hardened steel – 2-6 Flutes – Cylindrical – Corner radius





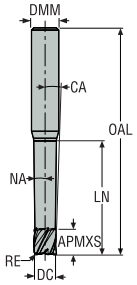
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	■

■ Stocked standard.

JH142

High speed – High precision – Torical – Hardened steel – 2-5 Flutes – Cylindrical – Corner radius



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- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	2	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	4	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	2	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	4	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	2	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	4	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	2	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	4	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	2	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	4	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	2	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	4	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	2	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	4	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	4	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	5	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	4	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	5	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	5	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	5	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	5	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	5	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	5	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	5	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	5	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	5	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	5	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	4	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	4	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	4	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	4	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	4	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	4	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	4	■

■ Stocked standard.

Cutting data – JH142 Copy milling roughing

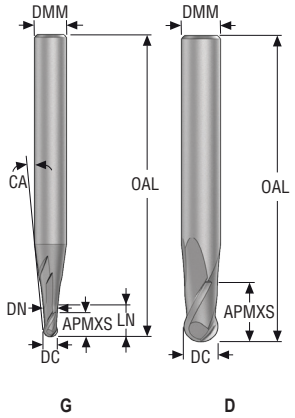
SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600 — 1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500 — 1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300 — 1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200 — 1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300 — 1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200 — 1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100 — 1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200 — 1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960 — 1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600 — 1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400 — 1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960 — 1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200 — 1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100 — 1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120 — 160) *460 (400 — 520)*

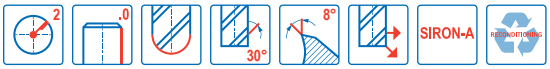
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHB970

High speed – Universal – Ball nose – 2 Flutes – Cylindrical





- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm			
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	2,5	2	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	–	2	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	–	2	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	–	2	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	–	2	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	8,0	2	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	7,5	2	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	5,5	2	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	4,5	2	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	3,0	2	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,0	2	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	2,5	2	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	–	2	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	–	2	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	–	2	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	–	2	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	8,0	2	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	5,5	2	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	3,0	2	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	2,5	2	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	–	2	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	–	2	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	–	2	■

■ Stocked standard.

Cutting data – JHB970 Copy milling roughing

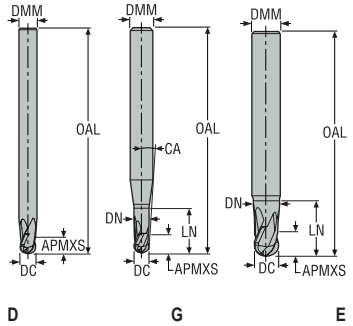
SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630 — 750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600 — 750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140 — 170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140 — 170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80 — 100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55 — 75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140 — 180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120 — 150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140 — 190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66 — 120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

For cutting data recalculations, see pages 573 - 580

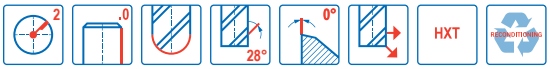
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH112

High speed – High precision – Hardened steel – Ball nose – 2 Flutes – Cylindrical



- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

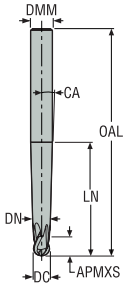


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm			
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	6,45	2	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	3,3	2	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	–	2	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,0	2	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	–	2	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	–	2	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	–	2	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	2,5	2	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	–	2	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	–	2	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	–	2	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	–	2	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	8,12	2	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	7,39	2	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	5,5	2	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	3,81	2	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	3,34	2	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,0	2	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	2,78	2	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	–	2	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	–	2	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	–	2	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	3,82	2	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	2,91	2	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	1,97	2	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	0,53	2	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	–	2	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	–	2	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	–	2	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	–	2	■

■ Stocked standard.

JH112

High speed – High precision – Hardened steel – Ball nose – 2 Flutes – Cylindrical



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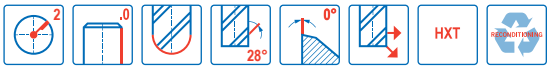


- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm			
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	3,3	2	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	2,2	2	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	1,2	2	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	1,6	2	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	1,1	2	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	1,0	2	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	1,0	2	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	2,0	2	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	1,8	2	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	0,8	2	■

■ Stocked standard.

Cutting data – JH112 Copy milling finishing

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500 — 730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200 — 1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200 — 1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560 — 790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990 — 1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920 — 1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960 — 1400)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JH112 Copy milling roughing

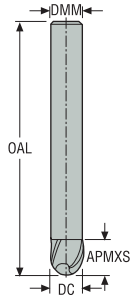
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890 — 1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760 — 1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730 — 1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830 — 1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200 — 1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560 — 780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

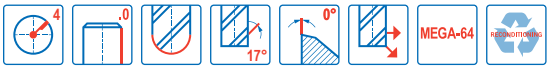
JH150

High speed – Hardened steel – Ball nose – 4 Flutes – Cylindrical



D

- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	4	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	4	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	4	■

■ Stocked standard.

Cutting data – JH150 Copy milling roughing

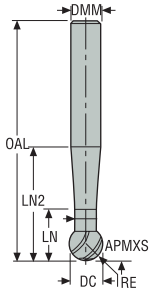
SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100 — 1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890 — 1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890 — 1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300 — 1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200 — 1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630 — 750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130 — 180) *410 (430 — 590)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

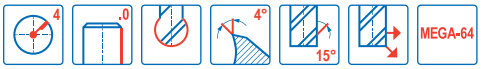
JH160

High speed – Hardened steel – Ball nose – 4 Flutes – Cylindrical



E

- Tolerances:
- DMM= h5
- DC= 0,02/-0,06 mm
- SA=250°



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm		
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	9,0	1,8	1,5	4	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	11,0	2,4	2,0	4	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	13,0	3,0	2,5	4	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	17,3	3,6	3,0	4	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	21,3	4,8	4,0	4	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	27,9	6,0	5,0	4	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	31,8	7,2	6,0	4	■

■ Stocked standard.

Cutting data – JH160 Copy milling finishing

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450 — 700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300 — 1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200 — 1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200 — 1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200 — 1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100 — 1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400 — 1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200 — 1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

STAINLESS AND S-MATERIALS

Seco offers a complete range of high performance solid carbide square shoulder end mills, ballnose cutters and finish end mills for high productivity in stainless steel and ISO S-materials.

- JS754, JS755, JS720, JHP751, JHP760, JHP770, JHP780, JHP794, JCG790, JH770, JH740, JH710, JH790, JH730, JHP994, SHF712, SME714, SME716 and JCO710 for chamfer or radius type.
- JS730, JH780, JHB720, JH721, JH722, SMB713, SMB714 and SMB716 for ball-nose type.
- JH724, JH726, JH734, JH736, JH744, JH746 for barrel type.

Tool selection Stainless and S-materials

Name		JS754	JS755	JS720	JS730	JHP751	JHP760	JHP770
Page(s)		221	238	249	269	273	276	280
Family name		SOLID²	SOLID²	SOLID²	SOLID²	HPM	HPM	HPM
Type of mill								
Shank	Cylindrical	■	■	■	■	■	■	■
	Weldon	■	■	■	□	■	■	■
	Safelock	□	□	□	□			□
Number of Flutes		4	5	6-9	6	2-4	2,3,4	4-5
ICC		■					■	■
Diameter range	Metric	3-25	6-25	6-25	6-25	2-20	4-25	6-25
	Inch							
Length availability		2,3	2,3	2,3	2,3	1,2	2,3	2
Operation								
SMG								
M1		●	●	●	●		●	
M2		●	●	●	●		●	
M3		●	●	●	●		●	
M4		●	●	●	●		●	
M5		●	●	●	●		●	
S1		●	●	●	●	●		
S2		●	●	●	●	●		
S3		●	●	●	●	●		
S11		●	●	●	●	●		●
S12		●	●	●	●	●		●
S13		●	●	●	●	●		●

■ Stock standard □ Weldon available, delivery time is 3 days. □ Safe-Lock available, delivery time is 6 days
● Preferred choice ○ Alternative choice

Tool selection Stainless and S-materials

Name		JHP780	JHP794	JCG790	JH724	JH726	JH734	JH736	JH744	JH746
Page(s)		287	292	294	296	298	300	302	304	306
Family name		HPM	HPM	Ceramic	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO
Type of mill										
Shank	Cylindrical	■		■	■	■	■	■	■	■
	Weldon	■	■							
	Safelock	□								
Number of Flutes		4	4	5-6	6	6	4	6	4	6
ICC		■	■						■	■
Diameter range	Metric	6-25	6-25	6-25	10	10	6-16	10-16	4-16	10-16
	Inch									
Length availability		2	2	2	2	2	2	2	2,4	2
Operation										
SMG										
M1			●		●	●	●	●	●	●
M2			●		●	●	●	●	●	●
M3			●		●	●	●	●	●	●
M4			●		●	●				
M5			●		●	●				
S1		●		●	●	●				
S2		●		●	●	●				
S3		●		●	●	●				
S11					●	●	●	●	●	●
S12					●	●	●	●	●	●
S13					●	●	●	●	●	●

■ Stock standard □ Weldon available, delivery time is 3 days. □ Safe-Lock available, delivery time is 6 days
● Preferred choice ○ Alternative choice

Tool selection Stainless and S-materials

Name		JH770	JH740	JH710	JH790	JH730	JHP994	JH780
Page(s)		308	304	312	314	316	318	320
Family name		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HPM	HSM/TORNADO
Type of mill		r	r	r	r	r	45°	
Shank	Cylindrical	■	■	■	■	■	■	■
	Weldon							
	Safelock							
Number of Flutes		3,4,5,6	4-5	5	6	5,6,7	4	4
ICC								
Diameter range	Metric	3-10	6-10	6-8	9,5	6-10	6-10	1,83-4,89
	Inch							
Length availability		2	2	2	2,3	2	3	2
Operation								
SMG								
M1								
M2								
M3								
M4								
M5								
S1								
S2		●	●	●	●	●	●	●
S3								
S11		●	●	●	●	●	●	
S12		●	●	●	●	●	●	●
S13								

■ Stock standard ☐ Weldon available, delivery time is 3 days. ☐ Safe-Lock available, delivery time is 6 days
● Preferred choice ○ Alternative choice

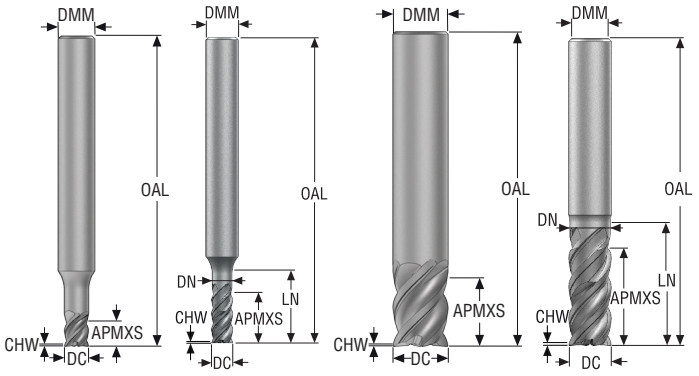
Tool selection Stainless and S-materials

Name		JHB720	JH721	JH722	SHF712	SME714/716	SMB713/714/416
Page(s)		322	324	326	328	330	178
Family name		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM	MINI	MINI
Type of mill							
Shank	Cylindrical	■	■	■	■	■	■
	Weldon						
	Safelock						
Number of Flutes		3	6	6	3-4-5	3-4-5	4
ICC							
Diameter range	Metric	2-16	6-8	10	3-6	0,5-2	0,3-3
	Inch						
Length availability		2	2	2	1,2,3,4	1,2,3,4	2,4
Operation							
SMG							
M1		●					
M2		●					
M3		●					
M4		●					
M5		●					
S1		○					
S2		○	●	●	●	●	●
S3		○					
S11		●	●	●			
S12		●	●	●	●	●	●
S13		●					

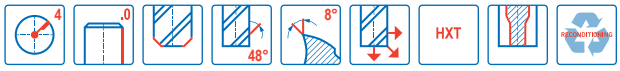
■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Cylindrical – Chamfer



F G D E



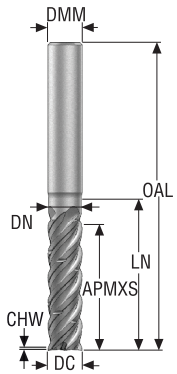
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS754030F1C.0Z4-HXT	10165556	1	F	3,0	6,0	4,0	50,0	6,0	3,05	0,035	4	■
JS754040F1C.0Z4-HXT	10164855	1	F	4,0	6,0	6,0	50,0	9,0	4,05	0,045	4	■
JS754050F1C.0Z4-HXT	10165557	1	F	5,0	6,0	7,0	50,0	10,0	5,05	0,055	4	■
JS754060D1C.0Z4-HXT	10164856	1	D	6,0	6,0	8,0	50,0	–	–	0,075	4	■
JS754080D1C.0Z4-HXT	10164857	1	D	8,0	8,0	11,0	58,0	–	–	0,1	4	■
JS754100D1C.0Z4-HXT	10164858	1	D	10,0	10,0	13,0	58,0	–	–	0,125	4	■
JS754120D1C.0Z4-HXT	10164859	1	D	12,0	12,0	15,0	67,0	–	–	0,15	4	■
JS754160D1C.0Z4-HXT	10164860	1	D	16,0	16,0	19,0	73,0	–	–	0,2	4	■
JS754030G2C.0Z4-HXT	03186807	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	4	■
JS754040G2C.0Z4-HXT	03186808	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4	■
JS754050G2C.0Z4-HXT	03186809	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	4	■
JS754060E2C.0Z4-HXT	03186810	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.0Z4-HXT	03186811	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.0Z4-HXT	03186812	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.0Z4-HXT	03186813	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.0Z4-HXT	03186814	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.0Z4-HXT	03186815	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■
JS754250E2C.0Z4-HXT	03186816	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	■
JS754060E3C.0Z4-HXT	03186823	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.0Z4-HXT	03186824	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.0Z4-HXT	03186825	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.0Z4-HXT	03186826	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.0Z4-HXT	03186827	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.0Z4-HXT	03186828	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■
JS754250E3C.0Z4-HXT	03186829	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	■

■ Stocked standard.

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Cylindrical – Chamfer – Chip splitters



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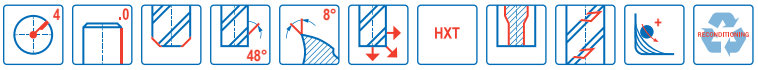


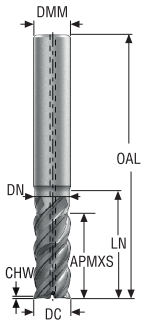
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.0Z4C-HXT	03186817	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.0Z4C-HXT	03186818	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754060E3C.0Z4C-HXT	03200550	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.0Z4C-HXT	03200551	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.0Z4C-HXT	03186830	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.0Z4C-HXT	03186831	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.0Z4C-HXT	03186832	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.0Z4C-HXT	03186833	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■

■ Stocked standard.

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Cylindrical – Chamfer – ICC



E

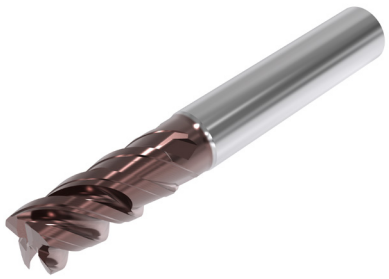
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible

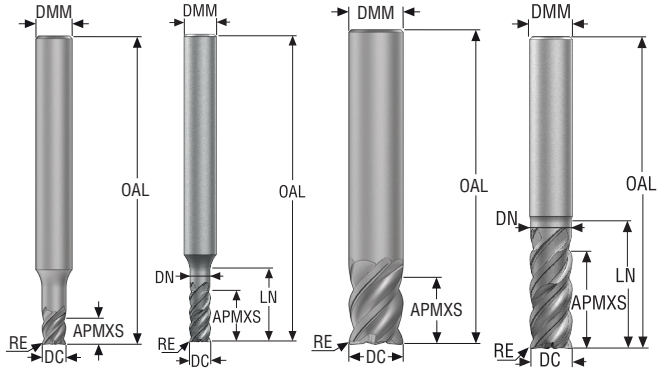
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.0Z4A-HXT	03186834	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.0Z4A-HXT	03186835	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.0Z4A-HXT	03186836	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.0Z4A-HXT	03186837	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.0Z4A-HXT	03186838	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.0Z4A-HXT	03186839	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■

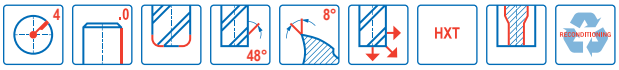
■ Stocked standard.

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Cylindrical – Corner radius







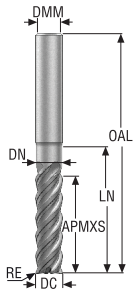
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS754030F1R020.0Z4-HXT	10165558	1	F	3,0	6,0	4,0	50,0	6,0	3,05	0,2	4	■
JS754040F1R020.0Z4-HXT	10164867	1	F	4,0	6,0	6,0	50,0	9,0	4,05	0,2	4	■
JS754050F1R020.0Z4-HXT	10165559	1	F	5,0	6,0	7,0	50,0	10,0	5,05	0,2	4	■
JS754060D1R020.0Z4-HXT	10164868	1	D	6,0	6,0	8,0	50,0	–	–	0,2	4	■
JS754060D1R050.0Z4-HXT	10164869	1	D	6,0	6,0	8,0	50,0	–	–	0,5	4	■
JS754080D1R050.0Z4-HXT	10164871	1	D	8,0	8,0	11,0	58,0	–	–	0,5	4	■
JS754100D1R050.0Z4-HXT	10164873	1	D	10,0	10,0	13,0	58,0	–	–	0,5	4	■
JS754100D1R100.0Z4-HXT	10164874	1	D	10,0	10,0	13,0	58,0	–	–	1,0	4	■
JS754120D1R050.0Z4-HXT	10164875	1	D	12,0	12,0	15,0	67,0	–	–	0,5	4	■
JS754120D1R100.0Z4-HXT	10164876	1	D	12,0	12,0	15,0	67,0	–	–	1,0	4	■
JS754160D1R050.0Z4-HXT	10164877	1	D	16,0	16,0	19,0	73,0	–	–	0,5	4	■
JS754160D1R100.0Z4-HXT	10164878	1	D	16,0	16,0	19,0	73,0	–	–	1,0	4	■
JS754030G2R020.0Z4-HXT	03186840	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	4	■
JS754040G2R020.0Z4-HXT	03186841	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4	■
JS754050G2R020.0Z4-HXT	03186842	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	4	■
JS754060E2R020.0Z4-HXT	03186843	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	■
JS754060E2R050.0Z4-HXT	03186844	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JS754060E2R100.0Z4-HXT	03186845	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JS754080E2R050.0Z4-HXT	03186846	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JS754080E2R100.0Z4-HXT	03186847	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JS754100E2R050.0Z4-HXT	03186848	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JS754100E2R100.0Z4-HXT	03186849	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JS754100E2R150.0Z4-HXT	03200552	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	■
JS754100E2R200.0Z4-HXT	03186850	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	■
JS754100E2R300.0Z4-HXT	03186851	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	■
JS754120E2R050.0Z4-HXT	03186852	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JS754120E2R100.0Z4-HXT	03186853	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JS754120E2R150.0Z4-HXT	03200553	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	■
JS754120E2R200.0Z4-HXT	03186854	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	■
JS754120E2R300.0Z4-HXT	03186855	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	■
JS754160E2R050.0Z4-HXT	03186856	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JS754160E2R100.0Z4-HXT	03186857	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JS754160E2R200.0Z4-HXT	03186858	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	■

■ Stocked standard.

JS754

High performance –Square – ISO– M and ISO– S – 4 Flutes – Cylindrical – Corner radius



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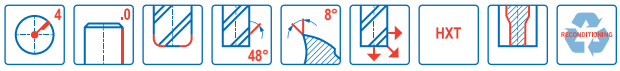


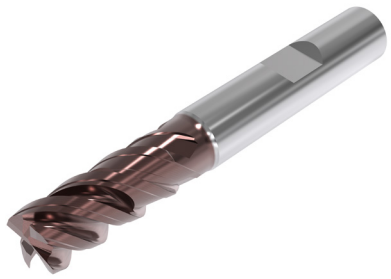
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

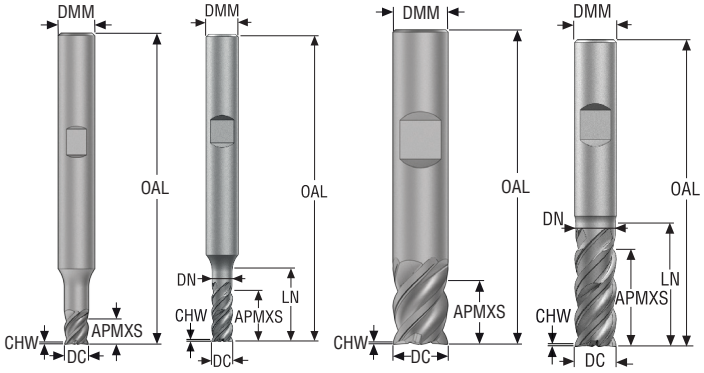
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS754160E2R300.0Z4-HXT	03186859	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	■
JS754160E2R400.0Z4-HXT	03186860	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	■
JS754160E2R600.0Z4-HXT	03186861	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	■
JS754200E2R050.0Z4-HXT	03186862	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	■
JS754200E2R100.0Z4-HXT	03186863	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	■
JS754200E2R200.0Z4-HXT	03186864	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	■
JS754200E2R300.0Z4-HXT	03186865	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	■
JS754200E2R400.0Z4-HXT	03186866	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	■
JS754200E2R600.0Z4-HXT	03186867	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	■
JS754060E3R020.0Z4-HXT	03186873	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	■
JS754060E3R050.0Z4-HXT	03186874	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	■
JS754060E3R100.0Z4-HXT	03186875	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	■
JS754080E3R050.0Z4-HXT	03186876	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	■
JS754080E3R100.0Z4-HXT	03186877	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	■
JS754100E3R050.0Z4-HXT	03186878	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	■
JS754100E3R100.0Z4-HXT	03186879	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	■
JS754100E3R200.0Z4-HXT	03186880	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	■
JS754100E3R300.0Z4-HXT	03186881	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	■
JS754120E3R050.0Z4-HXT	03186882	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	■
JS754120E3R100.0Z4-HXT	03186883	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	■
JS754120E3R200.0Z4-HXT	03186884	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	■
JS754120E3R300.0Z4-HXT	03186885	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	■
JS754160E3R050.0Z4-HXT	03186886	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	■
JS754160E3R100.0Z4-HXT	03186887	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	■
JS754160E3R200.0Z4-HXT	03186888	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	■
JS754160E3R300.0Z4-HXT	03186889	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	■
JS754160E3R400.0Z4-HXT	03186890	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	■
JS754160E3R600.0Z4-HXT	03186891	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	■
JS754200E3R050.0Z4-HXT	03186892	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	■
JS754200E3R100.0Z4-HXT	03186893	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	■
JS754200E3R200.0Z4-HXT	03186894	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	■
JS754200E3R300.0Z4-HXT	03186895	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	■
JS754200E3R400.0Z4-HXT	03186896	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	■
JS754200E3R600.0Z4-HXT	03186897	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	■

■ Stocked standard.

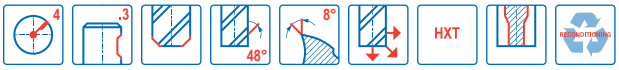
JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Weldon – Chamfer





- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

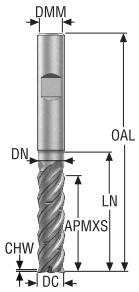


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754030F1C.3Z4-HXT	10165658	1	F	3,0	6,0	4,0	50,0	6,0	3,05	0,035	4	□
JS754040F1C.3Z4-HXT	10164861	1	F	4,0	6,0	6,0	50,0	9,0	4,05	0,045	4	□
JS754050F1C.3Z4-HXT	10165660	1	F	5,0	6,0	7,0	50,0	10,0	5,05	0,055	4	□
JS754060D1C.3Z4-HXT	10164862	1	D	6,0	6,0	8,0	50,0	–	–	0,075	4	□
JS754080D1C.3Z4-HXT	10164863	1	D	8,0	8,0	11,0	58,0	–	–	0,1	4	□
JS754100D1C.3Z4-HXT	10164864	1	D	10,0	10,0	13,0	58,0	–	–	0,125	4	□
JS754120D1C.3Z4-HXT	10164865	1	D	12,0	12,0	15,0	67,0	–	–	0,15	4	□
JS754160D1C.3Z4-HXT	10164866	1	D	16,0	16,0	19,0	73,0	–	–	0,2	4	□
JS754030G2C.3Z4-HXT	03186975	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	4	□
JS754040G2C.3Z4-HXT	03186976	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4	□
JS754050G2C.3Z4-HXT	03186977	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	4	□
JS754060E2C.3Z4-HXT	03186978	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.3Z4-HXT	03186979	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.3Z4-HXT	03186980	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4-HXT	03186981	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.3Z4-HXT	03186982	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.3Z4-HXT	03186983	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■
JS754250E2C.3Z4-HXT	03186984	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	■
JS754060E3C.3Z4-HXT	03186990	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.3Z4-HXT	03186991	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.3Z4-HXT	03186992	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.3Z4-HXT	03186993	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.3Z4-HXT	03186994	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.3Z4-HXT	03186995	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■
JS754250E3C.3Z4-HXT	03186996	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Weldon – Chamfer – Chip splitters



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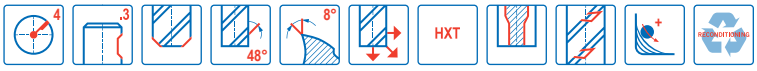


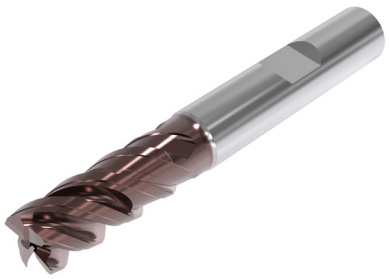
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible

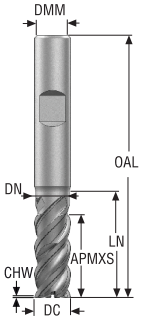
Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.3Z4C-HXT	03186985	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4C-HXT	03186986	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754060E3C.3Z4C-HXT	03200562	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.3Z4C-HXT	03200563	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.3Z4C-HXT	03186997	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.3Z4C-HXT	03186998	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.3Z4C-HXT	03186999	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.3Z4C-HXT	03187000	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■

■ Stocked standard.

JS754

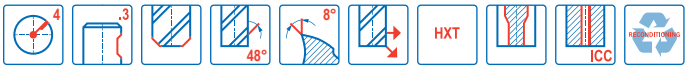
High performance – Square – ISO– M and ISO– S – 4 Flutes – Weldon – Chamfer – ICC





E

- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible

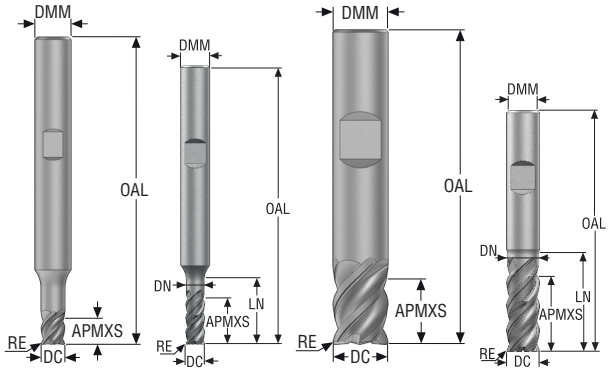


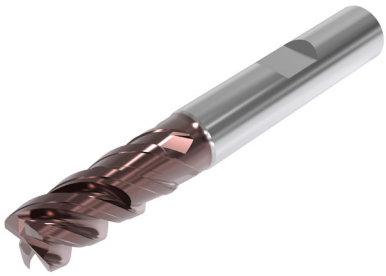
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.3Z4A-HXT	03187001	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.3Z4A-HXT	03187002	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.3Z4A-HXT	03187003	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4A-HXT	03187004	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.3Z4A-HXT	03187005	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.3Z4A-HXT	03187006	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■

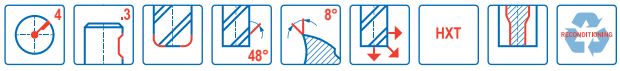
■ Stocked standard.

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Weldon – Corner radius







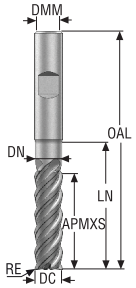
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754030F1R020.3Z4-HXT	10165560	1	F	3,0	6,0	4,0	50,0	6,0	3,05	0,2	4	☐
JS754040F1R020.3Z4-HXT	10164879	1	F	4,0	6,0	6,0	50,0	9,0	4,05	0,2	4	☐
JS754050F1R020.3Z4-HXT	10165561	1	F	5,0	6,0	7,0	50,0	10,0	5,05	0,2	4	☐
JS754060D1R020.3Z4-HXT	10164880	1	D	6,0	6,0	8,0	50,0	–	–	0,2	4	☐
JS754060D1R050.3Z4-HXT	10164881	1	D	6,0	6,0	8,0	50,0	–	–	0,5	4	☐
JS754080D1R050.3Z4-HXT	10164883	1	D	8,0	8,0	11,0	58,0	–	–	0,5	4	☐
JS754100D1R050.3Z4-HXT	10164885	1	D	10,0	10,0	13,0	58,0	–	–	0,5	4	☐
JS754100D1R100.3Z4-HXT	10164886	1	D	10,0	10,0	13,0	58,0	–	–	1,0	4	☐
JS754120D1R050.3Z4-HXT	10164887	1	D	12,0	12,0	15,0	67,0	–	–	0,5	4	☐
JS754120D1R100.3Z4-HXT	10164888	1	D	12,0	12,0	15,0	67,0	–	–	1,0	4	☐
JS754160D1R050.3Z4-HXT	10164889	1	D	16,0	16,0	19,0	73,0	–	–	0,5	4	☐
JS754160D1R100.3Z4-HXT	10164890	1	D	16,0	16,0	19,0	73,0	–	–	1,0	4	☐
JS754030G2R020.3Z4-HXT	03187007	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	4	☐
JS754040G2R020.3Z4-HXT	03187008	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4	☐
JS754050G2R020.3Z4-HXT	03187009	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	4	☐
JS754060E2R020.3Z4-HXT	03187010	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	■
JS754060E2R050.3Z4-HXT	03187011	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JS754060E2R100.3Z4-HXT	03187012	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JS754080E2R050.3Z4-HXT	03187013	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JS754080E2R100.3Z4-HXT	03187014	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JS754100E2R050.3Z4-HXT	03187015	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JS754100E2R100.3Z4-HXT	03187016	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JS754100E2R150.3Z4-HXT	03200564	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	■
JS754100E2R200.3Z4-HXT	03187017	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	■
JS754100E2R300.3Z4-HXT	03187018	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	■
JS754120E2R050.3Z4-HXT	03187019	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JS754120E2R100.3Z4-HXT	03187020	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JS754120E2R150.3Z4-HXT	03200565	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	■
JS754120E2R200.3Z4-HXT	03187021	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	■
JS754120E2R300.3Z4-HXT	03187022	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	■
JS754160E2R050.3Z4-HXT	03187023	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JS754160E2R100.3Z4-HXT	03187024	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JS754160E2R200.3Z4-HXT	03187025	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	■
JS754160E2R300.3Z4-HXT	03187026	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	■
JS754160E2R400.3Z4-HXT	03187027	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	■
JS754160E2R600.3Z4-HXT	03187028	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	■

■ Stocked standard. ☐ Weldon available. Delivery time is 3 days.

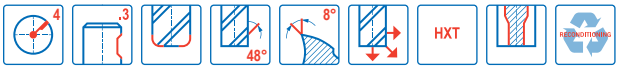
JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Weldon – Corner radius



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

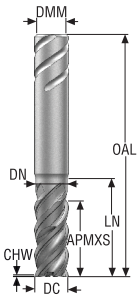


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754200E2R050.3Z4-HXT	03187029	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	■
JS754200E2R100.3Z4-HXT	03187030	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	■
JS754200E2R200.3Z4-HXT	03187031	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	■
JS754200E2R300.3Z4-HXT	03187032	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	■
JS754200E2R400.3Z4-HXT	03187033	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	■
JS754200E2R600.3Z4-HXT	03187034	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	■
JS754060E3R020.3Z4-HXT	03187040	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	□
JS754060E3R050.3Z4-HXT	03187041	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	□
JS754060E3R100.3Z4-HXT	03187042	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	□
JS754080E3R050.3Z4-HXT	03187043	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	□
JS754080E3R100.3Z4-HXT	03187044	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	□
JS754100E3R050.3Z4-HXT	03187045	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	□
JS754100E3R100.3Z4-HXT	03187046	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	□
JS754100E3R200.3Z4-HXT	03187047	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	□
JS754100E3R300.3Z4-HXT	03187049	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	□
JS754120E3R050.3Z4-HXT	03187050	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	□
JS754120E3R100.3Z4-HXT	03187051	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	□
JS754120E3R200.3Z4-HXT	03187052	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	□
JS754120E3R300.3Z4-HXT	03187053	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	□
JS754160E3R050.3Z4-HXT	03187054	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	□
JS754160E3R100.3Z4-HXT	03187055	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	□
JS754160E3R200.3Z4-HXT	03187056	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	□
JS754160E3R300.3Z4-HXT	03187057	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	□
JS754160E3R400.3Z4-HXT	03187058	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	□
JS754160E3R600.3Z4-HXT	03187059	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	□
JS754200E3R050.3Z4-HXT	03187060	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	□
JS754200E3R100.3Z4-HXT	03187061	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	□
JS754200E3R200.3Z4-HXT	03187062	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	□
JS754200E3R300.3Z4-HXT	03187063	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	□
JS754200E3R400.3Z4-HXT	03187064	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	□
JS754200E3R600.3Z4-HXT	03187065	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	□

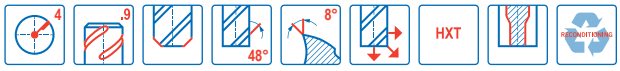
□ Weldon available. Delivery time is 3 days.

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Safelock – Chamfer



E



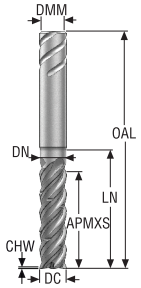
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.9Z4-HXT	03187144	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	☐
JS754080E2C.9Z4-HXT	03187145	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	☐
JS754100E2C.9Z4-HXT	03187146	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	☐
JS754120E2C.9Z4-HXT	03187147	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	☐
JS754160E2C.9Z4-HXT	03187148	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	☐
JS754200E2C.9Z4-HXT	03187149	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	☐
JS754250E2C.9Z4-HXT	03187150	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	☐
JS754060E3C.9Z4-HXT	03187153	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	☐
JS754080E3C.9Z4-HXT	03187154	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	☐
JS754100E3C.9Z4-HXT	03187155	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	☐
JS754120E3C.9Z4-HXT	03187156	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	☐
JS754160E3C.9Z4-HXT	03187157	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	☐
JS754200E3C.9Z4-HXT	03187158	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	☐
JS754250E3C.9Z4-HXT	03187159	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	☐

☐ Safelock available. Delivery time is 6 days.

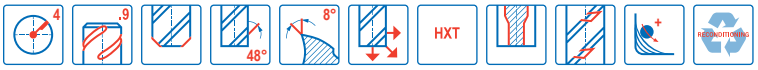
JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Safelock – Chamfer – Chip splitters



E

- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible

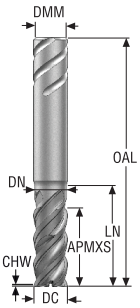


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.9Z4C-HXT	03187151	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	□
JS754120E2C.9Z4C-HXT	03187152	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	□
JS754060E3C.9Z4C-HXT	03200571	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	□
JS754080E3C.9Z4C-HXT	03200572	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	□
JS754100E3C.9Z4C-HXT	03187160	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	□
JS754120E3C.9Z4C-HXT	03187161	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	□
JS754160E3C.9Z4C-HXT	03187162	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	□
JS754200E3C.9Z4C-HXT	03187163	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	□

□ Safelock available. Delivery time is 6 days.

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Safelock – Chamfer – ICC



E

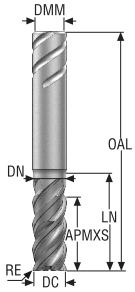
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.9Z4A-HXT	03187164	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	☐
JS754080E2C.9Z4A-HXT	03187165	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	☐
JS754100E2C.9Z4A-HXT	03187166	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	☐
JS754120E2C.9Z4A-HXT	03187167	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	☐
JS754160E2C.9Z4A-HXT	03187168	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	☐
JS754200E2C.9Z4A-HXT	03187169	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	☐

☐ Safelock available. Delivery time is 6 days.

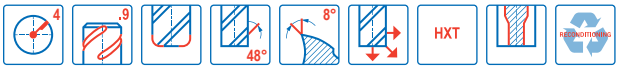
JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Safelock – Corner radius



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

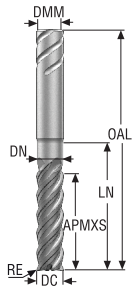


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E2R020.9Z4-HXT	03187170	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	☐
JS754060E2R050.9Z4-HXT	03187171	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	☐
JS754060E2R100.9Z4-HXT	03187172	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	☐
JS754080E2R050.9Z4-HXT	03187173	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	☐
JS754080E2R100.9Z4-HXT	03187174	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	☐
JS754100E2R050.9Z4-HXT	03187175	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	☐
JS754100E2R100.9Z4-HXT	03187176	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	☐
JS754100E2R150.9Z4-HXT	03200573	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	☐
JS754100E2R200.9Z4-HXT	03187177	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	☐
JS754100E2R300.9Z4-HXT	03187178	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	☐
JS754120E2R050.9Z4-HXT	03187179	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	☐
JS754120E2R100.9Z4-HXT	03187180	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	☐
JS754120E2R150.9Z4-HXT	03200832	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	☐
JS754120E2R200.9Z4-HXT	03187181	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	☐
JS754120E2R300.9Z4-HXT	03187182	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	☐
JS754160E2R050.9Z4-HXT	03187183	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	☐
JS754160E2R100.9Z4-HXT	03187184	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	☐
JS754160E2R200.9Z4-HXT	03187185	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	☐
JS754160E2R300.9Z4-HXT	03187186	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	☐
JS754160E2R400.9Z4-HXT	03187187	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	☐
JS754160E2R600.9Z4-HXT	03187188	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	☐
JS754200E2R050.9Z4-HXT	03187189	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	☐
JS754200E2R100.9Z4-HXT	03187190	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	☐
JS754200E2R200.9Z4-HXT	03187191	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	☐
JS754200E2R300.9Z4-HXT	03187192	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	☐
JS754200E2R400.9Z4-HXT	03187193	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	☐
JS754200E2R600.9Z4-HXT	03187194	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	☐

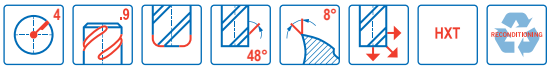
☐ Safelock available. Delivery time is 6 days.

JS754

High performance – Square – ISO– M and ISO– S – 4 Flutes – Safelock – Corner radius



E



- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E3R020.9Z4-HXT	03187197	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	☐
JS754060E3R050.9Z4-HXT	03187198	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	☐
JS754060E3R100.9Z4-HXT	03187199	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	☐
JS754080E3R050.9Z4-HXT	03187200	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	☐
JS754080E3R100.9Z4-HXT	03187201	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	☐
JS754100E3R050.9Z4-HXT	03187202	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	☐
JS754100E3R100.9Z4-HXT	03187203	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	☐
JS754100E3R200.9Z4-HXT	03187204	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	☐
JS754100E3R300.9Z4-HXT	03187205	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	☐
JS754120E3R050.9Z4-HXT	03187206	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	☐
JS754120E3R100.9Z4-HXT	03187207	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	☐
JS754120E3R200.9Z4-HXT	03187208	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	☐
JS754120E3R300.9Z4-HXT	03187209	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	☐
JS754160E3R050.9Z4-HXT	03187210	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	☐
JS754160E3R100.9Z4-HXT	03187211	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	☐
JS754160E3R200.9Z4-HXT	03187212	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	☐
JS754160E3R300.9Z4-HXT	03187213	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	☐
JS754160E3R400.9Z4-HXT	03187214	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	☐
JS754160E3R600.9Z4-HXT	03187215	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	☐
JS754200E3R050.9Z4-HXT	03187216	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	☐
JS754200E3R100.9Z4-HXT	03187217	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	☐
JS754200E3R200.9Z4-HXT	03187218	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	☐
JS754200E3R300.9Z4-HXT	03187219	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	☐
JS754200E3R400.9Z4-HXT	03187220	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	☐
JS754200E3R600.9Z4-HXT	03187221	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	☐

☐ Safelock available. Delivery time is 6 days.

Cutting data – JS754 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (130 — 180) *540 (430 — 590)*
P12	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	105 (83 — 120) *345 (280 — 390)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 130) *360 (320 — 420)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 110) *295 (260 — 360)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (44 — 76) *195 (150 — 240)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	46 (34 — 59) *150 (120 — 190)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	39 (29 — 49) *130 (96 — 160)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	50 (26 — 68) *165 (86 — 220)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	41 (21 — 55) *135 (69 — 180)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	36 (19 — 48) *120 (63 — 150)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (73 — 140) *360 (240 — 450)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (56 — 110) *280 (190 — 360)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (44 — 87) *215 (150 — 280)*

Cutting data – JS754 Slot milling

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	150 (120 — 170) *490 (400 — 550)*
P12	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	90 (69 — 100) *295 (230 — 320)*
M1	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (85 — 120) *310 (280 — 390)*
M2	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 97) *260 (230 — 310)*
M3	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	55 (39 — 67) *180 (130 — 210)*
M4	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	40 (29 — 50) *130 (96 — 160)*
M5	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (25 — 42) *110 (83 — 130)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	41 (21 — 54) *135 (69 — 170)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (17 — 43) *110 (56 — 140)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	28 (15 — 37) *90 (50 — 120)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (63 — 120) *310 (210 — 390)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	70 (48 — 95) *230 (160 — 310)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	55 (38 — 74) *180 (130 — 240)*

If radius exeeds 15% of value DC please reduce fz with 20%

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS754-2C Advanced roughing a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P11	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.15 *0,0060*	0.17 *0,0065*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150 — 190) *560 (500 — 620)*
M1	E	0.100 *0,100*	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	205 (180 — 230) *670 (600 — 750)*
M2	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150 — 190) *560 (500 — 620)*
M3	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	130 (120 — 150) *425 (400 — 490)*
M4	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	100 (86 — 110) *330 (290 — 360)*
M5	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	60 (35 — 80) *195 (120 — 260)*
S3	E	0.0500 *0,0500*	2.0 *2,0*	0.080 *0,0032*	0.095 *0,0038*	50 (31 — 70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	165 (140 — 190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	125 (110 — 150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	2.0 *2,0*	0.060 *0,0024*	0.070 *0,0028*	100 (84 — 110) *330 (280 — 360)*

Cutting data – JS754-3C Advanced roughing a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 230) *670 (560 — 750)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 190) *560 (460 — 620)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 150) *425 (370 — 490)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (86 — 110) *330 (290 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (30 — 70) *165 (99 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	165 (140 — 190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (84 — 110) *330 (280 — 360)*

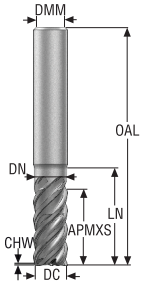
If radius exeeds 15% of value DC please reduce fz with 20%

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

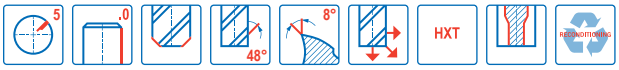
JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Cylindrical – Chamfer



E

- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible

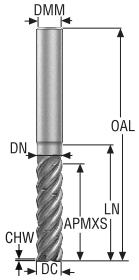


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.0Z5-HXT	03186907	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	■
JS755080E2C.0Z5-HXT	03186908	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	■
JS755100E2C.0Z5-HXT	03186909	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	■
JS755120E2C.0Z5-HXT	03186910	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	■
JS755160E2C.0Z5-HXT	03186911	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	■
JS755200E2C.0Z5-HXT	03186912	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	■
JS755250E2C.0Z5-HXT	03186913	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	■
JS755060E3C.0Z5-HXT	03186914	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	■
JS755080E3C.0Z5-HXT	03186915	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	■
JS755100E3C.0Z5-HXT	03186916	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.0Z5-HXT	03186917	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.0Z5-HXT	03186918	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.0Z5-HXT	03186919	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■
JS755250E3C.0Z5-HXT	03186920	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	■

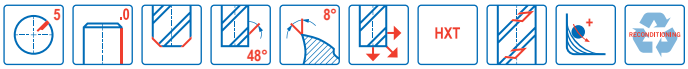
■ Stocked standard.

JS755

High performance - Square – ISO– M and ISO– S – 5 Flutes – Cylindrical – Chamfer – Chip splitters



E



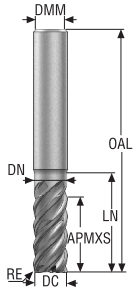
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.0Z5C-HXT	03186921	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.0Z5C-HXT	03186922	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.0Z5C-HXT	03186923	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.0Z5C-HXT	03186924	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■

■ Stocked standard.

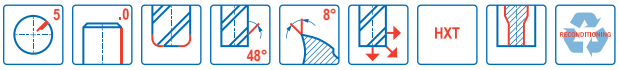
JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Cylindrical – Corner radius



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

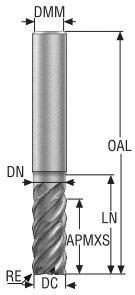


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.0Z5-HXT	03186925	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	■
JS755060E2R050.0Z5-HXT	03186926	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	■
JS755060E2R100.0Z5-HXT	03186927	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	■
JS755080E2R050.0Z5-HXT	03186928	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	■
JS755080E2R100.0Z5-HXT	03186929	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	■
JS755100E2R050.0Z5-HXT	03186930	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	■
JS755100E2R100.0Z5-HXT	03186931	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	■
JS755100E2R200.0Z5-HXT	03186932	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	■
JS755100E2R300.0Z5-HXT	03186933	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	■
JS755120E2R050.0Z5-HXT	03186934	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	■
JS755120E2R100.0Z5-HXT	03186935	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	■
JS755120E2R200.0Z5-HXT	03186936	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	■
JS755120E2R300.0Z5-HXT	03186937	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	■
JS755160E2R050.0Z5-HXT	03186938	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	■
JS755160E2R100.0Z5-HXT	03186939	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	■
JS755160E2R600.0Z5-HXT	03186940	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	■
JS755200E2R050.0Z5-HXT	03186941	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	■
JS755200E2R100.0Z5-HXT	03186942	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	■
JS755200E2R600.0Z5-HXT	03186943	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	■

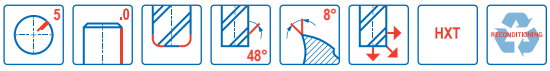
■ Stocked standard.

JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Cylindrical – Corner radius



E



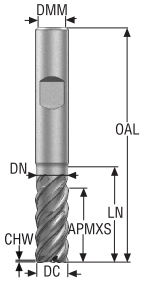
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS755060E3R020.0Z5-HXT	03186946	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	■
JS755060E3R050.0Z5-HXT	03186947	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	■
JS755060E3R100.0Z5-HXT	03186948	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	■
JS755080E3R050.0Z5-HXT	03186949	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	■
JS755080E3R100.0Z5-HXT	03186950	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	■
JS755100E3R050.0Z5-HXT	03186951	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	■
JS755100E3R100.0Z5-HXT	03186952	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	■
JS755100E3R200.0Z5-HXT	03186953	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	■
JS755100E3R300.0Z5-HXT	03186954	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	■
JS755120E3R050.0Z5-HXT	03186955	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	■
JS755120E3R100.0Z5-HXT	03186956	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	■
JS755120E3R200.0Z5-HXT	03186957	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	■
JS755120E3R300.0Z5-HXT	03186958	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	■
JS755160E3R050.0Z5-HXT	03186959	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	■
JS755160E3R600.0Z5-HXT	03186960	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	■
JS755200E3R050.0Z5-HXT	03186961	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	■
JS755200E3R600.0Z5-HXT	03186962	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	■

■ Stocked standard.

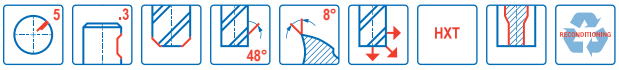
JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Weldon – Chamfer



E

- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible

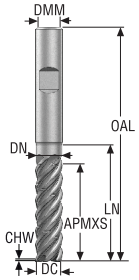


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.3Z5-HXT	03187083	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	■
JS755080E2C.3Z5-HXT	03187084	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	■
JS755100E2C.3Z5-HXT	03187085	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	■
JS755120E2C.3Z5-HXT	03187086	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	■
JS755160E2C.3Z5-HXT	03187087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	■
JS755200E2C.3Z5-HXT	03187088	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	■
JS755250E2C.3Z5-HXT	03187089	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	■
JS755060E3C.3Z5-HXT	03187090	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	■
JS755080E3C.3Z5-HXT	03187091	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	■
JS755100E3C.3Z5-HXT	03187092	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.3Z5-HXT	03187093	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.3Z5-HXT	03187094	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.3Z5-HXT	03187095	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■
JS755250E3C.3Z5-HXT	03187096	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	■

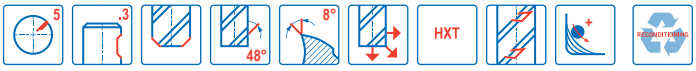
■ Stocked standard.

JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Weldon – Chamfer – Chip splitters



E



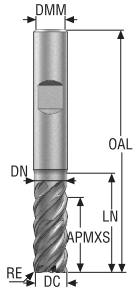
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.3Z5C-HXT	03187097	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.3Z5C-HXT	03187098	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.3Z5C-HXT	03187099	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.3Z5C-HXT	03187100	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■

■ Stocked standard.

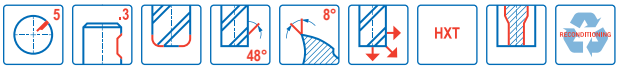
JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Weldon – Corner radius



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

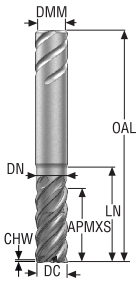


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.3Z5-HXT	03187101	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	■
JS755060E2R050.3Z5-HXT	03187102	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	■
JS755060E2R100.3Z5-HXT	03187103	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	■
JS755080E2R050.3Z5-HXT	03187104	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	■
JS755080E2R100.3Z5-HXT	03187105	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	■
JS755100E2R050.3Z5-HXT	03187106	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	■
JS755100E2R100.3Z5-HXT	03187107	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	■
JS755100E2R200.3Z5-HXT	03187108	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	■
JS755100E2R300.3Z5-HXT	03187109	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	■
JS755120E2R050.3Z5-HXT	03187110	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	■
JS755120E2R100.3Z5-HXT	03187111	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	■
JS755120E2R200.3Z5-HXT	03187112	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	■
JS755120E2R300.3Z5-HXT	03187113	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	■
JS755160E2R050.3Z5-HXT	03187114	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	■
JS755160E2R100.3Z5-HXT	03187115	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	■
JS755160E2R600.3Z5-HXT	03187116	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	■
JS755200E2R050.3Z5-HXT	03187117	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	■
JS755200E2R100.3Z5-HXT	03187118	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	■
JS755200E2R600.3Z5-HXT	03187119	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	■
JS755060E3R020.3Z5-HXT	03187122	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	□
JS755060E3R050.3Z5-HXT	03187123	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	□
JS755060E3R100.3Z5-HXT	03187124	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	□
JS755080E3R050.3Z5-HXT	03187125	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	□
JS755080E3R100.3Z5-HXT	03187126	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	□
JS755100E3R050.3Z5-HXT	03187127	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	□
JS755100E3R100.3Z5-HXT	03187128	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	□
JS755100E3R200.3Z5-HXT	03187129	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	□
JS755100E3R300.3Z5-HXT	03187130	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	□
JS755120E3R050.3Z5-HXT	03187131	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	□
JS755120E3R100.3Z5-HXT	03187132	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	□
JS755120E3R200.3Z5-HXT	03187133	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	□
JS755120E3R300.3Z5-HXT	03187134	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	□
JS755160E3R050.3Z5-HXT	03187135	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	□
JS755160E3R600.3Z5-HXT	03187136	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	□
JS755200E3R050.3Z5-HXT	03187137	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	□
JS755200E3R600.3Z5-HXT	03187138	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	□

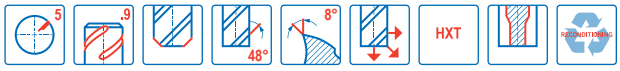
■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Safelock – Chamfer



E



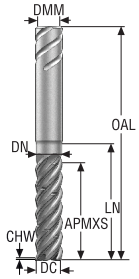
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.9Z5-HXT	03187235	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	☐
JS755080E2C.9Z5-HXT	03187236	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	☐
JS755100E2C.9Z5-HXT	03187237	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	☐
JS755120E2C.9Z5-HXT	03187238	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	☐
JS755160E2C.9Z5-HXT	03187239	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	☐
JS755200E2C.9Z5-HXT	03187240	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	☐
JS755250E2C.9Z5-HXT	03187241	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	☐
JS755060E3C.9Z5-HXT	03187242	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	☐
JS755080E3C.9Z5-HXT	03187243	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	☐
JS755100E3C.9Z5-HXT	03187244	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	☐
JS755120E3C.9Z5-HXT	03187245	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	☐
JS755160E3C.9Z5-HXT	03187246	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	☐
JS755200E3C.9Z5-HXT	03187247	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	☐
JS755250E3C.9Z5-HXT	03187248	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	☐

☐ Safelock available. Delivery time is 6 days.

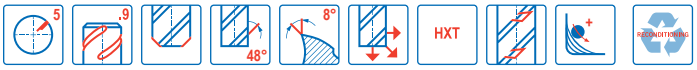
JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Safelock – Chamfer – Chip splitters



E

- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible

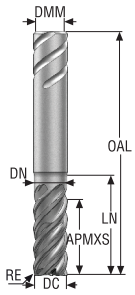


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.9Z5C-HXT	03187249	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	☐
JS755120E3C.9Z5C-HXT	03187250	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	☐
JS755160E3C.9Z5C-HXT	03187252	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	☐
JS755200E3C.9Z5C-HXT	03187253	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	☐

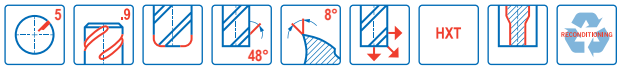
☐ Safelock available. Delivery time is 6 days.

JS755

High performance – Square – ISO– M and ISO– S – 5 Flutes – Safelock – Corner radius



E



- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.9Z5-HXT	03187254	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	☐
JS755060E2R050.9Z5-HXT	03187255	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	☐
JS755060E2R100.9Z5-HXT	03187256	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	☐
JS755080E2R050.9Z5-HXT	03187257	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	☐
JS755080E2R100.9Z5-HXT	03187258	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	☐
JS755100E2R050.9Z5-HXT	03187259	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	☐
JS755100E2R100.9Z5-HXT	03187260	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	☐
JS755100E2R200.9Z5-HXT	03187261	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	☐
JS755100E2R300.9Z5-HXT	03187262	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	☐
JS755120E2R050.9Z5-HXT	03187263	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	☐
JS755120E2R100.9Z5-HXT	03187264	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	☐
JS755120E2R200.9Z5-HXT	03187265	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	☐
JS755120E2R300.9Z5-HXT	03187266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	☐
JS755160E2R050.9Z5-HXT	03187267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	☐
JS755160E2R100.9Z5-HXT	03187269	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	☐
JS755160E2R600.9Z5-HXT	03187270	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	☐
JS755200E2R050.9Z5-HXT	03187271	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	☐
JS755200E2R100.9Z5-HXT	03187272	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	☐
JS755200E2R600.9Z5-HXT	03187273	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	☐
JS755060E3R020.9Z5-HXT	03187276	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	☐
JS755060E3R050.9Z5-HXT	03187277	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	☐
JS755060E3R100.9Z5-HXT	03187279	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	☐
JS755080E3R050.9Z5-HXT	03187280	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	☐
JS755080E3R100.9Z5-HXT	03187281	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	☐
JS755100E3R050.9Z5-HXT	03187282	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	☐
JS755100E3R100.9Z5-HXT	03187283	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	☐
JS755100E3R200.9Z5-HXT	03187284	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	☐
JS755100E3R300.9Z5-HXT	03187285	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	☐
JS755120E3R050.9Z5-HXT	03187286	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	☐
JS755120E3R100.9Z5-HXT	03187287	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	☐
JS755120E3R200.9Z5-HXT	03187288	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	☐
JS755120E3R300.9Z5-HXT	03187289	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	☐
JS755160E3R050.9Z5-HXT	03187290	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	☐
JS755160E3R600.9Z5-HXT	03187291	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	☐
JS755200E3R050.9Z5-HXT	03187292	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	☐
JS755200E3R600.9Z5-HXT	03187293	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	☐

☐ Safelock available. Delivery time is 6 days.

Cutting data – JS755 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	135 (97 — 150) *445 (320 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	85 (63 — 99) *280 (210 — 320)*
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120 — 150) *460 (400 — 490)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (92 — 120) *360 (310 — 390)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (71 — 95) *280 (240 — 310)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	70 (59 — 79) *230 (200 — 250)*
S1	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	70 (48 — 110) *230 (160 — 360)*
S2	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	60 (39 — 89) *195 (130 — 290)*
S3	E	0.0300 *0,0300*	2.0 *2,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (34 — 78) *165 (120 — 250)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120 — 160) *460 (400 — 520)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (91 — 120) *360 (300 — 390)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (73 — 100) *280 (240 — 320)*

Cutting data – JS755_3C Advanced roughing a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 220) *670 (560 — 720)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (85 — 110) *330 (280 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (31 — 70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 190) *520 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (83 — 110) *330 (280 — 360)*

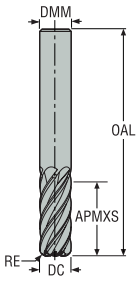
If radius exeeds 15% of value DC please reduce fz with 20%

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS720

High performance – Titanium – Square – 6 Flutes – Cylindrical – Corner radius



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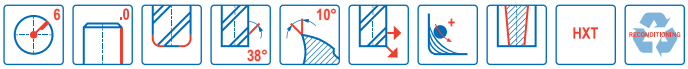


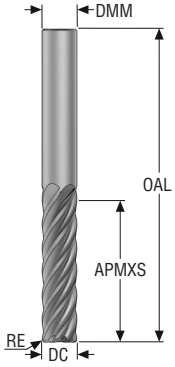
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS720060D2R050.0Z6-HXT	03060293	2	D	6,0	6,0	17,0	57,0	0,5	6	■
JS720060D2R100.0Z6-HXT	03060294	2	D	6,0	6,0	17,0	57,0	1,0	6	■
JS720080D2R050.0Z6-HXT	03060295	2	D	8,0	8,0	23,0	63,0	0,5	6	■
JS720080D2R100.0Z6-HXT	03061294	2	D	8,0	8,0	23,0	63,0	1,0	6	■
JS720100D2R050.0Z6-HXT	03060296	2	D	10,0	10,0	26,0	72,0	0,5	6	■
JS720100D2R100.0Z6-HXT	03060298	2	D	10,0	10,0	26,0	72,0	1,0	6	■
JS720100D2R200.0Z6-HXT	03060299	2	D	10,0	10,0	26,0	72,0	2,0	6	■
JS720100D2R300.0Z6-HXT	03060300	2	D	10,0	10,0	26,0	72,0	3,0	6	■
JS720120D2R050.0Z6-HXT	03060301	2	D	12,0	12,0	30,0	83,0	0,5	6	■
JS720120D2R100.0Z6-HXT	03060304	2	D	12,0	12,0	30,0	83,0	1,0	6	■
JS720120D2R200.0Z6-HXT	03060305	2	D	12,0	12,0	30,0	83,0	2,0	6	■
JS720120D2R300.0Z6-HXT	03060306	2	D	12,0	12,0	30,0	83,0	3,0	6	■
JS720160D2R050.0Z6-HXT	03060307	2	D	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.0Z6-HXT	03060309	2	D	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.0Z6-HXT	03060310	2	D	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R300.0Z6-HXT	03060311	2	D	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R400.0Z6-HXT	03060312	2	D	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.0Z6-HXT	03060313	2	D	16,0	16,0	44,0	99,0	6,0	6	■
JS720200D2R050.0Z6-HXT	10228426	2	D	20,0	20,0	45,0	105,0	0,5	6	■
JS720200D2R100.0Z6-HXT	10228427	2	D	20,0	20,0	45,0	105,0	1,0	6	■
JS720200D2R200.0Z6-HXT	10228428	2	D	20,0	20,0	45,0	105,0	2,0	6	■
JS720200D2R300.0Z6-HXT	10228429	2	D	20,0	20,0	45,0	105,0	3,0	6	■
JS720250D2R050.0Z6-HXT	10228430	2	D	25,0	25,0	50,0	125,0	0,5	6	■
JS720250D2R100.0Z6-HXT	10228431	2	D	25,0	25,0	50,0	125,0	1,0	6	■
JS720250D2R200.0Z6-HXT	10228432	2	D	25,0	25,0	50,0	125,0	2,0	6	■
JS720250D2R300.0Z6-HXT	03169498	2	D	25,0	25,0	50,0	125,0	3,0	6	■

■ Stocked standard.

JS720

High performance – Titanium – Square – 6 Flutes – Cylindrical – Corner radius



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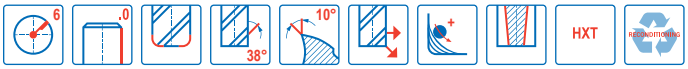


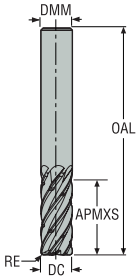
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS720080D3R050.0Z6-HXT	10228433	3	D	8,0	8,0	32,0	80,0	0,5	6	■
JS720080D3R100.0Z6-HXT	10228434	3	D	8,0	8,0	32,0	80,0	1,0	6	■
JS720100D3R050.0Z6-HXT	10228435	3	D	10,0	10,0	40,0	89,0	0,5	6	■
JS720100D3R100.0Z6-HXT	10228436	3	D	10,0	10,0	40,0	89,0	1,0	6	■
JS720100D3R200.0Z6-HXT	10228437	3	D	10,0	10,0	40,0	89,0	2,0	6	■
JS720120D3R050.0Z6-HXT	10228438	3	D	12,0	12,0	45,0	100,0	0,5	6	■
JS720120D3R100.0Z6-HXT	10228439	3	D	12,0	12,0	45,0	100,0	1,0	6	■
JS720120D3R200.0Z6-HXT	10228440	3	D	12,0	12,0	45,0	100,0	2,0	6	■
JS720160D3R050.0Z6-HXT	10228441	3	D	16,0	16,0	65,0	130,0	0,5	6	■
JS720160D3R100.0Z6-HXT	10228442	3	D	16,0	16,0	65,0	130,0	1,0	6	■
JS720160D3R200.0Z6-HXT	10228443	3	D	16,0	16,0	65,0	130,0	2,0	6	■
JS720160D3R300.0Z6-HXT	03169497	3	D	16,0	16,0	65,0	130,0	3,0	6	■
JS720200D3R050.0Z6-HXT	03060314	3	D	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.0Z6-HXT	03060316	3	D	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.0Z6-HXT	03060317	3	D	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R300.0Z6-HXT	03060318	3	D	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R400.0Z6-HXT	03060319	3	D	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.0Z6-HXT	03060320	3	D	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.0Z6-HXT	03060321	3	D	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.0Z6-HXT	03060322	3	D	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.0Z6-HXT	03060323	3	D	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.0Z6-HXT	03060324	3	D	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.0Z6-HXT	03060325	3	D	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.0Z6-HXT	03060326	3	D	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.0Z6-HXT	03060327	3	D	25,0	25,0	78,0	146,0	6,0	6	■

■ Stocked standard.

JS720

High performance – Titanium – Square – 6 Flutes – Cylindrical – Corner radius – Chip splitters



D

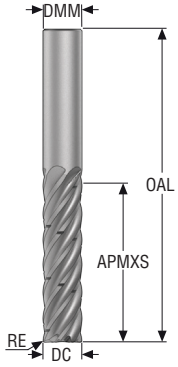
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS720080D2R050.0Z6C-HXT	10228513	2	D	■	8,0	8,0	23,0	63,0	0,5	6	■
JS720080D2R100.0Z6C-HXT	10228514	2	D	■	8,0	8,0	23,0	63,0	1,0	6	■
JS720100D2R050.0Z6C-HXT	03060297	2	D	■	10,0	10,0	26,0	72,0	0,5	6	■
JS720100D2R100.0Z6C-HXT	10228515	2	D	■	10,0	10,0	26,0	72,0	1,0	6	■
JS720120D2R050.0Z6C-HXT	03060302	2	D	■	12,0	12,0	30,0	83,0	0,5	6	■
JS720120D2R100.0Z6C-HXT	03298280	2	D	■	12,0	12,0	30,0	83,0	1,0	6	■
JS720120D2R200.0Z6C-HXT	03298281	2	D	■	12,0	12,0	30,0	83,0	2,0	6	■
JS720120D2R250.0Z6C-HXT	03298282	2	D	■	12,0	12,0	30,0	83,0	2,5	6	■
JS720120D2R300.0Z6C-HXT	03298283	2	D	■	12,0	12,0	30,0	83,0	3,0	6	■
JS720120D2R310.0Z6C-HXT	03298284	2	D	■	12,0	12,0	30,0	83,0	3,1	6	■
JS720160D2R050.0Z6C-HXT	03060308	2	D	■	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.0Z6C-HXT	03298285	2	D	■	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.0Z6C-HXT	03298286	2	D	■	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R250.0Z6C-HXT	03298287	2	D	■	16,0	16,0	44,0	99,0	2,5	6	■
JS720160D2R300.0Z6C-HXT	03298288	2	D	■	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R310.0Z6C-HXT	03298289	2	D	■	16,0	16,0	44,0	99,0	3,1	6	■
JS720160D2R400.0Z6C-HXT	03298290	2	D	■	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.0Z6C-HXT	03298291	2	D	■	16,0	16,0	44,0	99,0	6,0	6	■

■ Stocked standard.

JS720

High performance – Titanium – Square – 6 Flutes – Cylindrical – Corner radius – Chip splitters



D

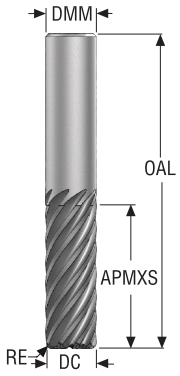
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS720160D3R050.0Z6C-HXT	10228516	3	D	■	16,0	16,0	65,0	130,0	0,5	6	■
JS720160D3R100.0Z6C-HXT	10228517	3	D	■	16,0	16,0	65,0	130,0	1,0	6	■
JS720160D3R200.0Z6C-HXT	10228518	3	D	■	16,0	16,0	65,0	130,0	2,0	6	■
JS720160D3R300.0Z6C-HXT	10228519	3	D	■	16,0	16,0	65,0	130,0	3,0	6	■
JS720200D3R050.0Z6C-HXT	03060315	3	D	■	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.0Z6C-HXT	03298292	3	D	■	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.0Z6C-HXT	03298293	3	D	■	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R250.0Z6C-HXT	03298294	3	D	■	20,0	20,0	62,0	121,0	2,5	6	■
JS720200D3R300.0Z6C-HXT	03298295	3	D	■	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R310.0Z6C-HXT	03298296	3	D	■	20,0	20,0	62,0	121,0	3,1	6	■
JS720200D3R400.0Z6C-HXT	03298297	3	D	■	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.0Z6C-HXT	03298298	3	D	■	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.0Z6C-HXT	03298299	3	D	■	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.0Z6C-HXT	03066270	3	D	■	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.0Z6C-HXT	03298300	3	D	■	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.0Z6C-HXT	03298301	3	D	■	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.0Z6C-HXT	03298302	3	D	■	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.0Z6C-HXT	03298303	3	D	■	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.0Z6C-HXT	03298304	3	D	■	25,0	25,0	78,0	146,0	6,0	6	■

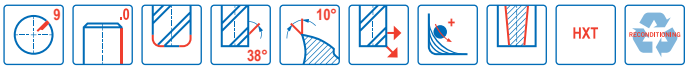
■ Stocked standard.

JS720

High performance – Titanium – Square – 9 Flutes – Cylindrical – Corner radius



D



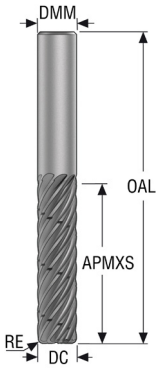
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS720100D2R050.0Z9-HXT	10067510	2	D	10,0	10,0	26,0	72,0	0,5	9	■
JS720100D2R100.0Z9-HXT	10067511	2	D	10,0	10,0	26,0	72,0	1,0	9	■
JS720100D2R200.0Z9-HXT	10067512	2	D	10,0	10,0	26,0	72,0	2,0	9	■
JS720120D2R050.0Z9-HXT	10067513	2	D	12,0	12,0	30,0	83,0	0,5	9	■
JS720120D2R100.0Z9-HXT	10067514	2	D	12,0	12,0	30,0	83,0	1,0	9	■
JS720120D2R200.0Z9-HXT	10067515	2	D	12,0	12,0	30,0	83,0	2,0	9	■
JS720160D2R100.0Z9-HXT	10008152	2	D	16,0	16,0	44,0	99,0	1,0	9	■
JS720160D2R200.0Z9-HXT	10008153	2	D	16,0	16,0	44,0	99,0	2,0	9	■
JS720160D2R300.0Z9-HXT	10008154	2	D	16,0	16,0	44,0	99,0	3,0	9	■
JS720200D2R100.0Z9-HXT	10228393	2	D	20,0	20,0	45,0	105,0	1,0	9	■
JS720200D2R200.0Z9-HXT	10228394	2	D	20,0	20,0	45,0	105,0	2,0	9	■
JS720200D2R300.0Z9-HXT	10228395	2	D	20,0	20,0	45,0	105,0	3,0	9	■
JS720250D2R100.0Z9-HXT	10008155	2	D	25,0	25,0	50,0	125,0	1,0	9	■
JS720250D2R200.0Z9-HXT	10008156	2	D	25,0	25,0	50,0	125,0	2,0	9	■
JS720250D2R300.0Z9-HXT	10008157	2	D	25,0	25,0	50,0	125,0	3,0	9	■
JS720100D3R050.0Z9-HXT	10067516	3	D	10,0	10,0	40,0	89,0	0,5	9	■
JS720100D3R100.0Z9-HXT	10067517	3	D	10,0	10,0	40,0	89,0	1,0	9	■
JS720100D3R200.0Z9-HXT	10067518	3	D	10,0	10,0	40,0	89,0	2,0	9	■
JS720120D3R050.0Z9-HXT	10067519	3	D	12,0	12,0	45,0	100,0	0,5	9	■
JS720120D3R100.0Z9-HXT	10067520	3	D	12,0	12,0	45,0	100,0	1,0	9	■
JS720120D3R200.0Z9-HXT	10067521	3	D	12,0	12,0	45,0	100,0	2,0	9	■
JS720160D3R100.0Z9-HXT	10008158	3	D	16,0	16,0	65,0	130,0	1,0	9	■
JS720160D3R200.0Z9-HXT	10008159	3	D	16,0	16,0	65,0	130,0	2,0	9	■
JS720160D3R300.0Z9-HXT	10008160	3	D	16,0	16,0	65,0	130,0	3,0	9	■
JS720200D3R100.0Z9-HXT	10008161	3	D	20,0	20,0	62,0	121,0	1,0	9	■
JS720200D3R200.0Z9-HXT	10008162	3	D	20,0	20,0	62,0	121,0	2,0	9	■
JS720200D3R300.0Z9-HXT	10008163	3	D	20,0	20,0	62,0	121,0	3,0	9	■
JS720250D3R100.0Z9-HXT	10008164	3	D	25,0	25,0	78,0	146,0	1,0	9	■
JS720250D3R200.0Z9-HXT	10008165	3	D	25,0	25,0	78,0	146,0	2,0	9	■
JS720250D3R300.0Z9-HXT	10008166	3	D	25,0	25,0	78,0	146,0	3,0	9	■

■ Stocked standard.

JS720

High performance – Titanium – Square – 9 Flutes – Cylindrical – Corner radius – Chip splitters



D

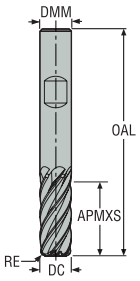
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS720100D3R050.0Z9C-HXT	10067522	3	D	■	10,0	10,0	40,0	89,0	0,5	9	■
JS720100D3R100.0Z9C-HXT	10067523	3	D	■	10,0	10,0	40,0	89,0	1,0	9	■
JS720100D3R200.0Z9C-HXT	10067524	3	D	■	10,0	10,0	40,0	89,0	2,0	9	■
JS720120D3R050.0Z9C-HXT	10067525	3	D	■	12,0	12,0	45,0	100,0	0,5	9	■
JS720120D3R100.0Z9C-HXT	10067526	3	D	■	12,0	12,0	45,0	100,0	1,0	9	■
JS720120D3R200.0Z9C-HXT	10067527	3	D	■	12,0	12,0	45,0	100,0	2,0	9	■
JS720160D3R100.0Z9C-HXT	10067528	3	D	■	16,0	16,0	65,0	130,0	1,0	9	■
JS720160D3R200.0Z9C-HXT	10067529	3	D	■	16,0	16,0	65,0	130,0	2,0	9	■
JS720160D3R300.0Z9C-HXT	10067530	3	D	■	16,0	16,0	65,0	130,0	3,0	9	■
JS720200D3R100.0Z9C-HXT	10067531	3	D	■	20,0	20,0	62,0	121,0	1,0	9	■
JS720200D3R200.0Z9C-HXT	10067532	3	D	■	20,0	20,0	62,0	121,0	2,0	9	■
JS720200D3R300.0Z9C-HXT	10067533	3	D	■	20,0	20,0	62,0	121,0	3,0	9	■
JS720250D3R100.0Z9C-HXT	10067534	3	D	■	25,0	25,0	78,0	146,0	1,0	9	■
JS720250D3R200.0Z9C-HXT	10067535	3	D	■	25,0	25,0	78,0	146,0	2,0	9	■
JS720250D3R300.0Z9C-HXT	10067536	3	D	■	25,0	25,0	78,0	146,0	3,0	9	■

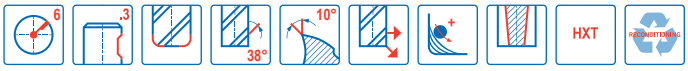
■ Stocked standard.

JS720

High performance – Titanium – Square – 6 Flutes – Weldon – Corner radius



D



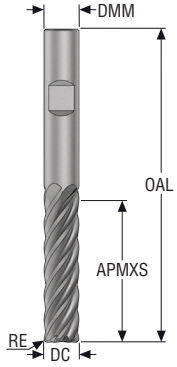
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720060D2R050.3Z6-HXT	03060339	2	D	6,0	6,0	17,0	57,0	0,5	6	☐
JS720060D2R100.3Z6-HXT	03060340	2	D	6,0	6,0	17,0	57,0	1,0	6	☐
JS720080D2R050.3Z6-HXT	03060341	2	D	8,0	8,0	23,0	63,0	0,5	6	☐
JS720080D2R100.3Z6-HXT	03061295	2	D	8,0	8,0	23,0	63,0	1,0	6	☐
JS720100D2R050.3Z6-HXT	03060342	2	D	10,0	10,0	26,0	72,0	0,5	6	☐
JS720100D2R100.3Z6-HXT	03060344	2	D	10,0	10,0	26,0	72,0	1,0	6	☐
JS720100D2R200.3Z6-HXT	03060345	2	D	10,0	10,0	26,0	72,0	2,0	6	☐
JS720100D2R300.3Z6-HXT	03060346	2	D	10,0	10,0	26,0	72,0	3,0	6	☐
JS720120D2R050.3Z6-HXT	03060347	2	D	12,0	12,0	30,0	83,0	0,5	6	☐
JS720120D2R100.3Z6-HXT	03060349	2	D	12,0	12,0	30,0	83,0	1,0	6	☐
JS720120D2R200.3Z6-HXT	03060350	2	D	12,0	12,0	30,0	83,0	2,0	6	☐
JS720120D2R300.3Z6-HXT	03060351	2	D	12,0	12,0	30,0	83,0	3,0	6	☐
JS720160D2R050.3Z6-HXT	03060352	2	D	16,0	16,0	44,0	99,0	0,5	6	☐
JS720160D2R100.3Z6-HXT	03060354	2	D	16,0	16,0	44,0	99,0	1,0	6	☐
JS720160D2R200.3Z6-HXT	03060355	2	D	16,0	16,0	44,0	99,0	2,0	6	☐
JS720160D2R300.3Z6-HXT	03060356	2	D	16,0	16,0	44,0	99,0	3,0	6	☐
JS720160D2R400.3Z6-HXT	03060357	2	D	16,0	16,0	44,0	99,0	4,0	6	☐
JS720160D2R600.3Z6-HXT	03060358	2	D	16,0	16,0	44,0	99,0	6,0	6	☐
JS720200D2R050.3Z6-HXT	10228444	2	D	20,0	20,0	45,0	105,0	0,5	6	☐
JS720200D2R100.3Z6-HXT	10228445	2	D	20,0	20,0	45,0	105,0	1,0	6	☐
JS720200D2R200.3Z6-HXT	10228446	2	D	20,0	20,0	45,0	105,0	2,0	6	☐
JS720200D2R300.3Z6-HXT	10228447	2	D	20,0	20,0	45,0	105,0	3,0	6	☐
JS720250D2R050.3Z6-HXT	10228448	2	D	25,0	25,0	50,0	125,0	0,5	6	☐
JS720250D2R100.3Z6-HXT	10228449	2	D	25,0	25,0	50,0	125,0	1,0	6	☐
JS720250D2R200.3Z6-HXT	10228450	2	D	25,0	25,0	50,0	125,0	2,0	6	☐
JS720250D2R300.3Z6-HXT	10228451	2	D	25,0	25,0	50,0	125,0	3,0	6	☐

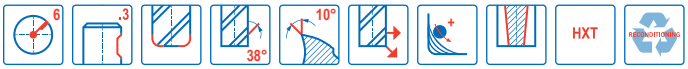
■ Stocked standard. ☐ Weldon available. Delivery time is 3 days.

JS720

High performance – Titanium – Square – 6 Flutes – Weldon – Corner radius



D



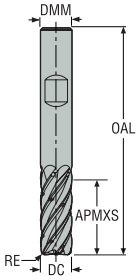
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720080D3R050.3Z6-HXT	10228452	3	D	8,0	8,0	32,0	80,0	0,5	6	☐
JS720080D3R100.3Z6-HXT	10228453	3	D	8,0	8,0	32,0	80,0	1,0	6	☐
JS720100D3R050.3Z6-HXT	10228454	3	D	10,0	10,0	40,0	89,0	0,5	6	☐
JS720100D3R100.3Z6-HXT	10228455	3	D	10,0	10,0	40,0	89,0	1,0	6	☐
JS720100D3R200.3Z6-HXT	10228456	3	D	10,0	10,0	40,0	89,0	2,0	6	☐
JS720120D3R050.3Z6-HXT	10228457	3	D	12,0	12,0	45,0	100,0	0,5	6	☐
JS720120D3R100.3Z6-HXT	10228458	3	D	12,0	12,0	45,0	100,0	1,0	6	☐
JS720120D3R200.3Z6-HXT	10228459	3	D	12,0	12,0	45,0	100,0	2,0	6	☐
JS720160D3R050.3Z6-HXT	10228460	3	D	16,0	16,0	65,0	130,0	0,5	6	☐
JS720160D3R100.3Z6-HXT	10228461	3	D	16,0	16,0	65,0	130,0	1,0	6	☐
JS720160D3R200.3Z6-HXT	10228462	3	D	16,0	16,0	65,0	130,0	2,0	6	☐
JS720160D3R300.3Z6-HXT	10228463	3	D	16,0	16,0	6,0	130,0	3,0	6	☐
JS720200D3R050.3Z6-HXT	03060359	3	D	20,0	20,0	62,0	121,0	0,5	6	☐
JS720200D3R100.3Z6-HXT	03060361	3	D	20,0	20,0	62,0	121,0	1,0	6	☐
JS720200D3R200.3Z6-HXT	03060362	3	D	20,0	20,0	62,0	121,0	2,0	6	☐
JS720200D3R300.3Z6-HXT	03060363	3	D	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R400.3Z6-HXT	03060364	3	D	20,0	20,0	62,0	121,0	4,0	6	☐
JS720200D3R500.3Z6-HXT	03060365	3	D	20,0	20,0	62,0	121,0	5,0	6	☐
JS720200D3R600.3Z6-HXT	03060366	3	D	20,0	20,0	62,0	121,0	6,0	6	☐
JS720250D3R050.3Z6-HXT	03060367	3	D	25,0	25,0	78,0	146,0	0,5	6	☐
JS720250D3R100.3Z6-HXT	03060368	3	D	25,0	25,0	78,0	146,0	1,0	6	☐
JS720250D3R200.3Z6-HXT	03060369	3	D	25,0	25,0	78,0	146,0	2,0	6	☐
JS720250D3R300.3Z6-HXT	03060370	3	D	25,0	25,0	78,0	146,0	3,0	6	☐
JS720250D3R400.3Z6-HXT	03060371	3	D	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.3Z6-HXT	03060372	3	D	25,0	25,0	78,0	146,0	6,0	6	☐

■ Stocked standard. ☐ Weldon available. Delivery time is 3 days.

JS720

High performance – Titanium – Square – 6 Flutes – Weldon – Corner radius – Chip splitters



D

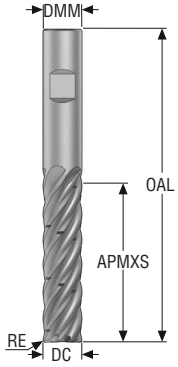
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720080D2R050.3Z6C-HXT	10228520	2	D	■	8,0	8,0	23,0	63,0	0,5	6	□
JS720080D2R100.3Z6C-HXT	10228521	2	D	■	8,0	8,0	23,0	63,0	1,0	6	□
JS720100D2R050.3Z6C-HXT	03060343	2	D	■	10,0	10,0	26,0	72,0	0,5	6	□
JS720100D2R100.3Z6C-HXT	10228522	2	D	■	10,0	10,0	26,0	72,0	1,0	6	□
JS720120D2R050.3Z6C-HXT	03060348	2	D	■	12,0	12,0	30,0	83,0	0,5	6	□
JS720120D2R100.3Z6C-HXT	03298308	2	D	■	12,0	12,0	30,0	83,0	1,0	6	□
JS720120D2R200.3Z6C-HXT	03298309	2	D	■	12,0	12,0	30,0	83,0	2,0	6	□
JS720120D2R250.3Z6C-HXT	03298310	2	D	■	12,0	12,0	30,0	83,0	2,5	6	□
JS720120D2R300.3Z6C-HXT	03298311	2	D	■	12,0	12,0	30,0	83,0	3,0	6	□
JS720120D2R310.3Z6C-HXT	03298312	2	D	■	12,0	12,0	30,0	83,0	3,1	6	□
JS720160D2R050.3Z6C-HXT	03060353	2	D	■	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.3Z6C-HXT	03298313	2	D	■	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.3Z6C-HXT	03298314	2	D	■	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R250.3Z6C-HXT	03298315	2	D	■	16,0	16,0	44,0	99,0	2,5	6	■
JS720160D2R300.3Z6C-HXT	03298316	2	D	■	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R310.3Z6C-HXT	03298317	2	D	■	16,0	16,0	44,0	99,0	3,1	6	■
JS720160D2R400.3Z6C-HXT	03298318	2	D	■	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.3Z6C-HXT	03298319	2	D	■	16,0	16,0	44,0	99,0	6,0	6	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS720

High performance – Titanium – Square – 6 Flutes – Weldon – Corner radius – Chip splitters



D

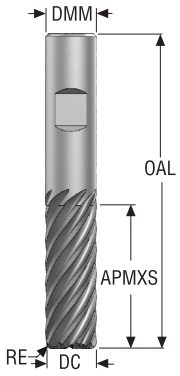
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720160D3R050.3Z6C-HXT	10228523	3	D	■	16,0	16,0	65,0	130,0	0,5	6	□
JS720160D3R100.3Z6C-HXT	10228524	3	D	■	16,0	16,0	65,0	130,0	1,0	6	□
JS720160D3R200.3Z6C-HXT	10228525	3	D	■	16,0	16,0	65,0	130,0	2,0	6	□
JS720160D3R300.3Z6C-HXT	10228526	3	D	■	16,0	16,0	65,0	130,0	3,0	6	□
JS720200D3R050.3Z6C-HXT	03060360	3	D	■	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.3Z6C-HXT	03298320	3	D	■	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.3Z6C-HXT	03298321	3	D	■	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R250.3Z6C-HXT	03298322	3	D	■	20,0	20,0	62,0	121,0	2,5	6	■
JS720200D3R300.3Z6C-HXT	03298323	3	D	■	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R310.3Z6C-HXT	03298324	3	D	■	20,0	20,0	62,0	121,0	3,1	6	■
JS720200D3R400.3Z6C-HXT	03298325	3	D	■	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.3Z6C-HXT	03298326	3	D	■	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.3Z6C-HXT	03298327	3	D	■	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.3Z6C-HXT	03066460	3	D	■	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.3Z6C-HXT	03298328	3	D	■	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.3Z6C-HXT	03298329	3	D	■	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.3Z6C-HXT	03298330	3	D	■	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.3Z6C-HXT	03298331	3	D	■	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.3Z6C-HXT	03298332	3	D	■	25,0	25,0	78,0	146,0	6,0	6	■

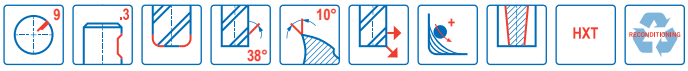
■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS720

High performance – Titanium – Square – 9 Flutes – Weldon – Corner radius



D



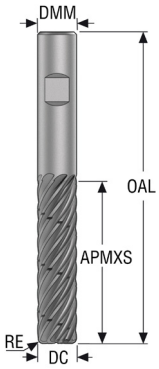
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720100D2R050.3Z9-HXT	10067881	2	D	10,0	10,0	26,0	72,0	0,5	9	☐
JS720100D2R100.3Z9-HXT	10067882	2	D	10,0	10,0	26,0	72,0	1,0	9	☐
JS720100D2R200.3Z9-HXT	10067883	2	D	10,0	10,0	26,0	72,0	2,0	9	☐
JS720120D2R050.3Z9-HXT	10067884	2	D	12,0	12,0	30,0	83,0	0,5	9	☐
JS720120D2R100.3Z9-HXT	10067885	2	D	12,0	12,0	30,0	83,0	1,0	9	☐
JS720120D2R200.3Z9-HXT	10067886	2	D	12,0	12,0	30,0	83,0	2,0	9	☐
JS720160D2R100.3Z9-HXT	10008279	2	D	16,0	16,0	44,0	99,0	1,0	9	☐
JS720160D2R200.3Z9-HXT	10008280	2	D	16,0	16,0	44,0	99,0	2,0	9	☐
JS720160D2R300.3Z9-HXT	10008281	2	D	16,0	16,0	44,0	99,0	3,0	9	☐
JS720200D2R100.3Z9-HXT	10228396	2	D	20,0	20,0	45,0	105,0	1,0	9	☐
JS720200D2R200.3Z9-HXT	10228397	2	D	20,0	20,0	45,0	105,0	2,0	9	☐
JS720200D2R300.3Z9-HXT	10228398	2	D	20,0	20,0	45,0	105,0	3,0	9	☐
JS720250D2R100.3Z9-HXT	10008282	2	D	25,0	25,0	50,0	125,0	1,0	9	☐
JS720250D2R200.3Z9-HXT	10008283	2	D	25,0	25,0	50,0	125,0	2,0	9	☐
JS720250D2R300.3Z9-HXT	10008284	2	D	25,0	25,0	50,0	125,0	3,0	9	☐
JS720100D3R050.3Z9-HXT	10067887	3	D	10,0	10,0	40,0	89,0	0,5	9	☐
JS720100D3R100.3Z9-HXT	10067888	3	D	10,0	10,0	40,0	89,0	1,0	9	☐
JS720100D3R200.3Z9-HXT	10067889	3	D	10,0	10,0	40,0	89,0	2,0	9	☐
JS720120D3R050.3Z9-HXT	10067890	3	D	12,0	12,0	45,0	100,0	0,5	9	☐
JS720120D3R100.3Z9-HXT	10067891	3	D	12,0	12,0	45,0	100,0	1,0	9	☐
JS720120D3R200.3Z9-HXT	10067892	3	D	12,0	12,0	45,0	100,0	2,0	9	☐
JS720160D3R100.3Z9-HXT	10008285	3	D	16,0	16,0	65,0	130,0	1,0	9	☐
JS720160D3R200.3Z9-HXT	10008286	3	D	16,0	16,0	65,0	130,0	2,0	9	☐
JS720160D3R300.3Z9-HXT	10008287	3	D	16,0	16,0	65,0	130,0	3,0	9	☐
JS720200D3R100.3Z9-HXT	10008288	3	D	20,0	20,0	62,0	121,0	1,0	9	☐
JS720200D3R200.3Z9-HXT	10008289	3	D	20,0	20,0	62,0	121,0	2,0	9	☐
JS720200D3R300.3Z9-HXT	10008290	3	D	20,0	20,0	62,0	121,0	3,0	9	☐
JS720250D3R100.3Z9-HXT	10008292	3	D	25,0	25,0	78,0	146,0	1,0	9	☐
JS720250D3R200.3Z9-HXT	10008293	3	D	25,0	25,0	78,0	146,0	2,0	9	☐
JS720250D3R300.3Z9-HXT	10008294	3	D	25,0	25,0	78,0	146,0	3,0	9	☐

☐ Weldon available. Delivery time is 3 days.

JS720

High performance – Titanium – Square – 9 Flutes – Weldon – Corner radius – Chip splitters



D

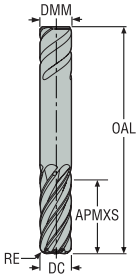
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720100D3R050.3Z9C-HXT	10067893	3	D	■	10,0	10,0	40,0	89,0	0,5	9	□
JS720100D3R100.3Z9C-HXT	10067894	3	D	■	10,0	10,0	40,0	89,0	1,0	9	□
JS720100D3R200.3Z9C-HXT	10067895	3	D	■	10,0	10,0	40,0	89,0	2,0	9	□
JS720120D3R050.3Z9C-HXT	10067897	3	D	■	12,0	12,0	45,0	100,0	0,5	9	□
JS720120D3R100.3Z9C-HXT	10067898	3	D	■	12,0	12,0	45,0	100,0	1,0	9	□
JS720120D3R200.3Z9C-HXT	10067899	3	D	■	12,0	12,0	45,0	100,0	2,0	9	□
JS720160D3R100.3Z9C-HXT	10067900	3	D	■	16,0	16,0	65,0	130,0	1,0	9	□
JS720160D3R200.3Z9C-HXT	10067901	3	D	■	16,0	16,0	65,0	130,0	2,0	9	□
JS720160D3R300.3Z9C-HXT	10067902	3	D	■	16,0	16,0	65,0	130,0	3,0	9	□
JS720200D3R100.3Z9C-HXT	10067903	3	D	■	20,0	20,0	62,0	121,0	1,0	9	□
JS720200D3R200.3Z9C-HXT	10067904	3	D	■	20,0	20,0	62,0	121,0	2,0	9	□
JS720200D3R300.3Z9C-HXT	10067905	3	D	■	20,0	20,0	62,0	121,0	3,0	9	□
JS720250D3R100.3Z9C-HXT	10067906	3	D	■	25,0	25,0	78,0	146,0	1,0	9	□
JS720250D3R200.3Z9C-HXT	10067907	3	D	■	25,0	25,0	78,0	146,0	2,0	9	□
JS720250D3R300.3Z9C-HXT	10067908	3	D	■	25,0	25,0	78,0	146,0	3,0	9	□

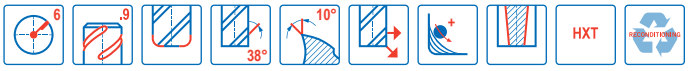
■ Stocked standard.

JS720

High performance – Titanium – Square – 6 Flutes – Safelock – Corner radius



D



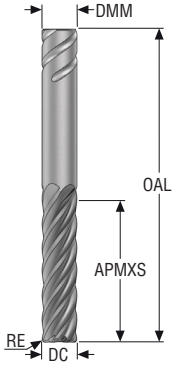
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm		
JS720060D2R050.9Z6-HXT	03060374	2	D	6,0	6,0	17,0	57,0	0,5	6	☐
JS720060D2R100.9Z6-HXT	03060375	2	D	6,0	6,0	17,0	57,0	1,0	6	☐
JS720080D2R050.9Z6-HXT	03060376	2	D	8,0	8,0	23,0	63,0	0,5	6	☐
JS720080D2R100.9Z6-HXT	03061296	2	D	8,0	8,0	23,0	63,0	1,0	6	☐
JS720100D2R050.9Z6-HXT	03060377	2	D	10,0	10,0	26,0	72,0	0,5	6	☐
JS720100D2R100.9Z6-HXT	03060379	2	D	10,0	10,0	26,0	72,0	1,0	6	☐
JS720100D2R200.9Z6-HXT	03060380	2	D	10,0	10,0	26,0	72,0	2,0	6	☐
JS720100D2R300.9Z6-HXT	03060381	2	D	10,0	10,0	26,0	72,0	3,0	6	☐
JS720120D2R050.9Z6-HXT	03060382	2	D	12,0	12,0	30,0	83,0	0,5	6	☐
JS720120D2R100.9Z6-HXT	03060384	2	D	12,0	12,0	30,0	83,0	1,0	6	☐
JS720120D2R200.9Z6-HXT	03060385	2	D	12,0	12,0	30,0	83,0	2,0	6	☐
JS720120D2R300.9Z6-HXT	03060386	2	D	12,0	12,0	30,0	83,0	3,0	6	☐
JS720160D2R050.9Z6-HXT	03060387	2	D	16,0	16,0	44,0	99,0	0,5	6	☐
JS720160D2R100.9Z6-HXT	03060389	2	D	16,0	16,0	44,0	99,0	1,0	6	☐
JS720160D2R200.9Z6-HXT	03060390	2	D	16,0	16,0	44,0	99,0	2,0	6	☐
JS720160D2R300.9Z6-HXT	03060391	2	D	16,0	16,0	44,0	99,0	3,0	6	☐
JS720160D2R400.9Z6-HXT	03060392	2	D	16,0	16,0	44,0	99,0	4,0	6	☐
JS720160D2R600.9Z6-HXT	03060393	2	D	16,0	16,0	44,0	99,0	6,0	6	☐
JS720200D2R050.9Z6-HXT	10228464	2	D	20,0	20,0	45,0	105,0	0,5	6	☐
JS720200D2R100.9Z6-HXT	10228465	2	D	20,0	20,0	45,0	105,0	1,0	6	☐
JS720200D2R200.9Z6-HXT	10228467	2	D	20,0	20,0	45,0	105,0	2,0	6	☐
JS720200D2R300.9Z6-HXT	10228468	2	D	20,0	20,0	45,0	105,0	3,0	6	☐
JS720250D2R050.9Z6-HXT	10228469	2	D	25,0	25,0	50,0	125,0	0,5	6	☐
JS720250D2R100.9Z6-HXT	10228470	2	D	25,0	25,0	50,0	125,0	1,0	6	☐
JS720250D2R200.9Z6-HXT	10228471	2	D	25,0	25,0	50,0	125,0	2,0	6	☐
JS720250D2R300.9Z6-HXT	10228472	2	D	25,0	25,0	50,0	125,0	3,0	6	☐

☐ Safelock available. Delivery time is 6 days.

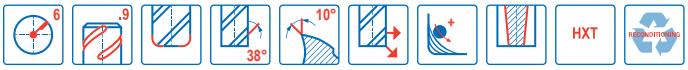
JS720

High performance – Titanium – Square – 6 Flutes – Safelock – Corner radius



D

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

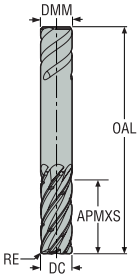


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm		
JS720080D3R050.9Z6-HXT	10228473	3	D	8,0	8,0	32,0	80,0	0,5	6	☐
JS720080D3R100.9Z6-HXT	10228474	3	D	8,0	8,0	32,0	80,0	1,0	6	☐
JS720100D3R050.9Z6-HXT	10228475	3	D	10,0	10,0	40,0	89,0	0,5	6	☐
JS720100D3R100.9Z6-HXT	10228476	3	D	10,0	10,0	40,0	89,0	1,0	6	☐
JS720100D3R200.9Z6-HXT	10228477	3	D	10,0	10,0	40,0	89,0	2,0	6	☐
JS720120D3R050.9Z6-HXT	10228478	3	D	12,0	12,0	45,0	100,0	0,5	6	☐
JS720120D3R100.9Z6-HXT	10228479	3	D	12,0	12,0	45,0	100,0	1,0	6	☐
JS720120D3R200.9Z6-HXT	10228480	3	D	12,0	12,0	45,0	100,0	2,0	6	☐
JS720160D3R050.9Z6-HXT	10228481	3	D	16,0	16,0	65,0	130,0	0,5	6	☐
JS720160D3R100.9Z6-HXT	10228482	3	D	16,0	16,0	65,0	130,0	1,0	6	☐
JS720160D3R200.9Z6-HXT	10228483	3	D	16,0	16,0	65,0	130,0	2,0	6	☐
JS720160D3R300.9Z6-HXT	10228484	3	D	16,0	16,0	65,0	130,0	3,0	6	☐
JS720200D3R050.9Z6-HXT	03060394	3	D	20,0	20,0	62,0	121,0	0,5	6	☐
JS720200D3R100.9Z6-HXT	03060396	3	D	20,0	20,0	62,0	121,0	1,0	6	☐
JS720200D3R200.9Z6-HXT	03060397	3	D	20,0	20,0	62,0	121,0	2,0	6	☐
JS720200D3R300.9Z6-HXT	03060398	3	D	20,0	20,0	62,0	121,0	3,0	6	☐
JS720200D3R400.9Z6-HXT	03060399	3	D	20,0	20,0	62,0	121,0	4,0	6	☐
JS720200D3R500.9Z6-HXT	03060400	3	D	20,0	20,0	62,0	121,0	5,0	6	☐
JS720200D3R600.9Z6-HXT	03060401	3	D	20,0	20,0	62,0	121,0	6,0	6	☐
JS720250D3R050.9Z6-HXT	03060402	3	D	25,0	25,0	78,0	146,0	0,5	6	☐
JS720250D3R100.9Z6-HXT	03060403	3	D	25,0	25,0	78,0	146,0	1,0	6	☐
JS720250D3R200.9Z6-HXT	03060404	3	D	25,0	25,0	78,0	146,0	2,0	6	☐
JS720250D3R300.9Z6-HXT	03060405	3	D	25,0	25,0	78,0	146,0	3,0	6	☐
JS720250D3R400.9Z6-HXT	03060406	3	D	25,0	25,0	78,0	146,0	4,0	6	☐
JS720250D3R600.9Z6-HXT	03060407	3	D	25,0	25,0	78,0	146,0	6,0	6	☐

☐ Safelock available. Delivery time is 6 days.

JS720

High performance – Titanium – Square – 6 Flutes – Safelock – Corner radius – Chip splitters



D

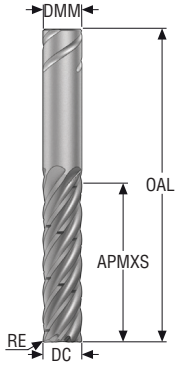
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm		
JS720080D2R050.9Z6C-HXT	10228527	2	D	■	8,0	8,0	23,0	63,0	0,5	6	□
JS720080D2R100.9Z6C-HXT	10228528	2	D	■	8,0	8,0	23,0	63,0	1,0	6	□
JS720100D2R050.9Z6C-HXT	03060378	2	D	■	10,0	10,0	26,0	72,0	0,5	6	□
JS720100D2R100.9Z6C-HXT	10228529	2	D	■	10,0	10,0	26,0	72,0	1,0	6	□
JS720120D2R050.9Z6C-HXT	03060383	2	D	■	12,0	12,0	30,0	83,0	0,5	6	□
JS720120D2R100.9Z6C-HXT	03298334	2	D	■	12,0	12,0	30,0	83,0	1,0	6	□
JS720120D2R200.9Z6C-HXT	03298335	2	D	■	12,0	12,0	30,0	83,0	2,0	6	□
JS720120D2R250.9Z6C-HXT	03298336	2	D	■	12,0	12,0	30,0	83,0	2,5	6	□
JS720120D2R300.9Z6C-HXT	03298337	2	D	■	12,0	12,0	30,0	83,0	3,0	6	□
JS720120D2R310.9Z6C-HXT	03298338	2	D	■	12,0	12,0	30,0	83,0	3,1	6	□
JS720160D2R050.9Z6C-HXT	03060388	2	D	■	16,0	16,0	44,0	99,0	0,5	6	□
JS720160D2R100.9Z6C-HXT	03298339	2	D	■	16,0	16,0	44,0	99,0	1,0	6	□
JS720160D2R200.9Z6C-HXT	03298340	2	D	■	16,0	16,0	44,0	99,0	2,0	6	□
JS720160D2R250.9Z6C-HXT	03298341	2	D	■	16,0	16,0	44,0	99,0	2,5	6	□
JS720160D2R300.9Z6C-HXT	03298342	2	D	■	16,0	16,0	44,0	99,0	3,0	6	□
JS720160D2R310.9Z6C-HXT	03298343	2	D	■	16,0	16,0	44,0	99,0	3,1	6	□
JS720160D2R400.9Z6C-HXT	03298344	2	D	■	16,0	16,0	44,0	99,0	4,0	6	□
JS720160D2R600.9Z6C-HXT	03298345	2	D	■	16,0	16,0	44,0	99,0	6,0	6	□

■ Stocked standard.

JS720

High performance – Titanium – Square – 6 Flutes – Safelock – Corner radius – Chip splitters



D

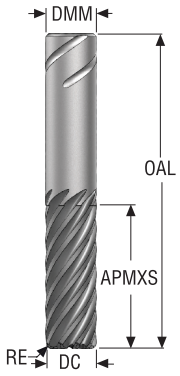
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm		
JS720160D3R050.9Z6C-HXT	10228530	3	D	■	16,0	16,0	65,0	130,0	0,5	6	□
JS720160D3R100.9Z6C-HXT	10228531	3	D	■	16,0	16,0	65,0	130,0	1,0	6	□
JS720160D3R200.9Z6C-HXT	10228532	3	D	■	16,0	16,0	65,0	130,0	2,0	6	□
JS720160D3R300.9Z6C-HXT	10228533	3	D	■	16,0	16,0	65,0	130,0	3,0	6	□
JS720200D3R050.9Z6C-HXT	03060395	3	D	■	20,0	20,0	62,0	121,0	0,5	6	□
JS720200D3R100.9Z6C-HXT	03298346	3	D	■	20,0	20,0	62,0	121,0	1,0	6	□
JS720200D3R200.9Z6C-HXT	03298347	3	D	■	20,0	20,0	62,0	121,0	2,0	6	□
JS720200D3R250.9Z6C-HXT	03298348	3	D	■	20,0	20,0	62,0	121,0	2,5	6	□
JS720200D3R300.9Z6C-HXT	03298349	3	D	■	20,0	20,0	62,0	121,0	3,0	6	□
JS720200D3R310.9Z6C-HXT	03298350	3	D	■	20,0	20,0	62,0	121,0	3,1	6	□
JS720200D3R400.9Z6C-HXT	03298351	3	D	■	20,0	20,0	62,0	121,0	4,0	6	□
JS720200D3R500.9Z6C-HXT	03298352	3	D	■	20,0	20,0	62,0	121,0	5,0	6	□
JS720200D3R600.9Z6C-HXT	03298353	3	D	■	20,0	20,0	62,0	121,0	6,0	6	□
JS720250D3R050.9Z6C-HXT	03066461	3	D	■	25,0	25,0	78,0	146,0	0,5	6	□
JS720250D3R100.9Z6C-HXT	03298354	3	D	■	25,0	25,0	78,0	146,0	1,0	6	□
JS720250D3R200.9Z6C-HXT	03298355	3	D	■	25,0	25,0	78,0	146,0	2,0	6	□
JS720250D3R300.9Z6C-HXT	03298356	3	D	■	25,0	25,0	78,0	146,0	3,0	6	□
JS720250D3R400.9Z6C-HXT	03298357	3	D	■	25,0	25,0	78,0	146,0	4,0	6	□
JS720250D3R600.9Z6C-HXT	03298358	3	D	■	25,0	25,0	78,0	146,0	6,0	6	□

■ Stocked standard.

JS720

High performance – Titanium – Square – 9 Flutes – Safelock – Corner radius



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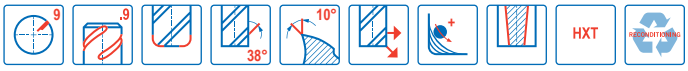


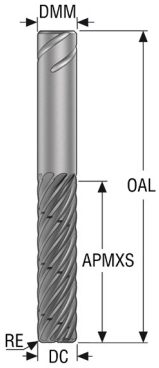
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm		
JS720100D2R050.9Z9-HXT	10067909	2	D	10,0	10,0	26,0	72,0	0,5	9	☐
JS720100D2R100.9Z9-HXT	10067910	2	D	10,0	10,0	26,0	72,0	1,0	9	☐
JS720100D2R200.9Z9-HXT	10067911	2	D	10,0	10,0	26,0	72,0	2,0	9	☐
JS720120D2R050.9Z9-HXT	10067912	2	D	12,0	12,0	30,0	83,0	0,5	9	☐
JS720120D2R100.9Z9-HXT	10067913	2	D	12,0	12,0	30,0	83,0	1,0	9	☐
JS720120D2R200.9Z9-HXT	10067914	2	D	12,0	12,0	30,0	83,0	2,0	9	☐
JS720160D2R100.9Z9-HXT	10008295	2	D	16,0	16,0	44,0	99,0	1,0	9	☐
JS720160D2R200.9Z9-HXT	10008296	2	D	16,0	16,0	44,0	99,0	2,0	9	☐
JS720160D2R300.9Z9-HXT	10008297	2	D	16,0	16,0	44,0	99,0	3,0	9	☐
JS720200D2R100.9Z9-HXT	10228399	2	D	20,0	20,0	45,0	105,0	1,0	9	☐
JS720200D2R200.9Z9-HXT	10228400	2	D	20,0	20,0	45,0	105,0	2,0	9	☐
JS720200D2R300.9Z9-HXT	10228401	2	D	20,0	20,0	45,0	105,0	3,0	9	☐
JS720250D2R100.9Z9-HXT	10008298	2	D	25,0	25,0	50,0	125,0	1,0	9	☐
JS720250D2R200.9Z9-HXT	10008299	2	D	25,0	25,0	50,0	125,0	2,0	9	☐
JS720250D2R300.9Z9-HXT	10008300	2	D	25,0	25,0	50,0	125,0	3,0	9	☐
JS720100D3R050.9Z9-HXT	10067915	3	D	10,0	10,0	40,0	89,0	0,5	9	☐
JS720100D3R100.9Z9-HXT	10067916	3	D	10,0	10,0	40,0	89,0	1,0	9	☐
JS720100D3R200.9Z9-HXT	10067917	3	D	10,0	10,0	40,0	89,0	2,0	9	☐
JS720120D3R050.9Z9-HXT	10067918	3	D	12,0	12,0	45,0	100,0	0,5	9	☐
JS720120D3R100.9Z9-HXT	10067919	3	D	12,0	12,0	45,0	100,0	1,0	9	☐
JS720120D3R200.9Z9-HXT	10067921	3	D	12,0	12,0	45,0	100,0	2,0	9	☐
JS720160D3R100.9Z9-HXT	10008301	3	D	16,0	16,0	65,0	130,0	1,0	9	☐
JS720160D3R200.9Z9-HXT	10008302	3	D	16,0	16,0	65,0	130,0	2,0	9	☐
JS720160D3R300.9Z9-HXT	10008303	3	D	16,0	16,0	65,0	130,0	3,0	9	☐
JS720200D3R100.9Z9-HXT	10008304	3	D	20,0	20,0	62,0	121,0	1,0	9	☐
JS720200D3R200.9Z9-HXT	10008305	3	D	20,0	20,0	62,0	121,0	2,0	9	☐
JS720200D3R300.9Z9-HXT	10008306	3	D	20,0	20,0	62,0	121,0	3,0	9	☐
JS720250D3R100.9Z9-HXT	10008307	3	D	25,0	25,0	78,0	146,0	1,0	9	☐
JS720250D3R200.9Z9-HXT	10008308	3	D	25,0	25,0	78,0	146,0	2,0	9	☐
JS720250D3R300.9Z9-HXT	10008309	3	D	25,0	25,0	78,0	146,0	3,0	9	☐

☐ Safelock available. Delivery time is 6 days.

JS720

High performance – Titanium – Square – 9 Flutes – Safelock – Corner radius – Chip splitters



D

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Chip splitters
- Regrind possible

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm		
JS720100D3R050.9Z9C-HXT	10067922	3	D	■	10,0	10,0	40,0	89,0	0,5	9	□
JS720100D3R100.9Z9C-HXT	10067923	3	D	■	10,0	10,0	40,0	89,0	1,0	9	□
JS720100D3R200.9Z9C-HXT	10067924	3	D	■	10,0	10,0	40,0	89,0	2,0	9	□
JS720120D3R050.9Z9C-HXT	10067925	3	D	■	12,0	12,0	45,0	100,0	0,5	9	□
JS720120D3R100.9Z9C-HXT	10067926	3	D	■	12,0	12,0	45,0	100,0	1,0	9	□
JS720120D3R200.9Z9C-HXT	10067927	3	D	■	12,0	12,0	45,0	100,0	2,0	9	□
JS720160D3R100.9Z9C-HXT	10067928	3	D	■	16,0	16,0	65,0	130,0	1,0	9	□
JS720160D3R200.9Z9C-HXT	10067929	3	D	■	16,0	16,0	65,0	130,0	2,0	9	□
JS720160D3R300.9Z9C-HXT	10067930	3	D	■	16,0	16,0	65,0	130,0	3,0	9	□
JS720200D3R100.9Z9C-HXT	10067931	3	D	■	20,0	20,0	62,0	121,0	1,0	9	□
JS720200D3R200.9Z9C-HXT	10067932	3	D	■	20,0	20,0	62,0	121,0	2,0	9	□
JS720200D3R300.9Z9C-HXT	10067933	3	D	■	20,0	20,0	62,0	121,0	3,0	9	□
JS720250D3R100.9Z9C-HXT	10067934	3	D	■	25,0	25,0	78,0	146,0	1,0	9	□
JS720250D3R200.9Z9C-HXT	10067935	3	D	■	25,0	25,0	78,0	146,0	2,0	9	□
JS720250D3R300.9Z9C-HXT	10067936	3	D	■	25,0	25,0	78,0	146,0	3,0	9	□

■ Stocked standard.

Cutting data – JS720 Side milling PCEDC =6

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	110 (85 — 140) *360 (280 — 450)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	90 (70 — 110) *295 (230 — 360)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	70 (55 — 99) *230 (190 — 320)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	65 (50 — 83) *215 (170 — 270)*
S1	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	43 (29 — 71) *140 (96 — 230)*
S2	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	34 (23 — 57) *110 (76 — 180)*
S3	E	0.0500 *0,0500*	2.6 *2,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	30 (20 — 49) *100 (66 — 160)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	105 (78 — 120) *345 (260 — 390)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*

Cutting data – JS720 Side milling advanced roughing a_e/DC=0,07 PCEDC =6

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	140 (110 — 180) *460 (370 — 590)*
M2	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	115 (91 — 150) *375 (300 — 490)*
M3	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	90 (72 — 120) *295 (240 — 390)*
M4	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*
M5	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	85 (65 — 100) *280 (220 — 320)*
S1	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	41 (28 — 68) *135 (92 — 220)*
S2	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	33 (22 — 54) *110 (73 — 170)*
S3	E	2.6 *2,6*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	29 (20 — 47) *95 (66 — 150)*
S11	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	135 (110 — 160) *445 (370 — 520)*
S12	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*
S13	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JS720 Side milling advanced roughing a_e/DC=0,07 PCEDC =9

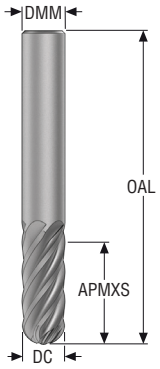
SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
M1	E	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	125 (98 — 160) *410 (330 — 520)*
M2	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (82 — 130) *345 (270 — 420)*
M3	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	80 (64 — 110) *260 (210 — 360)*
M4	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*
M5	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	75 (59 — 96) *245 (200 — 310)*
S1	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	37 (25 — 61) *120 (83 — 200)*
S2	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	30 (20 — 49) *100 (66 — 160)*
S3	E	2.8 *2,8*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	26 (18 — 43) *85 (60 — 140)*
S11	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	120 (91 — 150) *395 (300 — 490)*
S12	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*
S13	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS730

High performance – Titanium – Ball nose – 6 Flutes – Cylindrical



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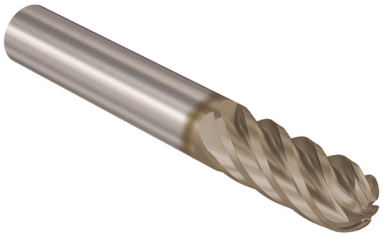
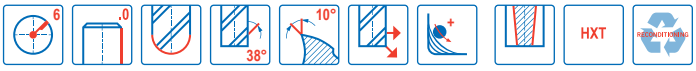




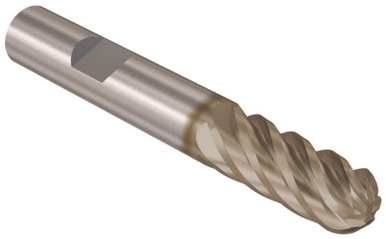
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Two flutes to centre
- Regrind possible

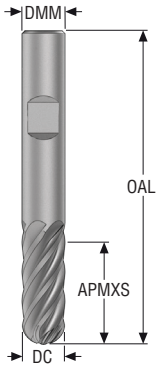
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
JS730060D2B.0Z6-HXT	03067605	2	D	6,0	6,0	17,0	57,0	6	■
JS730080D2B.0Z6-HXT	03067606	2	D	8,0	8,0	23,0	63,0	6	■
JS730100D2B.0Z6-HXT	03067607	2	D	10,0	10,0	26,0	72,0	6	■
JS730120D2B.0Z6-HXT	03067608	2	D	12,0	12,0	30,0	83,0	6	■
JS730160D2B.0Z6-HXT	03067609	2	D	16,0	16,0	44,0	99,0	6	■
JS730200D3B.0Z6-HXT	03067610	3	D	20,0	20,0	62,0	121,0	6	■
JS730250D3B.0Z6-HXT	03067611	3	D	25,0	25,0	78,0	146,0	6	■

■ Stocked standard.

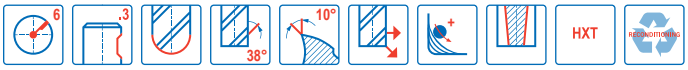
JS730

High performance – Titanium – Ball nose – 6 Flutes – Weldon





D



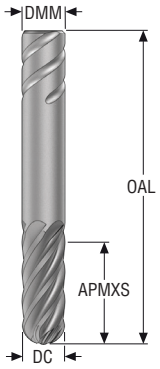
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Two flutes to centre
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS730060D2B.3Z6-HXT	03067778	2	D	6,0	6,0	17,0	57,0	6	☐
JS730080D2B.3Z6-HXT	03067779	2	D	8,0	8,0	23,0	63,0	6	☐
JS730100D2B.3Z6-HXT	03067780	2	D	10,0	10,0	26,0	72,0	6	☐
JS730120D2B.3Z6-HXT	03067781	2	D	12,0	12,0	30,0	83,0	6	☐
JS730160D2B.3Z6-HXT	03067782	2	D	16,0	16,0	44,0	99,0	6	☐
JS730200D3B.3Z6-HXT	03067783	3	D	20,0	20,0	62,0	121,0	6	☐
JS730250D3B.3Z6-HXT	03067784	3	D	25,0	25,0	78,0	146,0	6	☐

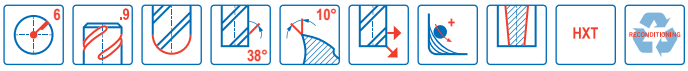
☐ Weldon available. Delivery time is 3 days.

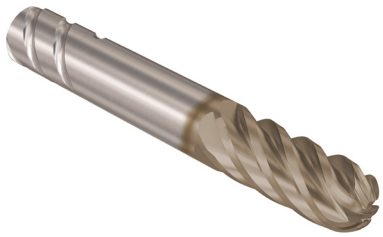
JS730

High performance – Titanium – Ball nose 6 Flutes – Safelock



D





- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Two flutes to centre
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Safelock
				mm	mm	mm	mm		
JS730060D2B.9Z6-HXT	03067785	2	D	6,0	6,0	17,0	57,0	6	☐
JS730080D2B.9Z6-HXT	03067786	2	D	8,0	8,0	23,0	63,0	6	☐
JS730100D2B.9Z6-HXT	03067787	2	D	10,0	10,0	26,0	72,0	6	☐
JS730120D2B.9Z6-HXT	03067788	2	D	12,0	12,0	30,0	83,0	6	☐
JS730160D2B.9Z6-HXT	03067789	2	D	16,0	16,0	44,0	99,0	6	☐
JS730200D3B.9Z6-HXT	03067790	3	D	20,0	20,0	62,0	121,0	6	☐
JS730250D3B.9Z6-HXT	03067791	3	D	25,0	25,0	78,0	146,0	6	☐

☐ Safelock available. Delivery time is 6 days.

Cutting data – JS730 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	140 (89 — 150) *460 (300 — 490)*
M2	E	0.150 *0,150*	2.2 *2,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (70 — 120) *360 (230 — 390)*
M3	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	85 (55 — 99) *280 (190 — 320)*
M4	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	90 (57 — 100) *295 (190 — 320)*
M5	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (47 — 85) *245 (160 — 270)*
S1	E	0.150 *0,150*	2.2 *2,2*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	43 (29 — 70) *140 (96 — 220)*
S2	E	0.150 *0,150*	2.2 *2,2*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	34 (23 — 57) *110 (76 — 180)*
S3	E	0.150 *0,150*	2.2 *2,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	30 (20 — 49) *100 (66 — 160)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	130 (79 — 130) *425 (260 — 420)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (61 — 100) *330 (210 — 320)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	100 (62 — 100) *330 (210 — 320)*

Cutting data – JS730 Side milling advanced roughing a_e/DC=0,07

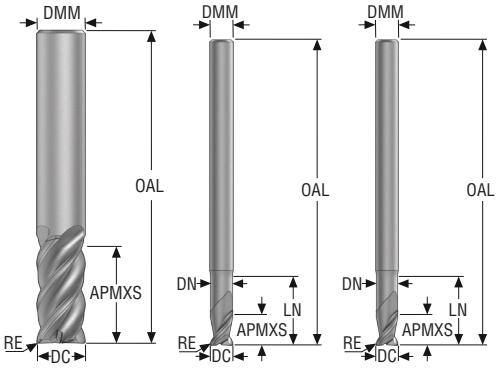
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	145 (93 — 150) *475 (310 — 490)*
M2	E	2.2 *2,2*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	125 (78 — 130) *410 (260 — 420)*
M3	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	90 (58 — 100) *295 (200 — 320)*
M4	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	95 (59 — 100) *310 (200 — 320)*
M5	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	80 (50 — 89) *260 (170 — 290)*
S1	E	2.2 *2,2*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	47 (32 — 79) *155 (110 — 250)*
S2	E	2.2 *2,2*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	38 (26 — 63) *125 (86 — 200)*
S3	E	2.2 *2,2*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	33 (23 — 55) *110 (76 — 180)*
S11	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (94 — 150) *490 (310 — 490)*
S12	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	115 (72 — 110) *375 (240 — 360)*
S13	E	1.9 *1,9*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	120 (74 — 120) *395 (250 — 390)*

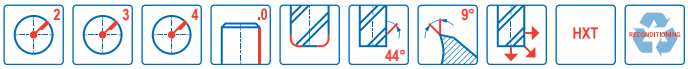
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHP751

High performance – Titanium – Square – 2-4 Flutes – Cylindrical – Corner radius





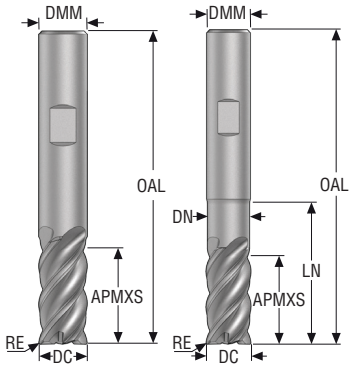
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JHP751080D1R040.0Z4	HXT	10105487	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	■
JHP751100D1R040.0Z4	HXT	10105548	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	■
JHP751100D1R150.0Z4	HXT	10105549	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	■
JHP751120D1R040.0Z4	HXT	10105550	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	■
JHP751120D1R150.0Z4	HXT	10105552	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	■
JHP751160D1R040.0Z4	HXT	10105581	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	■
JHP751160D1R150.0Z4	HXT	10105582	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	■
JHP751200D1R080.0Z4	HXT	10105583	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	■
JHP751020G2R020.0Z2	HXT	10105584	2	G	2,0	3,0	3,0	38,0	6,0	1,9	0,2	2	■
JHP751030G2R020.0Z2	HXT	10105585	2	E	3,0	3,0	4,5	38,0	9,0	2,8	0,2	2	■
JHP751040G2R020.0Z2	HXT	10105586	2	G	4,0	6,0	6,0	50,0	9,0	3,7	0,2	2	■
JHP751050G2R030.0Z2	HXT	10105587	2	G	5,0	6,0	7,5	50,0	9,0	4,6	0,3	2	■
JHP751060E2R030.0Z3	HXT	10105588	2	E	6,0	6,0	9,0	57,0	19,0	5,6	0,3	3	■
JHP751080E2R040.0Z4	HXT	10105589	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	■
JHP751100E2R040.0Z4	HXT	10105590	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	■
JHP751100E2R080.0Z4	HXT	10105591	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	■
JHP751100E2R200.0Z4	HXT	10105593	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	■
JHP751120E2R040.0Z4	HXT	10105594	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	■
JHP751120E2R080.0Z4	HXT	10105595	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	■
JHP751120E2R310.0Z4	HXT	10105596	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	■
JHP751140E2R080.0Z4	HXT	10105597	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	■
JHP751160E2R040.0Z4	HXT	10105598	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	■
JHP751160E2R080.0Z4	HXT	10105599	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	■
JHP751160E2R200.0Z4	HXT	10105600	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	■
JHP751200E2R080.0Z4	HXT	10105601	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	■

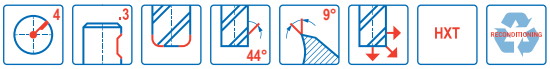
■ Stocked standard.

JHP751

High performance – Titanium – Square – 2-4 Flutes – Weldon – Corner radius



D E



- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP751080D1R040.3Z4	HXT	10105739	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	■
JHP751100D1R040.3Z4	HXT	10105740	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	■
JHP751100D1R150.3Z4	HXT	10105742	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	■
JHP751120D1R040.3Z4	HXT	10105743	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	■
JHP751120D1R150.3Z4	HXT	10105744	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	■
JHP751160D1R040.3Z4	HXT	10105745	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	■
JHP751160D1R150.3Z4	HXT	10105746	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	■
JHP751200D1R080.3Z4	HXT	10105747	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	■
JHP751080E2R040.3Z4	HXT	10105748	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	■
JHP751100E2R040.3Z4	HXT	10105749	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	■
JHP751100E2R080.3Z4	HXT	10105750	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	■
JHP751100E2R200.3Z4	HXT	10105751	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	■
JHP751120E2R040.3Z4	HXT	10105752	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	■
JHP751120E2R080.3Z4	HXT	10105753	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	■
JHP751120E2R310.3Z4	HXT	10105754	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	■
JHP751140E2R080.3Z4	HXT	10105755	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	■
JHP751160E2R040.3Z4	HXT	10105756	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	■
JHP751160E2R080.3Z4	HXT	10105757	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	■
JHP751160E2R200.3Z4	HXT	10105758	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	■
JHP751200E2R080.3Z4	HXT	10105759	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	■

■ Stocked standard.

Cutting data – JHP751 Side milling

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	48 (33 — 64) *155 (110 — 200)*
S2	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	39 (26 — 51) *130 (86 — 160)*
S3	E/M/A	0.0400 *0,0400*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	33 (26 — 50) *110 (86 — 160)*
S11	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	145 (130 — 180) *475 (430 — 590)*
S12	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	110 (95 — 140) *360 (320 — 450)*
S13	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	90 (76 — 110) *295 (250 — 360)*

Cutting data – JHP751 Slot milling

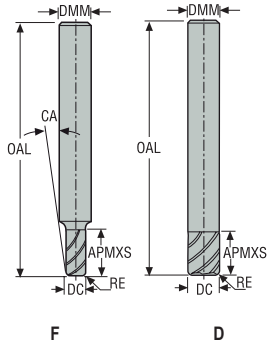
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	30 (20 — 39) *100 (66 — 120)*
S2	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	24 (17 — 32) *80 (56 — 100)*
S3	E/M/A	0.34 *0,34*	0.0046 *0,00018*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.034 *0,0013*	0.040 *0,0016*	20 (15 — 29) *65 (50 — 95)*
S11	E/M/A	0.70 *0,70*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	90 (78 — 110) *295 (260 — 360)*
S12	E/M/A	0.70 *0,70*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (60 — 89) *230 (200 — 290)*
S13	E/M/A	0.70 *0,70*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	55 (48 — 71) *180 (160 — 230)*

For cutting data recalculations, see pages 573 - 580

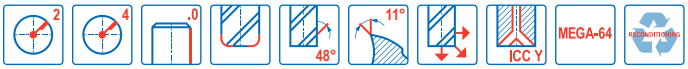
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHP760

High performance – ISO-M – Square – 2-4 Flutes – Cylindrical – Corner radius – ICC



- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Regrind possible if DC is ≥Ø6

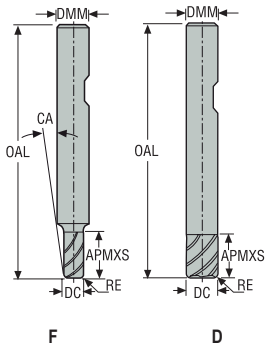


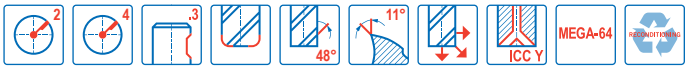
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm			
760040R020Z2.0A-MEGA-64	02734051	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0 °	2	■
760040R040Z2.0A-MEGA-64	02623413	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0 °	2	■
760050R020Z2.0A-MEGA-64	02734052	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0 °	2	■
760050R040Z2.0A-MEGA-64	02623435	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0 °	2	■
760060R020Z4.0A-MEGA-64	02734053	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	■
760060R040Z4.0A-MEGA-64	02623433	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	■
760080R040Z4.0A-MEGA-64	02623436	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	■
760080R100Z4.0A-MEGA-64	02623437	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	■
760100R040Z4.0A-MEGA-64	02623460	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	■
760100R100Z4.0A-MEGA-64	02623463	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	■
760100R150Z4.0A-MEGA-64	02623466	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	■
760120R040Z4.0A-MEGA-64	02623819	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	■
760120R100Z4.0A-MEGA-64	02623825	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	■
760120R150Z4.0A-MEGA-64	02623828	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	■
760120R310Z4.0A-MEGA-64	02623833	2	D	■	12,0	12,0	24,0	75,0	3,1	–	4	■
760200R040Z4.0A-MEGA-64	02734055	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	■
760200R080Z4.0A-MEGA-64	02623852	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	■
760L080R040Z4.0A-MEGA-64	02623438	3	D	■	8,0	8,0	28,0	65,0	0,4	–	4	■
760L100R040Z4.0A-MEGA-64	02623461	3	D	■	10,0	10,0	36,0	75,0	0,4	–	4	■
760L100R100Z4.0A-MEGA-64	02623464	3	D	■	10,0	10,0	36,0	75,0	1,0	–	4	■
760L100R150Z4.0A-MEGA-64	02623467	3	D	■	10,0	10,0	36,0	75,0	1,5	–	4	■
760L100R200Z4.0A-MEGA-64	02623472	3	D	■	10,0	10,0	36,0	75,0	2,0	–	4	■
760L100R310Z4.0A-MEGA-64	02623807	3	D	■	10,0	10,0	36,0	75,0	3,1	–	4	■
760L120R040Z4.0A-MEGA-64	02623821	3	D	■	12,0	12,0	42,0	90,0	0,4	–	4	■
760L120R100Z4.0A-MEGA-64	02623826	3	D	■	12,0	12,0	42,0	90,0	1,0	–	4	■
760L120R150Z4.0A-MEGA-64	02623829	3	D	■	12,0	12,0	42,0	90,0	1,5	–	4	■
760L120R400Z4.0A-MEGA-64	02623838	3	D	■	12,0	12,0	42,0	90,0	4,0	–	4	■
760L160R040Z4.0A-MEGA-64	02623840	3	D	■	16,0	16,0	50,0	100,0	0,4	–	4	■
760L160R100Z4.0A-MEGA-64	02623842	3	D	■	16,0	16,0	50,0	100,0	1,0	–	4	■
760L160R150Z4.0A-MEGA-64	02623844	3	D	■	16,0	16,0	50,0	100,0	1,5	–	4	■

■ Stocked standard.
ICC = Internal Coolant Channel

JHP760

High performance – ISO-M – Square – 2-4 Flutes – Weldon – Corner radius – ICC





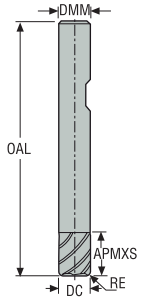
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Weldon
					mm	mm	mm	mm	mm			
760040R020Z2.0A-MEGA-64W	02734065	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0 °	2	□
760040R040Z2.0A-MEGA-64W	02669339	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0 °	2	□
760050R020Z2.0A-MEGA-64W	02734068	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0 °	2	□
760050R040Z2.0A-MEGA-64W	02669340	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0 °	2	□
760060R020Z4.0A-MEGA-64W	02734069	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	□
760060R040Z4.0A-MEGA-64W	02669341	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	□
760080R040Z4.0A-MEGA-64W	02669343	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	□
760080R100Z4.0A-MEGA-64W	02669344	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	□
760100R040Z4A-MEGA-64	02623442	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	■
760100R100Z4A-MEGA-64	02623462	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	■
760100R150Z4A-MEGA-64	02623465	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	■
760120R040Z4A-MEGA-64	02623817	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	■
760120R100Z4A-MEGA-64	02623824	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	■
760120R150Z4A-MEGA-64	02623827	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	■
760120R400Z4A-MEGA-64	02623835	2	D	■	12,0	12,0	24,0	75,0	4,0	–	4	■
760160R040Z4A-MEGA-64	02623839	2	D	■	16,0	16,0	40,0	90,0	0,4	–	4	■
760160R100Z4A-MEGA-64	02623841	2	D	■	16,0	16,0	40,0	90,0	1,0	–	4	■
760160R150Z4A-MEGA-64	02623843	2	D	■	16,0	16,0	40,0	90,0	1,5	–	4	■
760160R200Z4A-MEGA-64	02623845	2	D	■	16,0	16,0	40,0	90,0	2,0	–	4	■
760200R040Z4A-MEGA-64	02734054	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	■
760200R080Z4A-MEGA-64	02623851	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.
ICC = Internal Coolant Channel

JHP760

High performance – ISO-M – Square – 2-4 Flutes – Weldon – Corner radius – ICC



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
760L080R040Z4.0A-MEGA-64W	02720459	3	D	■	8,0	8,0	28,0	65,0	0,4	4	□
760L100R040Z4.0A-MEGA-64W	02669345	3	D	■	10,0	10,0	36,0	75,0	0,4	4	□
760L100R100Z4.0A-MEGA-64W	02669346	3	D	■	10,0	10,0	36,0	75,0	1,0	4	□
760L100R150Z4.0A-MEGA-64W	02669347	3	D	■	10,0	10,0	36,0	75,0	1,5	4	□
760L100R200Z4.0A-MEGA-64W	02669348	3	D	■	10,0	10,0	36,0	75,0	2,0	4	□
760L120R040Z4.0A-MEGA-64W	02669350	3	D	■	12,0	12,0	42,0	90,0	0,4	4	□
760L120R100Z4.0A-MEGA-64W	02669351	3	D	■	12,0	12,0	42,0	90,0	1,0	4	□
760L120R150Z4.0A-MEGA-64W	02669352	3	D	■	12,0	12,0	42,0	90,0	1,5	4	□
760L160R040Z4.0A-MEGA-64W	02669356	3	D	■	16,0	16,0	50,0	100,0	0,4	4	□
760L160R100Z4.0A-MEGA-64W	02669357	3	D	■	16,0	16,0	50,0	100,0	1,0	4	□
760L160R150Z4.0A-MEGA-64W	02669358	3	D	■	16,0	16,0	50,0	100,0	1,5	4	□

□ Weldon available. Delivery time is 3 days.
ICC = Internal Coolant Channel

Cutting data – JHP760 Side milling

SMG		a_e/DC	a_p/DC	f_z									v_c
				4	5	6	8	10	12	16	20	25	
M1	E	0.300 *0,300*	1.5 *1,5*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (97 — 130) *395 (320 — 420)*
M2	E	0.300 *0,300*	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	100 (81 — 110) *330 (270 — 360)*
M3	E	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (58 — 91) *245 (200 — 290)*
M4	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	60 (45 — 70) *195 (150 — 220)*
M5	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	48 (37 — 59) *155 (130 — 190)*

Cutting data – JHP760 Slot milling

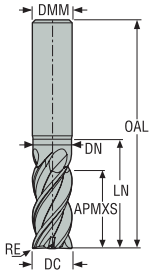
SMG		a_p/DC	f_z									v_c
			4	5	6	8	10	12	16	20	25	
M1	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	110 (92 — 130) *360 (310 — 420)*
M2	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	90 (74 — 100) *295 (250 — 320)*
M3	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	70 (54 — 85) *230 (180 — 270)*
M4	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	50 (40 — 63) *165 (140 — 200)*
M5	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	43 (34 — 53) *140 (120 — 170)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

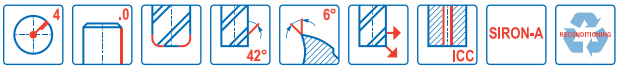
JHP770

High performance – Titanium – Square – 4-5 Flutes – Cylindrical – Corner radius – ICC



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

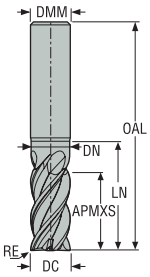


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.0Z4A-SIRA	02760645	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP770080E2R040.0Z4A-SIRA	02760653	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP770080E2R050.0Z4A-SIRA	02823416	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	■
JHP770100E2R040.0Z4A-SIRA	02760654	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP770100E2R050.0Z4A-SIRA	02823417	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	■
JHP770120E2R040.0Z4A-SIRA	02760656	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP770120E2R050.0Z4A-SIRA	02823419	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	■
JHP770120E2R100.0Z4A-SIRA	02823420	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	■
JHP770120E2R250.0Z4A-SIRA	02760659	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP770140E2R050.0Z4A-SIRA	02823421	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	■
JHP770160E2R040.0Z4A-SIRA	02760661	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP770160E2R050.0Z4A-SIRA	02823422	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	■
JHP770160E2R080.0Z4A-SIRA	02760662	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP770160E2R100.0Z4A-SIRA	02823423	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	■
JHP770160E2R250.0Z4A-SIRA	02760663	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	■
JHP770160E2R310.0Z4A-SIRA	02760664	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	■
JHP770160E2R400.0Z4A-SIRA	02760665	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP770200E2R050.0Z4A-SIRA	02823424	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	■
JHP770200E2R100.0Z4A-SIRA	02823425	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	■
JHP770200E2R250.0Z4A-SIRA	02760668	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	■
JHP770200E2R310.0Z4A-SIRA	02760669	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP770200E2R400.0Z4A-SIRA	02760670	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■

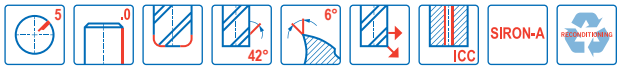
■ Stocked standard.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%
ICC = Internal Coolant Channel

JHP770

High performance – Titanium – Square –4-5 Flutes – Cylindrical – Corner radius – ICC



E



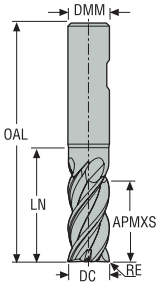
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.0Z5A-SIRA	02810129	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	■
JHP770160E2R100.0Z5A-SIRA	02810130	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	■
JHP770160E2R250.0Z5A-SIRA	02810131	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	■
JHP770160E2R310.0Z5A-SIRA	02810132	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	■
JHP770160E2R400.0Z5A-SIRA	02810133	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	■
JHP770200E2R050.0Z5A-SIRA	02810134	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	■
JHP770200E2R100.0Z5A-SIRA	02810135	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	■
JHP770200E2R250.0Z5A-SIRA	02810136	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	■
JHP770200E2R310.0Z5A-SIRA	02810137	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	■
JHP770200E2R400.0Z5A-SIRA	02810138	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	■
JHP770250E2R050.0Z5A-SIRA	02810139	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	■

■ Stocked standard.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%
ICC = Internal Coolant Channel

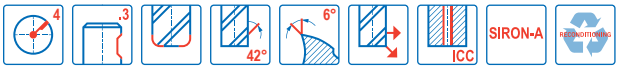
JHP770

High performance – Titanium – Square – 4-5 Flutes – Weldon – Corner radius – ICC



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

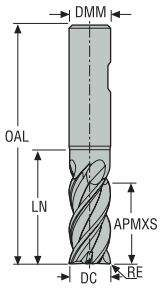


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.3Z4A-SIRA	02760796	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP770080E2R040.3Z4A-SIRA	02760799	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	□
JHP770080E2R050.3Z4A-SIRA	02823428	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	■
JHP770100E2R040.3Z4A-SIRA	02760801	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	□
JHP770100E2R050.3Z4A-SIRA	02823429	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	■
JHP770120E2R040.3Z4A-SIRA	02760803	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	□
JHP770120E2R050.3Z4A-SIRA	02823431	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	■
JHP770120E2R100.3Z4A-SIRA	02823432	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	■
JHP770120E2R250.3Z4A-SIRA	02760805	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	□
JHP770140E2R050.3Z4A-SIRA	02823433	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	■
JHP770160E2R040.3Z4A-SIRA	02760807	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	□
JHP770160E2R050.3Z4A-SIRA	02823434	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	■
JHP770160E2R080.3Z4A-SIRA	02760809	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	□
JHP770160E2R100.3Z4A-SIRA	02823435	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	■
JHP770160E2R250.3Z4A-SIRA	02760810	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	■
JHP770160E2R310.3Z4A-SIRA	02760811	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	□
JHP770160E2R400.3Z4A-SIRA	02760817	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	□
JHP770200E2R050.3Z4A-SIRA	02823436	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	■
JHP770200E2R100.3Z4A-SIRA	02823437	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	■
JHP770200E2R250.3Z4A-SIRA	02760823	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	□
JHP770200E2R310.3Z4A-SIRA	02760824	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	□
JHP770200E2R400.3Z4A-SIRA	02760825	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	□

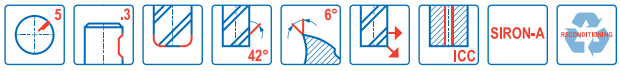
■ Stocked standard. □ Weldon available. Delivery time is 3 days.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%

JHP770

High performance – Titanium – Square – 4-5 Flutes – Weldon – Corner radius – ICC



E



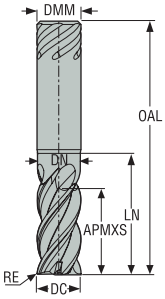
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.3Z5A-SIRA	02810143	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	■
JHP770160E2R100.3Z5A-SIRA	02810144	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	■
JHP770160E2R250.3Z5A-SIRA	02810145	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	□
JHP770160E2R310.3Z5A-SIRA	02810146	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	■
JHP770160E2R400.3Z5A-SIRA	02810147	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	□
JHP770200E2R050.3Z5A-SIRA	02810148	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	■
JHP770200E2R100.3Z5A-SIRA	02810149	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	■
JHP770200E2R250.3Z5A-SIRA	02810150	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	□
JHP770200E2R310.3Z5A-SIRA	02810151	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	■
JHP770200E2R400.3Z5A-SIRA	02810152	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	■
JHP770250E2R050.3Z5A-SIRA	02810153	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	■
JHP770250E2R100.3Z5A-SIRA	02810154	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	1,0	5	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%

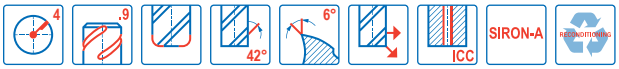
JHP770

High performance – Titanium – Square – 4-5 Flutes – Safelock – Corner radius – ICC



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

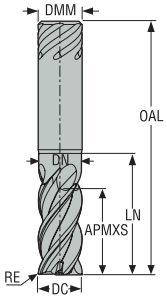


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.9Z4A-SIRA	02927936	2	E	■	6,0	6,0	12,0	60,0	18,0	6,0	0,3	4	□
JHP770080E2R040.9Z4A-SIRA	02927937	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,4	4	□
JHP770080E2R050.9Z4A-SIRA	02927938	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,5	4	□
JHP770100E2R040.9Z4A-SIRA	02927939	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,4	4	□
JHP770100E2R050.9Z4A-SIRA	02927940	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,5	4	□
JHP770120E2R040.9Z4A-SIRA	02927943	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,4	4	□
JHP770120E2R050.9Z4A-SIRA	02927944	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,5	4	□
JHP770120E2R100.9Z4A-SIRA	02927946	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	1,0	4	□
JHP770120E2R250.9Z4A-SIRA	02927947	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	2,5	4	□
JHP770140E2R050.9Z4A-SIRA	02927950	2	E	■	14,0	14,0	28,0	95,0	42,0	13,0	0,5	4	□
JHP770160E2R040.9Z4A-SIRA	02927948	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,4	4	□
JHP770160E2R050.9Z4A-SIRA	02927978	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	4	□
JHP770160E2R080.9Z4A-SIRA	02927951	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,8	4	□
JHP770160E2R100.9Z4A-SIRA	02927952	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	4	□
JHP770160E2R250.9Z4A-SIRA	02927954	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	4	□
JHP770160E2R310.9Z4A-SIRA	02927956	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	4	□
JHP770160E2R400.9Z4A-SIRA	02927958	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	4	□
JHP770200E2R050.9Z4A-SIRA	02927960	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	4	□
JHP770200E2R100.9Z4A-SIRA	02927962	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	4	□
JHP770200E2R250.9Z4A-SIRA	02927964	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	4	□
JHP770200E2R310.9Z4A-SIRA	02927966	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	4	□
JHP770200E2R400.9Z4A-SIRA	02927968	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	4	□

□ Safelock available. Delivery time is 6 days.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%

JHP770

High performance – Titanium – Square – 4-5 Flutes – Safelock – Corner radius – ICC



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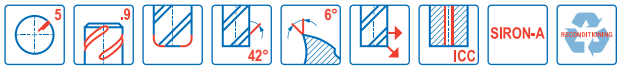


- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.9Z5A-SIRA	02927949	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	5	☐
JHP770160E2R100.9Z5A-SIRA	02927953	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	5	☐
JHP770160E2R250.9Z5A-SIRA	02927955	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	5	☐
JHP770160E2R310.9Z5A-SIRA	02927957	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	5	☐
JHP770160E2R400.9Z5A-SIRA	02927959	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	5	☐
JHP770200E2R050.9Z5A-SIRA	02927961	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	5	☐
JHP770200E2R100.9Z5A-SIRA	02927963	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	5	☐
JHP770200E2R250.9Z5A-SIRA	02927965	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	5	☐
JHP770200E2R310.9Z5A-SIRA	02927967	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	5	☐
JHP770200E2R400.9Z5A-SIRA	02927969	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	5	☐
JHP770250E2R050.9Z5A-SIRA	02927971	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	0,5	5	☐

☐ Safelock available. Delivery time is 6 days.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%

Cutting data – JHP770 Side milling

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S11	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	120 (110 — 130) *395 (370 — 420)*
S12	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	90 (80 — 100) *295 (270 — 320)*
S13	E	0.400 *0,400*	1.8 *1,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (64 — 81) *245 (210 — 260)*

Cutting data – JHP770 Slot milling

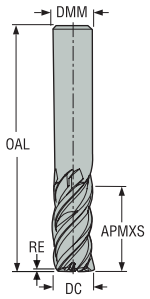
SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S11	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	105 (94 — 120) *345 (310 — 390)*
S12	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	80 (72 — 92) *260 (240 — 300)*
S13	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	65 (56 — 71) *215 (190 — 230)*

For cutting data recalculations, see pages 573 - 580

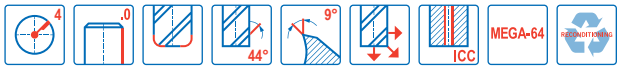
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHP780

High performance – Superalloy – Square – 4-Flutes – Cylindrical – Corner radius – ICC



D



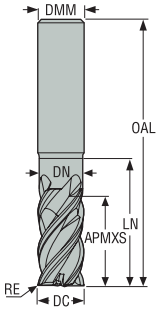
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JHP780060D1R030.0Z4A-M64	03134984	1	D	■	6,0	6,0	7,5	47,0	0,3	4	■
JHP780060D1R080.0Z4A-M64	03134985	1	D	■	6,0	6,0	7,5	47,0	0,8	4	■
JHP780080D1R040.0Z4A-M64	03134986	1	D	■	8,0	8,0	10,0	50,0	0,4	4	■
JHP780080D1R080.0Z4A-M64	03134987	1	D	■	8,0	8,0	10,0	50,0	0,8	4	■
JHP780100D1R040.0Z4A-M64	03134988	1	D	■	10,0	10,0	12,5	57,0	0,4	4	■
JHP780100D1R080.0Z4A-M64	03134989	1	D	■	10,0	10,0	12,5	57,0	0,8	4	■

■ Stocked standard.

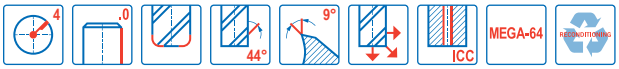
JHP780

High performance – Superalloy – Square – 4-Flutes – Cylindrical – Corner radius – ICC



E

- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible

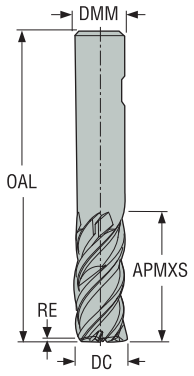


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JHP780060E2R030.0Z4A-M64	03134992	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780060E2R030.0Z4-M64	02760834	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780080E2R040.0Z4A-M64	03134993	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780080E2R040.0Z4-M64	02760842	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780100E2R040.0Z4A-M64	03134994	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R040.0Z4-M64	02760846	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R080.0Z4A-M64	03134995	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780100E2R080.0Z4-M64	02760847	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780120E2R040.0Z4A-M64	03134996	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R040.0Z4-M64	02760848	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R080.0Z4A-M64	03134997	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R080.0Z4-M64	02760849	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R150.0Z4-M64	02760850	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	■
JHP780120E2R250.0Z4-M64	02760851	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP780140E2R040.0Z4-M64	02760852	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	■
JHP780160E2R040.0Z4A-M64	03135000	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R040.0Z4-M64	02760853	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R080.0Z4A-M64	03135001	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R080.0Z4-M64	02760861	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R310.0Z4-M64	02760862	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	■
JHP780160E2R400.0Z4-M64	02760863	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP780200E2R040.0Z4-M64	02760865	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	■
JHP780200E2R080.0Z4-M64	02760866	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	■
JHP780200E2R310.0Z4-M64	02760867	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP780200E2R400.0Z4-M64	02760868	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■
JHP780250E2R080.0Z4-M64	02760870	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	■

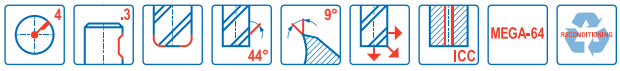
■ Stocked standard.

JHP780

High performance – Superalloy – Square – 4-Flutes – Weldon – Corner radius – ICC



D



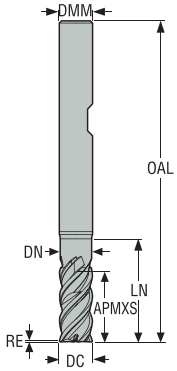
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JHP780060D1R030.3Z4A-M64	03135445	1	D	■	6,0	6,0	7,5	47,0	0,3	4	■
JHP780060D1R080.3Z4A-M64	03135446	1	D	■	6,0	6,0	7,5	47,0	0,8	4	■
JHP780080D1R040.3Z4A-M64	03135447	1	D	■	8,0	8,0	10,0	50,0	0,4	4	■
JHP780080D1R080.3Z4A-M64	03135449	1	D	■	8,0	8,0	10,0	50,0	0,8	4	■
JHP780100D1R040.3Z4A-M64	03135450	1	D	■	10,0	10,0	12,5	57,0	0,4	4	■
JHP780100D1R080.3Z4A-M64	03135451	1	D	■	10,0	10,0	12,5	57,0	0,8	4	■

■ Stocked standard.

JHP780

High performance – Superalloy – Square – 4-Flutes – Weldon – Corner radius – ICC



E

- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP780060E2R030.3Z4-M64	02760878	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780060E2R030.3Z4A-M64	03135454	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780080E2R040.3Z4-M64	02760879	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780080E2R040.3Z4A-M64	03135455	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780100E2R040.3Z4-M64	02760880	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R040.3Z4A-M64	03135456	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R080.3Z4-M64	02760881	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780100E2R080.3Z4A-M64	03135457	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780120E2R040.3Z4-M64	02760883	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R040.3Z4A-M64	03134998	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R080.3Z4-M64	02760885	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R080.3Z4A-M64	03134999	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R150.3Z4-M64	02760887	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	■
JHP780120E2R250.3Z4-M64	02766989	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP780140E2R040.3Z4-M64	02760888	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	■
JHP780160E2R040.3Z4-M64	02760889	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R040.3Z4A-M64	03135002	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R080.3Z4-M64	02760890	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R080.3Z4A-M64	03135003	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R400.3Z4-M64	02760893	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP780200E2R040.3Z4-M64	02760894	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	■
JHP780200E2R080.3Z4-M64	02760896	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	■
JHP780200E2R310.3Z4-M64	02760897	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP780200E2R400.3Z4-M64	02760898	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■
JHP780250E2R080.3Z4-M64	02760901	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	■

■ Stocked standard.

Cutting data – JHP780 Side milling

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S1	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	50 (45 — 59) *165 (150 — 190)*
S2	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	42 (36 — 47) *140 (120 — 150)*
S3	E	0.300 *0,300*	0.80 *0,80*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	28 (23 — 33) *90 (76 — 100)*

Cutting data – JHP780 Slot milling

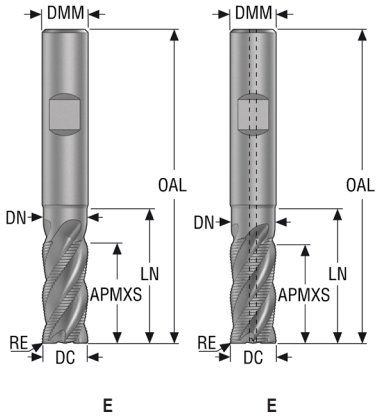
SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S1	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	43 (38 — 49) *140 (130 — 160)*
S2	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	35 (30 — 40) *115 (99 — 130)*
S3	E	0.60 *0,60*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	26 (21 — 30) *85 (69 — 98)*

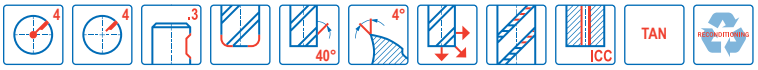
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHP794

High performance – ISO-M – Square – 4 Flutes – Weldon – Corner radius





- Tolerances:
- DMM= h6
- DC= h12
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø8

Designation	Grade	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
						mm	mm	mm	mm	mm	mm	mm		
JHP794060E2R020.3Z4	TAN	10072338	2	E	–	6,0	6,0	13,0	57,0	18,5	2,0	0,2	4	■
JHP794060E2R020.3Z4A	TAN	10072339	2	E	■	6,0	6,0	13,0	57,0	18,5	5,5	0,2	4	■
JHP794080E2R020.3Z4	TAN	10072340	2	E	–	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	■
JHP794080E2R020.3Z4A	TAN	10072341	2	E	■	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	■
JHP794100E2R035.3Z4	TAN	10072342	2	E	–	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	■
JHP794100E2R035.3Z4A	TAN	10072343	2	E	■	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	■
JHP794120E2R035.3Z4	TAN	10072344	2	E	–	12,0	12,0	26,0	83,0	35,5	11,4	0,35	4	■
JHP794120E2R035.3Z4A	TAN	10072345	2	E	■	12,0	12,0	26,0	92,0	35,5	11,4	0,35	4	■
JHP794160E2R040.3Z4	TAN	10072346	2	E	–	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	■
JHP794160E2R040.3Z4A	TAN	10072347	2	E	■	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	■
JHP794200E2R040.3Z4	TAN	10072348	2	E	–	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	■
JHP794200E2R040.3Z4A	TAN	10072349	2	E	■	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	■
JHP794250E2R040.3Z4	TAN	10072350	2	E	–	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	■
JHP794250E2R040.3Z4A	TAN	10072351	2	E	■	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	■

■ Stocked standard.

Cutting data – JHP794 Side milling

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.3 *1,3*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	90 (61 — 120) *295 (210 — 390)*
M2	E	1.3 *1,3*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M3	E	1.3 *1,3*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	60 (40 — 78) *195 (140 — 250)*
M4	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	45 (31 — 60) *150 (110 — 190)*
M5	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	38 (26 — 50) *125 (86 — 160)*

Cutting data – JHP794 Slot milling

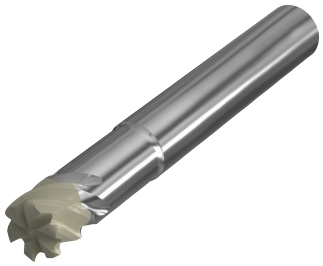
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M2	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	60 (40 — 79) *195 (140 — 250)*
M3	E	0.60 *0,60*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	47 (32 — 62) *155 (110 — 200)*
M4	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	36 (24 — 47) *120 (79 — 150)*
M5	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	30 (20 — 39) *100 (66 — 120)*

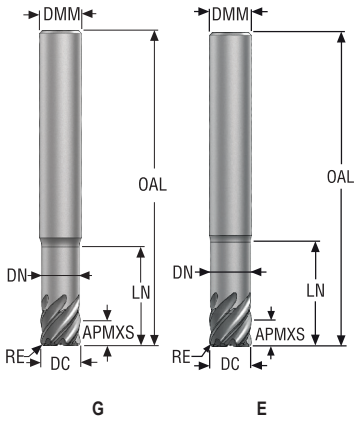
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

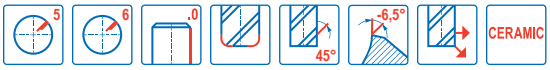
JCG790

High performance – Square – Superalloy – 5-6 Flutes – Cylindrical – Corner radius





- Tolerances:
- DMM= h5
- DC= -0,02/-0,1 mm
- RE= ±0,05 mm



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	DN	LN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JCG790060E2R050.0Z5	10010512	2	E	6,0	6,0	6,0	59,0	5,7	15,0	0,5	5	■
JCG790080E2R050.0Z5	10010513	2	E	8,0	8,0	6,0	67,0	7,6	20,0	0,5	5	■
JCG790094G2R100.0Z6	10010514	2	G	9,4	10,0	6,0	75,0	9,0	23,5	1,0	6	■
JCG790100E2R100.0Z6	10010515	2	E	10,0	10,0	6,0	75,0	9,5	25,0	1,0	6	■
JCG790114G2R150.0Z6	10010516	2	G	11,4	12,0	6,0	82,0	10,9	28,5	1,5	6	■
JCG790120E2R150.0Z6	10010517	2	E	12,0	12,0	6,0	82,0	11,4	30,0	1,5	6	■
JCG790160E2R200.0Z6	10010518	2	E	16,0	16,0	8,0	93,0	15,2	40,0	2,0	6	■
JCG790200E2R300.0Z6	10010519	2	E	20,0	20,0	8,0	103,0	19,0	50,0	3,0	6	■
JCG790250E2R400.0Z6	10010520	2	E	25,0	25,0	8,0	108,0	23,8	50,0	4,0	6	■

■ Stocked standard.

Cutting data – JCG790 Side milling roughing

SMG		a_e/DC	APMXS	f_z							v_c
				6	8	10	12	16	20	25	
S1	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340 — 1100) *2200 (1200 — 3600)*
S3	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

Cutting data – JCG790 Slot milling

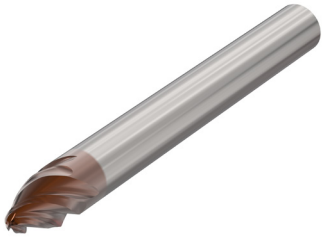
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
S1	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340 — 1100) *2200 (1200 — 3600)*
S3	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

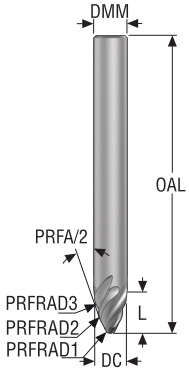
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

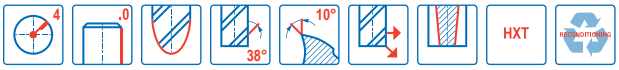
JH724

High speed – ISO– M and ISO– S - Taper Shape – 4 Flutes – Cylindrical





- Tolerances:
- DMM=h5
- PRFRAD1= ±0.03 mm
- Form tolerance PRFRAD2= 0.02 mm
- Regrind possible if PRFRAD is ≥1,5



Designation	Grade	Item number	Length index	Tool shape	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm			
JH724100T2R2R030.0Z4	HXT	10106106	2	T	10,0	10,0	12,3	89,0	2,0	30,0	5,0	20,0	4	■
JH724100T2R2R050.0Z4	HXT	10106107	2	T	10,0	10,0	12,5	89,0	2,0	50,0	5,0	20,0	4	■
JH724100T2R3R100.0Z4	HXT	10106108	2	T	10,0	10,0	10,7	89,0	3,0	100,0	5,0	20,0	4	■
JH724100T2R3R250.0Z4	HXT	10106109	2	T	10,0	10,0	10,8	89,0	3,0	250,0	5,0	20,0	4	■

■ Stocked standard.

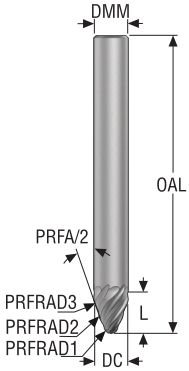
Cutting data – JH724 Copy milling finishing

SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	65 (55 - 75) *215 (180 - 245)*
S11	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310 - 475)*
S12	E	0.010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
S13	E	0.010 *0.010*	0,05 *0.0022*	95 (80 - 100) *310 (260 - 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

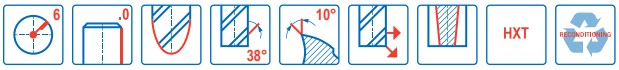
JH726

High speed – ISO– M and ISO– S - Taper Shape – 6 Flutes – Cylindrical



T

- Tolerances:
- DMM=h5
- PRFRAD1= ±0.03 mm
- Form tolerance PRFRAD2= 0.02 mm
- Regrind possible if PRFRAD is ≥1,5



Designation	Grade	Item number	Length index	Tool shape	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm			
JH726100T2R2R030.0Z6	HXT	10106110	2	T	10,0	10,0	10,8	89,0	2,0	30,0	5,0	20,0	6	■
JH726100T2R2R050.0Z6	HXT	10106111	2	T	10,0	10,0	10,7	89,0	2,0	50,0	5,0	20,0	6	■
JH726100T2R3R100.0Z6	HXT	10106112	2	T	10,0	10,0	12,3	89,0	3,0	100,0	5,0	20,0	6	■
JH726100T2R3R250.0Z6	HXT	10106113	2	T	10,0	10,0	12,5	89,0	3,0	250,0	5,0	20,0	6	■

■ Stocked standard.

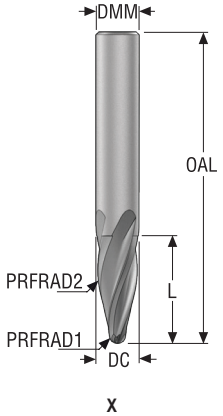
Cutting data – JH726 Copy milling finishing

SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	65 (55 - 75) *215 (180 - 245)*
S11	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310 - 475)*
S12	E	0.010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
S13	E	0.010 *0.010*	0,05 *0.0022*	95 (80 - 100) *310 (260 - 320)*

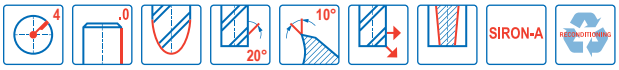
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH734

High speed – ISO– M and ISO– S - Drop Shape – 4 Flutes – Cylindrical



- Tolerances:
- DMM= h5
- PRFRAD1= ±0.03mm
- Form tolerance PRFRAD2= 0.02mm
- Regrind possible if PRFRAD is ≥1,5



Designation	Grade	Item number	Length index	Tool shape	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm		
JH734060X2R1R95.0Z4	SIRA	10044783	2	X	6,0	6,0	20,8	62,0	1,0	95,0	4	■
JH734080X2R1R90.0Z4	SIRA	10044784	2	X	8,0	8,0	24,5	68,0	1,0	90,0	4	■
JH734100X2R2R85.0Z4	SIRA	10044785	2	X	10,0	10,0	24,7	72,0	2,0	85,0	4	■
JH734120X2R2R80.0Z4	SIRA	10044786	2	X	12,0	12,0	27,3	83,0	2,0	80,0	4	■
JH734160X2R3R75.0Z4	SIRA	10044787	2	X	16,0	16,0	30,1	92,0	3,0	75,0	4	■

■ Stocked standard.

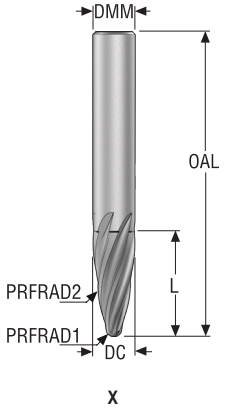
Cutting data – JH734 Copy milling finishing

SMG		a_e/DC	f_z					v_c
			6	8	10	12	16	
P8	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

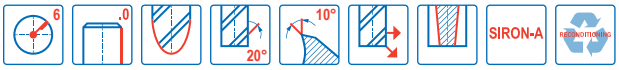
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH736

High speed – ISO– M and ISO– S - Drop Shape – 6 Flutes – Cylindrical



- Tolerances:
- DMM= h5
- PRFRAD1= ±0.03mm
- Form tolerance PRFRAD2= 0.02mm
- Regrind possible



Designation	Grade	Item number	Length index	Tool shape	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm		
JH736100X2R2R85.0Z6	SIRA	10044834	2	X	10,0	10,0	24,7	72,0	2,0	85,0	6	■
JH736120X2R2R80.0Z6	SIRA	10044835	2	X	12,0	12,0	27,3	83,0	2,0	80,0	6	■
JH736160X2R3R75.0Z6	SIRA	10044836	2	X	16,0	16,0	30,1	92,0	3,0	75,0	6	■

■ Stocked standard.

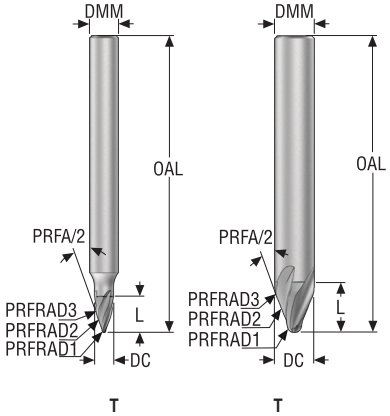
Cutting data – JH736 Copy milling finishing

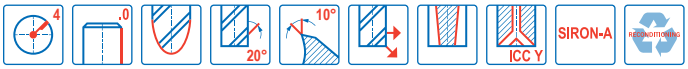
SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH744

High speed – ISO– M and ISO– S - Taper Shape – 4 Flutes – Cylindrical





- Tolerances:
- DMM= h5
- PRFRAD1= ±0.03mm
- Form tolerance PRFRAD2= 0.02mm
- Regrind possible if PRFRAD1 is ≥1,5

Designation	Grade	Item number	Length index	Tool shape	ICC	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Cylindrical
						mm	mm	mm	mm	mm	mm	mm			
JH744100T1R1.5R250.0Z4	SIRA	10044920	1	T	–	10,0	10,0	5,4	72,0	1,5	250,0	2,0	65,0	4	■
JH744120T1R3R250.0Z4	SIRA	10044921	1	T	–	12,0	12,0	10,5	89,0	3,0	250,0	6,0	32,5	4	■
JH744160T1R4R500.0Z4	SIRA	10044922	1	T	–	16,0	16,0	14,6	108,0	4,0	500,0	8,0	27,5	4	■
JH744040T2R0.5R250.0Z4	SIRA	10044923	2	T	–	4,0	6,0	7,6	62,0	0,5	250,0	3,0	17,5	4	■
JH744060T2R1R250.0Z4	SIRA	10044924	2	T	–	6,0	6,0	9,6	62,0	1,0	250,0	3,0	17,5	4	■
JH744080T2R1.5R250.0Z4	SIRA	10044925	2	T	–	8,0	8,0	10,7	68,0	1,5	250,0	4,0	20,0	4	■
JH744100T2R2R250.0Z4	SIRA	10044926	2	T	–	10,0	10,0	12,7	75,0	2,0	250,0	5,0	20,0	4	■
JH744120T2R3R250.0Z4	SIRA	10044927	2	T	–	12,0	12,0	13,7	89,0	3,0	250,0	6,0	20,0	4	■
JH744160T2R4R500.0Z4	SIRA	10044928	2	T	–	16,0	16,0	17,6	108,0	4,0	500,0	8,0	20,0	4	■
JH744160T2R2R1000.0Z4	SIRA	10044929	2	T	–	16,0	16,0	31,3	108,0	2,0	1000,0	5,0	12,5	4	■
JH744160T2R4R1000.0Z4	SIRA	10044930	2	T	–	16,0	16,0	24,1	108,0	4,0	1000,0	5,0	12,5	4	■
JH744160T4R4R1000.0Z4A	SIRA	10044931	4	T	■	16,0	16,0	24,1	150,0	4,0	1000,0	5,0	12,5	4	■

■ Stocked standard.

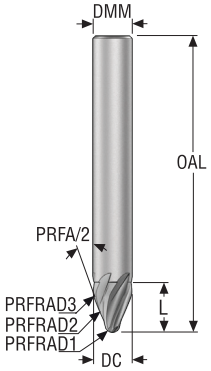
Cutting data – JH744 Copy milling finishing

SMG		a_e/DC	f_z						v_c
			4	6	8	10	12	16	
P8	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

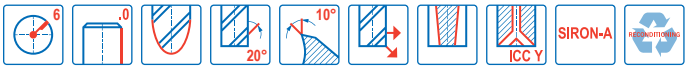
JH746

High speed – ISO– M and ISO– S - Taper Shape – 6 Flutes – Cylindrical



T

- Tolerances:
- DMM= h5
- PRFRAD1= ±0.03mm
- Form tolerance PRFRAD2= 0.02mm
- Regrind possible



Designation	Grade	Item number	Length index	Tool shape	ICC	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Cylindrical
						mm	mm	mm	mm	mm	mm	mm			
JH746100T2R2R250.0Z6	SIRA	10044958	2	T	–	10,0	10,0	12,7	75,0	2,0	250,0	5,0	20,0	6	■
JH746120T2R3R250.0Z6	SIRA	10044959	2	T	–	12,0	12,0	13,7	89,0	3,0	250,0	6,0	20,0	6	■
JH746160T2R4R500.0Z6	SIRA	10044960	2	T	–	16,0	16,0	17,6	108,0	4,0	500,0	8,0	20,0	6	■
JH746160T4R4R500.0Z6A	SIRA	10044961	4	T	■	16,0	16,0	17,6	150,0	4,0	500,0	8,0	20,0	6	■

■ Stocked standard.

Cutting data – JH746 Copy milling finishing

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

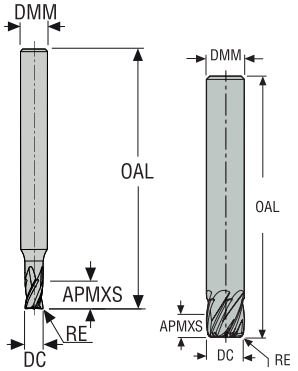
Cutting data – JH746 Copy milling roughing

SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	95 (80 - 100) *310 (270 - 320)*

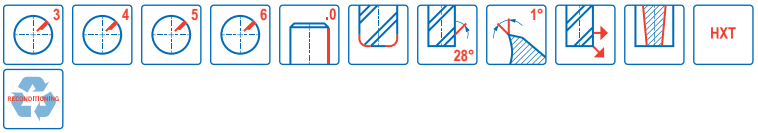
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH770

High speed – CoCr/Titanium – Square – 3-4-5-6 Flutes – Cylindrical – Corner radius



- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JH770030F2R020.0Z3-HXT	03320783	2	F	3,0	6,0	5,0	58,0	0,2	3	■
JH770040F2R020.0Z4-HXT	03320784	2	F	4,0	6,0	6,0	58,0	0,2	4	■
JH770050F2R020.0Z4-HXT	10000170	2	F	5,0	6,0	7,0	58,0	0,2	4	■
JH770060D2R050.0Z4-HXT	03127351	2	D	6,0	6,0	8,0	50,0	0,5	4	■
JH770080D2R050.0Z4-HXT	03127352	2	D	8,0	8,0	10,0	58,0	0,5	4	■
JH770080D2R050.0Z5-HXT	03127354	2	D	8,0	8,0	10,0	58,0	0,5	5	■
JH770080D2R100.0Z4-HXT	03127353	2	D	8,0	8,0	10,0	58,0	1,0	4	■
JH770080D2R100.0Z5-HXT	03127355	2	D	8,0	8,0	10,0	58,0	1,0	5	■
JH770080D2R100.0Z6-HXT	03127356	2	D	8,0	8,0	10,0	58,0	1,0	6	■
JH770100D2R100.0Z5-HXT	03127357	2	D	10,0	10,0	12,0	66,0	1,0	5	■
JH770100D2R100.0Z6-HXT	03127358	2	D	10,0	10,0	12,0	66,0	1,0	6	■

■ Stocked standard.

Cutting data – JH770 Side milling roughing PCEDC 3 and 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				3	4	6	8	
S2	E	0.750 *0,750*	0.12 *0,12*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	50 (42 — 62) *165 (140 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	65 (53 — 91) *215 (180 — 290)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	50 (41 — 70) *165 (140 — 220)*

Cutting data – JH770 Side milling roughing PCEDC 6

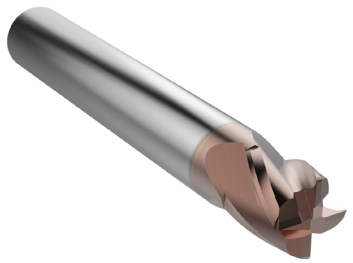
SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.750 *0,750*	0.12 *0,12*	0.050 *0,0020*	0.060 *0,0024*	55 (43 — 64) *180 (150 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	65 (54 — 93) *215 (180 — 300)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	50 (42 — 71) *165 (140 — 230)*

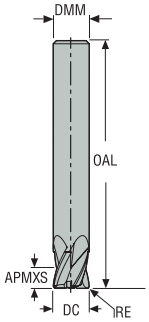
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH740

High speed – CoCr/Titanium – Bottom finisher – 4-5 Flutes – Cylindrical – Corner radius





D

- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JH740060D2R025.0Z4-HXT	03127359	2	D	6,0	6,0	6,0	50,0	0,25	4	■
JH740060D2R050.0Z4-HXT	03127360	2	D	6,0	6,0	6,0	50,0	0,5	4	■
JH740080D2R025.0Z4-HXT	03127361	2	D	8,0	8,0	8,0	58,0	0,25	4	■
JH740080D2R050.0Z4-HXT	03127362	2	D	8,0	8,0	8,0	58,0	0,5	4	■
JH740100D2R025.0Z5-HXT	03127363	2	D	10,0	10,0	10,0	66,0	0,25	5	■
JH740100D2R050.0Z5-HXT	03127364	2	D	10,0	10,0	10,0	66,0	0,5	5	■

■ Stocked standard.

Cutting data – JH740 Face finishing PCEDC 4

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140 — 190)*
S11	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	65 (52 — 77) *215 (180 — 250)*
S12	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140 — 190)*

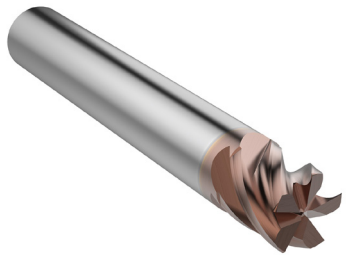
Cutting data – JH740 Face finishing PCEDC 5

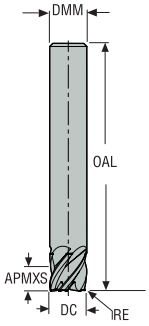
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*
S11	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	65 (51 — 75) *215 (170 — 240)*
S12	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH710

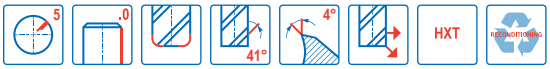
High speed – CoCr/Titanium – Square – 5 Flutes – Cylindrical – Corner radius





D

- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JH710060D2R025.0Z5-HXT	03127365	2	D	6,0	6,0	6,0	57,0	0,25	5	■
JH710060D2R050.0Z5-HXT	03127366	2	D	6,0	6,0	6,0	57,0	0,5	5	■
JH710080D2R025.0Z5-HXT	03127367	2	D	8,0	8,0	8,0	63,0	0,25	5	■
JH710080D2R050.0Z5-HXT	03127368	2	D	8,0	8,0	8,0	63,0	0,5	5	■
JH710080D2R100.0Z5-HXT	03127369	2	D	8,0	8,0	8,0	63,0	1,0	5	■

■ Stocked standard.

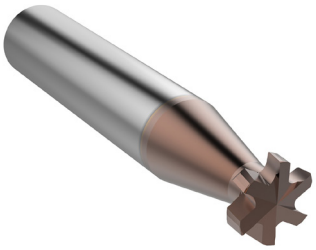
Cutting data – JH710 Side milling finishing

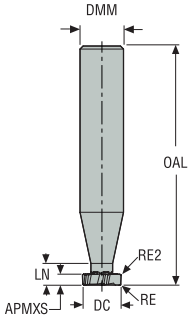
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S1	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S2	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S3	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S11	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	180 (160 — 200) *590 (530 — 650)*
S12	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	135 (120 — 150) *445 (400 — 490)*
S13	E	0.00800 *0,00800*	0.65 *0,65*	0.032 *0,0013*	0.040 *0,0016*	105 (92 — 120) *345 (310 — 390)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH790

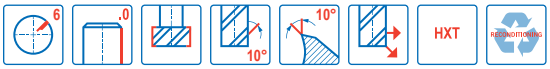
High speed – CoCr/Titanium – T Cutter – 6 Flutes – Cylindrical





G

- Tolerances:
- DMM=h5
- DC= ±0,02 mm
- RE= ±0,02 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	RE	RE2	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JH790095G2R025.0Z6-HXT	03127370	2	G	9,5	10,0	2,0	66,0	5,0	0,25	0,25	6	■
JH790095G2R050.0Z6-HXT	03127371	2	G	9,5	10,0	2,0	66,0	5,0	0,5	0,5	6	■
JH790095G3R025.0Z6-HXT	03127372	3	G	9,5	10,0	2,54	66,0	5,0	0,25	0,25	6	■
JH790095G3R050.0Z6-HXT	03127373	3	G	9,5	10,0	2,54	66,0	5,0	0,5	0,5	6	■

■ Stocked standard.

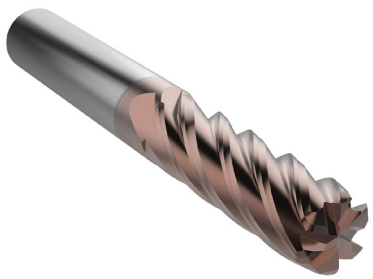
Cutting data – JH790 (T) Side milling roughing

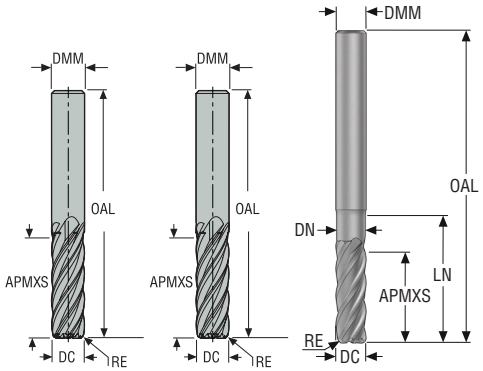
SMG		a_e/DC	a_p/DC	f_z	v_c
				9.5	
S2	E	0.189 *0,189*	0.19 *0,19*	0.030 *0,0012*	39 (31 — 50) *130 (110 — 160)*
S11	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	85 (66 — 100) *280 (220 — 320)*
S12	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	65 (51 — 80) *215 (170 — 260)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH730

High speed – CoCr/Titanium – Square – 5-6-7 Flutes – Cylindrical – Corner radius





- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	DN	LN	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JH730060E2R050.0Z5-HXT	10217826	2	E	6,0	6,0	19,0	5,7	25,0	65,0	0,5	5	■
JH730060E2R100.0Z5-HXT	10217827	2	E	6,0	6,0	19,0	5,7	25,0	65,0	1,0	5	■
JH730060E2R150.0Z5-HXT	10217828	2	E	6,0	6,0	19,0	5,7	25,0	65,0	1,5	5	■
JH730075F2R050.0Z6-HXT	10217829	2	F	7,5	8,0	24,0	–	–	63,0	0,5	6	■
JH730075F2R100.0Z6-HXT	10217830	2	F	7,5	8,0	24,0	–	–	63,0	1,0	6	■
JH730075F2R150.0Z6-HXT	10217831	2	F	7,5	8,0	24,0	–	–	63,0	1,5	6	■
JH730080D2R050.0Z6-HXT	03127375	2	D	8,0	8,0	25,0	–	–	63,0	0,5	6	■
JH730080D2R100.0Z6-HXT	03127377	2	D	8,0	8,0	25,0	–	–	63,0	1,0	6	■
JH730080D2R150.0Z6-HXT	03127378	2	D	8,0	8,0	25,0	–	–	63,0	1,5	6	■
JH730080D2R200.0Z6-HXT	03127379	2	D	8,0	8,0	25,0	–	–	63,0	2,0	6	■
JH730100D2R100.0Z7-HXT	03127380	2	D	10,0	10,0	31,0	–	–	72,0	1,0	7	■
JH730100D2R250.0Z7-HXT	03127381	2	D	10,0	10,0	31,0	–	–	72,0	2,5	7	■

■ Stocked standard.

Cutting data – JH730 Side milling finishing

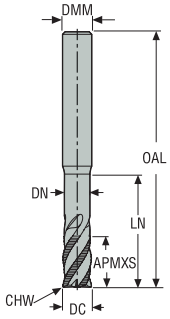
SMG		a_e/DC	a_p/DC	f_z				v_c
				6	7.5	8	10	
S2	E	0,065 *0.065*	1,3 *1.3*	0,015 *0.00060*	0,019 *0.00075*	0,020 *0.00080*	0,025 *0.0010*	80 (63 — 94) *260 (210 — 300)*
S11	E	0,065 *0.065*	1,3 *1.3*	0,012 *0.00048*	0,015 *0.00060*	0,017 *0.00065*	0,020 *0.00080*	135 (110 — 160) *445 (370 — 520)*
S12	E	0,065 *0.065*	1,3 *1.3*	0,012 *0.00048*	0,015 *0.00060*	0,017 *0.00065*	0,020 *0.00080*	105 (84 — 120) *345 (280 — 390)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHP994

High performance – CoCr/Titanium – Square – 4 Flutes – Cylindrical – Chamfer



E

- Tolerances:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW=0/-0,1 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JHP994060E3C.0Z4-HXT	03127382	3	E	6,0	6,0	14,0	63,0	24,0	5,6	0,2	4	■
JHP994080E3C.0Z4-HXT	03127383	3	E	8,0	8,0	18,0	69,0	32,0	7,4	0,2	4	■
JHP994100E3C.0Z4-HXT	03127384	3	E	10,0	10,0	22,0	88,0	40,0	9,4	0,2	4	■

■ Stocked standard.

Cutting data – JHP994 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z			v_c
				6	8	10	
S2	E	0.0480 *0,0480*	2.0 *2,0*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	55 (40 — 69) *180 (140 — 220)*
S11	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (39 — 77) *165 (130 — 250)*
S12	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	40 (30 — 59) *130 (99 — 190)*

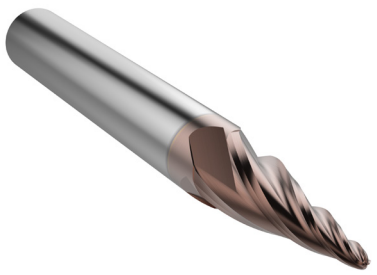
Cutting data – JHP994 Slot milling

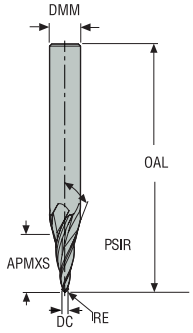
SMG		a_p/DC	f_z			v_c
			6	8	10	
S2	E	2.0 *2,0*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	33 (24 — 41) *110 (79 — 130)*
S11	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	42 (32 — 63) *140 (110 — 200)*
S12	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	33 (25 — 48) *110 (83 — 150)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH780

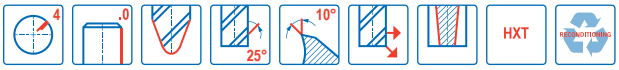
High speed – CoCr/Titanium – Tapered ball nose – 4 Flutes – Cylindrical





N

- Tolerances:
- DMM=h5
- DC= ±0,04 mm
- RE= ±0,01 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PSIR	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
JH780018N2R100.0Z4-HXT	03127386	2	N	1,827	8,0	23,5	63,0	1,0	5,1838	4	■
JH780028N2R150.0Z4-HXT	03127387	2	N	2,803	8,0	23,5	63,0	1,5	3,8915	4	■
JH780038N2R200.0Z4-HXT	03127388	2	N	3,823	8,0	23,5	63,0	2,0	2,5972	4	■
JH780049N2R250.0Z4-HXT	03127389	2	N	4,888	8,0	23,5	63,0	2,5	1,3003	4	■

■ Stocked standard.

Cutting data – JH780 Copy milling roughing

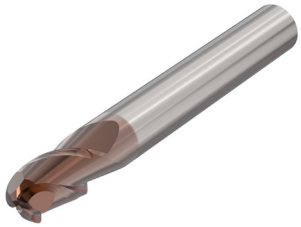
SMG		a_e/DC	a_p/DC	f_z				v_c
				1.8	2.8	3.8	4.9	
S2	E	0.0510 *0,0510*	4.2 *4,2*	0.0080 *0,00032*	0.012 *0,00048*	0.017 *0,00065*	0.022 *0,00085*	70 (54 — 86) *230 (180 — 280)*
S12	E	0.0510 *0,0510*	4.2 *4,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.013 *0,00050*	0.016 *0,00065*	95 (76 — 110) *310 (250 — 360)*

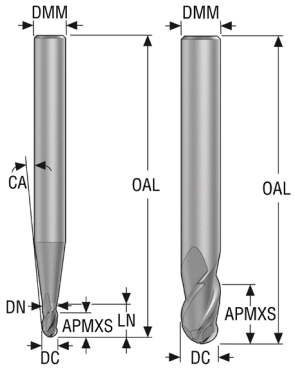
For cutting data recalculations, see pages 573 - 580

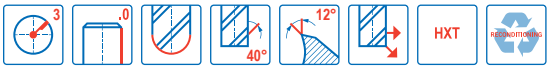
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHB720

High speed – Titanium – Ball nose – 3 Flutes – Cylindrical







- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm			
JHB720020G2B.0Z3	HXT	10072323	2	G	2,0	6,0	3,0	60,0	6,0	1,9	7,0	3	■
JHB720030G2B.0Z3	HXT	10072324	2	G	3,0	6,0	4,5	60,0	6,5	2,8	5,0	3	■
JHB720035G2B.0Z3	HXT	10072325	2	G	3,5	6,0	5,0	65,0	7,0	3,2	3,5	3	■
JHB720040G2B.0Z3	HXT	10072326	2	G	4,0	6,0	6,0	65,0	8,0	3,7	3,0	3	■
JHB720060D2B.0Z3	HXT	10072327	2	D	6,0	6,0	9,0	75,0	–	–	–	3	■
JHB720080D2B.0Z3	HXT	10072328	2	D	8,0	8,0	12,0	75,0	–	–	–	3	■
JHB720100D2B.0Z3	HXT	10072329	2	D	10,0	10,0	15,0	80,0	–	–	–	3	■
JHB720120D2B.0Z3	HXT	10072330	2	D	12,0	12,0	18,0	90,0	–	–	–	3	■
JHB720160D2B.0Z3	HXT	10072331	2	D	16,0	16,0	24,0	100,0	–	–	–	3	■

■ Stocked standard.

Cutting data – JHB720 Side milling

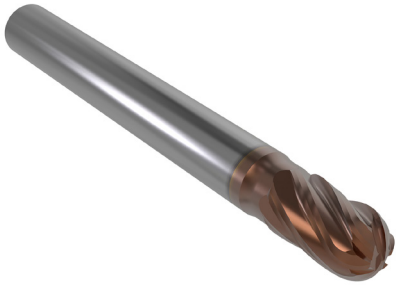
SMG		a_e/DC	a_p/DC	f_z									v_c
				2	3	3.5	4	6	8	10	12	16	
M1	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	85 (62 — 110) *280 (210 — 360)*
M2	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	70 (51 — 90) *230 (170 — 290)*
M3	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	65 (46 — 84) *215 (160 — 270)*
M4	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	50 (35 — 65) *165 (120 — 210)*
M5	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	42 (29 — 54) *140 (96 — 170)*
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	500 (400 — 600) *1650 (1400 — 1900)*
N3	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	335 (270 — 400) *1100 (890 — 1300)*
N11	E/M/A	0.300 *0,300*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	43 (29 — 57) *140 (96 — 180)*
S2	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	35 (24 — 46) *115 (79 — 150)*
S3	E	0.100 *0,100*	1.2 *1,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	30 (21 — 39) *100 (69 — 120)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.0085 *0,00034*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400 — 1900)*
TP1	M	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400 — 1900)*

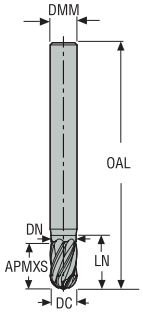
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH721

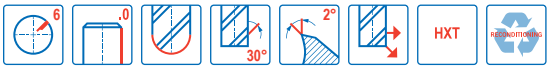
High speed – CoCr/Titanium – Ball nose – 6 Flutes – Cylindrical





E

- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
JH721060E2B.0Z6-HXT	03127390	2	E	6,0	6,0	10,0	57,0	12,0	5,6	6	■
JH721080E2B.0Z6-HXT	03127391	2	E	8,0	8,0	13,0	58,0	16,0	7,4	6	■

■ Stocked standard.

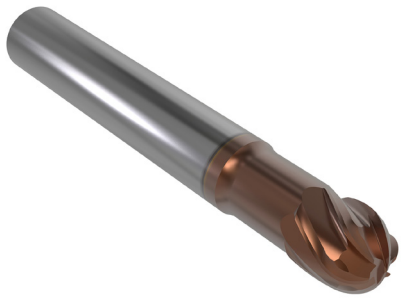
Cutting data – JH721 Copy milling finishing

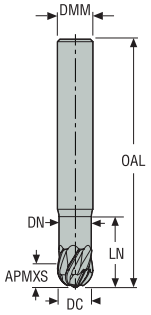
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	120 (110 — 140) *395 (370 — 450)*
S11	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	210 (140 — 230) *690 (460 — 750)*
S12	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	160 (110 — 180) *520 (370 — 590)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH722

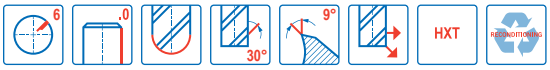
High speed – CoCr/Titanium – Ball nose – 6 Flutes – Cylindrical





E

- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,01 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
JH722100E2B.0Z6-HXT	03127392	2	E	10,0	10,0	10,0	72,0	20,0	9,4	6	■

■ Stocked standard.

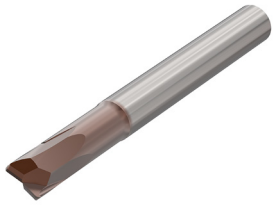
Cutting data – JH722 Copy milling finishing

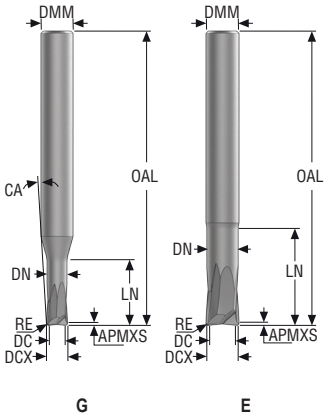
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.0500 *0,0500*	0.15 *0,15*	0.065 *0,0026*	125 (110 — 150) *410 (370 — 490)*
S11	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	210 (190 — 230) *690 (630 — 750)*
S12	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	160 (150 — 180) *520 (500 — 590)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

SHF712

High feed – ISO– S – 2 Flutes – Cylindrical – Corner radius





- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC G- Shape = 0/-0,01 mm
- DC E- Shape = 0,005/-0,015 mm
- RE = ±0,005 mm

Designation	Grade	Item number	Length index	Tool shape	DC	DCX	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm	mm			
SHF712040G2R050.0Z2	HXT	10106493	2	G	3,0	4,0	6,0	0,5	55,0	12,0	3,8	0,5	3,9 °	2	■
SHF712060E2R050.0Z2	HXT	10106494	2	E	5,0	6,0	6,0	0,5	55,0	18,0	5,7	0,5	0,0 °	2	■
SHF712030G3R050.0Z2	HXT	10106495	3	G	2,0	3,0	6,0	0,5	55,0	12,0	2,85	0,5	5,65 °	2	■
SHF712040G3R050.0Z2	HXT	10106496	3	G	3,0	4,0	6,0	0,5	55,0	16,0	3,8	0,5	3,07 °	2	■
SHF712060E3R050.0Z2	HXT	10106497	3	E	5,0	6,0	6,0	0,5	55,0	25,0	5,7	0,5	0,0 °	2	■
SHF712030G4R050.0Z2	HXT	10106498	4	G	2,0	3,0	6,0	0,5	55,0	16,0	2,85	0,5	4,47 °	2	■

■ Stocked standard.

Cutting data – SFH712 Side milling

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3	4	6	
S2	E	0,30 *0.30*	0,050 *0.050*	0,055 *0.0022*	0,075 *0.0030*	0,11 *0.0044*	65 (51 — 76) *215 (170 — 240)*
S12	E	0,30 *0.30*	0,050 *0.050*	0,085 *0.0034*	0,12 *0.0048*	0,17 *0.0065*	170 (150 — 190) *560 (500 — 620)*

Cutting data – SFH712 Slot milling

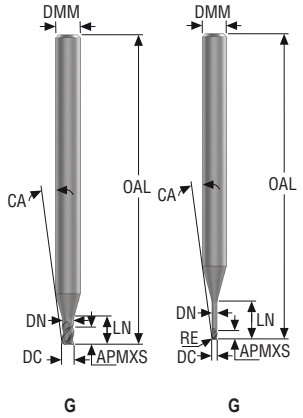
SMG		a_p/DCX	f_z			v_c
			3	4	6	
S2	E	0,050 *0.050*	0,046 *0.0018*	0,060 *0.0024*	0,090 *0.0036*	50 (41 — 60) *165 (140 — 190)*
S12	E	0,050 *0.050*	0,046 *0.0018*	0,060 *0.0024*	0,090 *0.0036*	145 (130 — 160) *475 (430 — 520)*

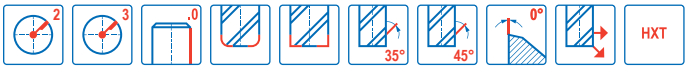
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

SME714/716

Miniature – ISO– S - Square – 2-3 Flutes – Cylindrical – Sharp or corner radius





- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC = 0/-0,01 mm
- RE = ±0,005 mm

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	DN	LN	RE	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm			
SME714020G1S.0Z3	HXT	10107349	1	G	2,0	4	2,0	50	1,9	4,0	–	6,86 °	3	■
SME716020G1S.0Z3	HXT	10107360	1	G	2,0	6	2,0	50	1,9	4,0	–	9,42 °	3	■
SME714020G3R010.0Z3	HXT	10107350	3	G	2,0	4	2,5	50	1,9	8,0	0,1	4,68 °	3	■
SME716020G3R010.0Z3	HXT	10107361	3	G	2,0	6	2,5	50	1,9	8,0	0,1	7,14 °	3	■
SME716010G4R010.0Z3	HXT	10107362	4	G	1,0	6	1,2	50	0,95	6,0	0,1	9,03 °	3	■
SME716015G4R010.0Z3	HXT	10107363	4	G	1,5	6	1,8	50	1,4	10,0	0,1	6,79 °	3	■
SME714010G4R010.0Z3	HXT	10107351	4	G	2,0	4	1,2	50	0,95	6,0	0,1	7,13 °	3	■
SME714015G4R010.0Z3	HXT	10107352	4	G	2,0	4	1,8	50	1,4	10,0	0,1	4,72 °	3	■
SME714020G4R010.0Z3	HXT	10107353	4	G	2,0	4	2,5	50	1,9	12,0	0,1	3,53 °	3	■
SME716020G4R010.0Z3	HXT	10107364	4	G	2,0	6	2,5	50	1,9	12,0	0,1	5,72 °	3	■
SME714015G5R010.0Z3	HXT	10107354	5	G	1,5	4	1,8	50	1,4	12,0	0,1	3,38 °	3	■
SME716015G5R010.0Z3	HXT	10107365	5	G	1,5	6	1,8	50	1,4	12,0	0,1	6,15 °	3	■
SME714020G5R010.0Z3	HXT	10107355	5	G	2,0	4	2,5	50	1,9	16,0	0,1	2,83 °	3	■
SME716020G5R010.0Z3	HXT	10107366	5	G	2,0	6	2,5	50	1,9	16,0	0,1	4,77 °	3	■
SME714005G6R005.0Z2	HXT	10107356	6	G	0,5	4	0,6	50	0,45	5,0	0,05	8,31 °	2	■
SME716005G6R005.0Z2	HXT	10107367	6	G	0,5	6	0,6	50	0,45	5,0	0,05	9,93 °	2	■
SME714010G6R010.0Z3	HXT	10107357	6	G	1,0	4	1,2	50	0,95	12,0	0,1	4,77 °	3	■
SME716010G6R010.0Z3	HXT	10107368	6	G	1,0	6	1,6	50	0,95	12,0	0,1	6,56 °	3	■
SME714015G6R010.0Z3	HXT	10107358	6	G	1,5	4	1,8	50	1,4	16,0	0,1	3,38 °	3	■
SME716015G6R010.0Z3	HXT	10107369	6	G	1,5	6	1,8	50	1,4	16,0	0,1	5,16 °	3	■
SME714010G7R010.0Z3	HXT	10107359	7	G	1,0	4	1,2	50	0,95	16,0	0,1	3,9 °	3	■
SME716010G7R010.0Z3	HXT	10107370	7	G	1,0	6	1,2	50	0,95	16,0	0,1	5,55 °	3	■

■ Stocked standard.

Cutting data – SME714 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.5	1	1.5	2	
S2	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	60 (31 — 120) *195 (110 — 390)*
S12	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	65 (33 — 130) *215 (110 — 420)*

Cutting data – SME714 Slot milling

SMG		a_p/DC	f_z				v_c
			0.5	1	1.5	2	
S2	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	41 (21 — 82) *135 (69 — 260)*
S12	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	45 (23 — 89) *150 (76 — 290)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – SME716 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.5	1	1.5	2	
S2	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	60 (31 — 120) *195 (110 — 390)*
S12	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	65 (33 — 130) *215 (110 — 420)*

Cutting data – SME716 Slot milling

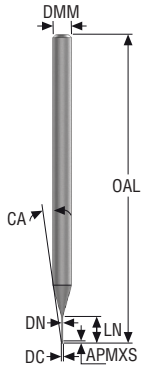
SMG		a_p/DC	f_z				v_c
			0.5	1	1.5	2	
S2	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	41 (21 — 82) *135 (69 — 260)*
S12	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	45 (23 — 89) *150 (76 — 290)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

SMB713/714/716

Miniature – ISO– S – Ball nose – 2 Flutes – Cylindrical



G

- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC = 0/-0,01 mm
- RE = ±0,005 mm

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	DN	LN	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm			
SMB714020G2B.0Z2	HXT	10109582	2	G	2,0	4	2,0	50	1,9	6,0	6,13 °	2	■
SMB716020G2B.0Z2	HXT	10109596	2	G	2,0	6	2,0	50	1,9	6,0	8,72 °	2	■
SMB714030G2B.0Z2	HXT	10109583	2	G	3,0	4	3,0	50	2,85	9,0	2,85 °	2	■
SMB716030G2B.0Z2	HXT	10109597	2	G	3,0	6	3,0	50	2,85	9,0	6,22 °	2	■
SMB714030G3B.0Z2	HXT	10109584	3	G	3,0	4	3,0	50	2,85	12,0	2,2 °	2	■
SMB716030G3B.0Z2	HXT	10109598	3	G	3,0	6	3,0	50	2,85	12,0	5,11 °	2	■
SMB714015G4B.0Z2	HXT	10109585	4	G	1,5	4	1,5	50	1,4	9,0	5,29 °	2	■
SMB716015G4B.0Z2	HXT	10109599	4	G	1,5	6	1,5	50	1,4	9,0	7,44 °	2	■
SMB714020G4B.0Z2	HXT	10109586	4	G	2,0	4	2,0	50	1,9	10,0	4,3 °	2	■
SMB716020G4B.0Z2	HXT	10109600	4	G	2,0	6	2,0	50	1,9	10,0	6,69 °	2	■
SMB714005G5B.0Z2	HXT	10109587	5	G	0,5	4	0,5	50	0,45	4,0	9,23 °	2	■
SMB716005G5B.0Z2	HXT	10109601	5	G	0,5	6	0,5	50	0,45	4,0	10,73 °	2	■
SMB714010G5B.0Z2	HXT	10109588	5	G	1,0	4	1,0	50	0,95	10,0	5,5 °	2	■
SMB716010G5B.0Z2	HXT	10109602	5	G	1,0	6	1,0	50	0,95	10,0	7,37 °	2	■
SMB714015G5B.0Z2	HXT	10109589	5	G	1,5	4	1,5	50	1,4	12,0	4,41 °	2	■
SMB716015G5B.0Z2	HXT	10109603	5	G	1,5	6	1,5	50	1,4	12,0	6,35 °	2	■
SMB714020G5B.0Z2	HXT	10109590	5	G	2,0	4	2,0	50	1,9	16,0	2,96 °	2	■
SMB716020G5B.0Z2	HXT	10109604	5	G	2,0	6	2,0	50	1,9	16,0	4,96 °	2	■
SMB713003G6B.0Z2	HXT	10109581	6	G	0,3	3	0,3	50	0,28	4,0	8,24 °	2	■
SMB714005G6B.0Z2	HXT	10109591	6	G	0,5	4	0,5	50	0,45	6,0	7,8 °	2	■
SMB716005G6B.0Z2	HXT	10109605	6	G	0,5	6	0,5	50	0,45	6,0	9,46 °	2	■
SMB714010G6B.0Z2	HXT	10109592	6	G	1,0	4	1,0	50	0,95	12,0	4,97 °	2	■
SMB716010G6B.0Z2	HXT	10109606	6	G	1,0	6	1,0	50	0,95	12,0	6,69 °	2	■
SMB714015G6B.0Z2	HXT	10109593	6	G	1,5	4	1,5	50	1,4	16,0	3,49 °	2	■
SMB716015G6B.0Z2	HXT	10109607	6	G	1,5	6	1,5	55	1,4	16,0	5,31 °	2	■
SMB714005G7B.0Z2	HXT	10109594	7	G	0,5	4	0,5	50	0,45	9,0	6,33 °	2	■
SMB716005G7B.0Z2	HXT	10109608	7	G	0,5	6	0,5	50	0,45	9,0	8,03 °	2	■
SMB714010G7B.0Z2	HXT	10109595	7	G	1,0	4	1,0	50	0,95	16,0	3,98 °	2	■
SMB716010G7B.0Z2	HXT	10109609	7	G	1,0	6	1,0	55	0,95	16,0	5,64 °	2	■

■ Stocked standard.

Cutting data – SMB713 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z	v_c
				0.3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0020 *0.000080*	47 (26 — 64) *155 (86 — 200)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0020 *0.000080*	47 (26 — 64) *155 (86 — 200)*

Cutting data – SMB714 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	1	1.5	2	3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*

Cutting data – SMB716 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	1	1.5	2	3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

NON FERROUS

Seco offers a complete range of high performance solid carbide square shoulder end mills, ballnose cutters and finish end mills for high productivity for non ferrous materials.

- JS412 and JS413 for sharp corner type.
- JS452, JS453, JHP490, JH40, JH421, JM403, JM404, JM406, JH410 and JH440 for radius type.
- JH450, JH460, SMB413, SMB414, SMB416, JM413 and JM416 for ball-nose type.

Tool selection Non ferrous

Name		JS412	JS413	JS452	JS453	JHP490
Page(s)		338	341	344	349	354
Family name		SOLID²	SOLID²	SOLID²	SOLID²	HPM
Type of mill		90°	90°	45° r	45° r	r
Shank	Cylindrical	■	■	■	■	■
	Weldon	■	■	□	□	■
	Safelock					□
Number of Flutes		2	3	2	3	2-3
ICC						■
Diameter range	Metric	2-20	2-20	2-20	2-20	10-25
	Inch					
Length availability		2	2,3	2,3	2,3	2,3,4
Operation						
SMG						
N1		●	●	●	●	●
N2		●	●	●	●	●
N3			●	●	●	●
N11						
TS1		●	●	●	●	
TP1		●	●	●	●	

■ Stock standard □ Weldon available, delivery time is 3 days. □ Safe-Lock available, delivery time is 6 days
● Preferred choice ○ Alternative choice

Tool selection Non ferrous

Name		JH40	JH421	JH410	JH440
Page(s)		358	361	365	367
Family name		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Type of mill		r	r	r	r
Shank	Cylindrical	■	■	■	■
	Weldon				
	Safelock				
Number of Flutes		2	2-3	1	2
ICC			■		
Diameter range	Metric	2-20	2-25	2-17	6-8
	Inch				
Length availability		1,2	2,3	2,3	2
Operation					
SMG					
N1		●	●	●	●
N2					●
N3					●
N11		●	●	●	●
TS1		●	●	●	●
TP1			●		●

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

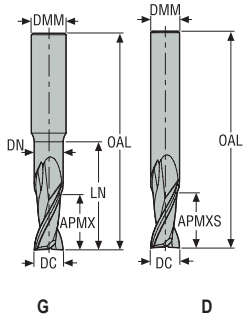
Tool selection Non ferrous

Name		JH450	JH460	SMB413/414/416	JM403/404/406	JM413/416
Page(s)		369	371	377	375	377
Family name		HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Type of mill						
Shank	Cylindrical	■	■	■	■	■
	Weldon					
	Safelock					
Number of Flutes		2	2	2	1	2
ICC						
Diameter range	Metric	2-20	3-12	1-3	0,5-2	0,5-2
	Inch					
Length availability		2,3	2	2,3,5	1,2,5	2,3,5
Operation						
SMG						
N1		●	●	●	●	●
N2		●		●	●	●
N3		●		●	●	●
N11		●	●			●
TS1		●	●	●		●
TP1		●	●	●		●

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

JS412

General purpose – Aluminium – Square – 2 Flutes – Cylindrical – Sharp



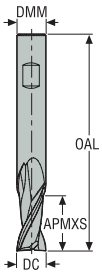
- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	DN	LN	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
JS412020G2SZ2.0	02881760	2	G	2,0	6,0	4,0	57,0	1,9	7,0	2	■
JS412030G2SZ2.0	02881761	2	G	3,0	6,0	6,0	57,0	2,8	10,0	2	■
JS412040G2SZ2.0	02881762	2	G	4,0	6,0	8,0	57,0	3,8	14,0	2	■
JS412050G2SZ2.0	02881763	2	G	5,0	6,0	10,0	57,0	4,7	17,0	2	■
JS412060D2SZ2.0	02881764	2	D	6,0	6,0	12,0	57,0	–	–	2	■
JS412080D2SZ2.0	02881765	2	D	8,0	8,0	16,0	63,0	–	–	2	■
JS412100D2SZ2.0	02881766	2	D	10,0	10,0	20,0	75,0	–	–	2	■
JS412120D2SZ2.0	02881767	2	D	12,0	12,0	24,0	88,0	–	–	2	■
JS412160D2SZ2.0	02881769	2	D	16,0	16,0	32,0	100,0	–	–	2	■
JS412200D2SZ2.0	02881770	2	D	20,0	20,0	40,0	124,0	–	–	2	■

■ Stocked standard.

JS412

General purpose – Aluminium – Square – 2 Flutes – Weldon – Sharp



D

- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS412060D2SZ2.3	02881771	2	D	6,0	6,0	12,0	57,0	2	■
JS412080D2SZ2.3	02881772	2	D	8,0	8,0	16,0	63,0	2	■
JS412100D2SZ2.3	02881773	2	D	10,0	10,0	20,0	75,0	2	■
JS412120D2SZ2.3	02881774	2	D	12,0	12,0	24,0	88,0	2	■
JS412160D2SZ2.3	02881776	2	D	16,0	16,0	32,0	100,0	2	■
JS412200D2SZ2.3	02881777	2	D	20,0	20,0	40,0	124,0	2	■

■ Stocked standard.

Cutting data – JS412 Side milling

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (470 — 700) *1925 (1600 — 2200)*
N2	E/M/A	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	475 (360 — 590) *1550 (1200 — 1900)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480 — 710) *1975 (1600 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	500 (380 — 630) *1650 (1300 — 2000)*

Cutting data – JS412 Slot milling

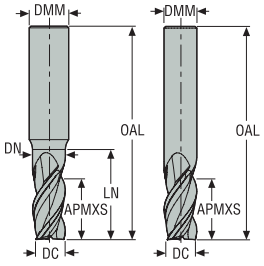
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
TS1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
TP1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	420 (320 — 520) *1375 (1100 — 1700)*

For cutting data recalculations, see pages 573 - 580

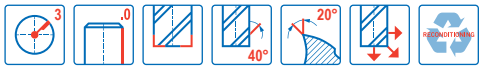
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS413

General purpose – Aluminium – Square – 3 Flutes – Cylindrical – Sharp



G D



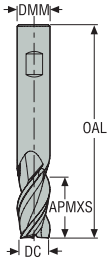
- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	DN	LN	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
JS413020G2SZ3.0	02881797	2	G	2,0	6,0	4,0	57,0	1,9	7,0	3	■
JS413030G2SZ3.0	02881798	2	G	3,0	6,0	6,0	57,0	2,8	10,0	3	■
JS413040G2SZ3.0	02881799	2	G	4,0	6,0	8,0	57,0	3,8	14,0	3	■
JS413050G2SZ3.0	02881800	2	G	5,0	6,0	10,0	57,0	4,7	17,0	3	■
JS413060D2SZ3.0	02881801	2	D	6,0	6,0	12,0	57,0	–	–	3	■
JS413080D2SZ3.0	02881802	2	D	8,0	8,0	16,0	63,0	–	–	3	■
JS413100D2SZ3.0	02881803	2	D	10,0	10,0	20,0	72,0	–	–	3	■
JS413120D2SZ3.0	02881804	2	D	12,0	12,0	24,0	88,0	–	–	3	■
JS413160D2SZ3.0	02881806	2	D	16,0	16,0	32,0	100,0	–	–	3	■
JS413200D2SZ3.0	02881807	2	D	20,0	20,0	40,0	124,0	–	–	3	■
JS413060D3SZ3.0	02881815	3	D	6,0	6,0	24,0	70,0	–	–	3	■
JS413080D3SZ3.0	02881816	3	D	8,0	8,0	32,0	85,0	–	–	3	■
JS413100D3SZ3.0	02881817	3	D	10,0	10,0	40,0	100,0	–	–	3	■
JS413120D3SZ3.0	02881818	3	D	12,0	12,0	50,0	115,0	–	–	3	■
JS413160D3SZ3.0	02881820	3	D	16,0	16,0	55,0	125,0	–	–	3	■
JS413200D3SZ3.0	02881821	3	D	20,0	20,0	75,0	150,0	–	–	3	■

■ Stocked standard.

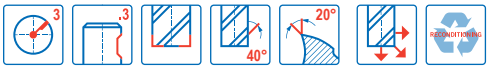
JS413

General purpose – Aluminium – Square – 3 Flutes – Weldon – Sharp



D

- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS413060D2SZ3.3	02881808	2	D	6,0	6,0	12,0	57,0	3	■
JS413080D2SZ3.3	02881809	2	D	8,0	8,0	16,0	63,0	3	■
JS413100D2SZ3.3	02881810	2	D	10,0	10,0	20,0	72,0	3	■
JS413120D2SZ3.3	02881811	2	D	12,0	12,0	24,0	88,0	3	■
JS413160D2SZ3.3	02881813	2	D	16,0	16,0	32,0	100,0	3	■
JS413200D2SZ3.3	02881814	2	D	20,0	20,0	40,0	124,0	3	■
JS413060D3SZ3.3	02881955	3	D	6,0	6,0	24,0	70,0	3	□
JS413080D3SZ3.3	02881956	3	D	8,0	8,0	32,0	85,0	3	□
JS413100D3SZ3.3	02881957	3	D	10,0	10,0	40,0	100,0	3	□
JS413120D3SZ3.3	02881958	3	D	12,0	12,0	50,0	115,0	3	□
JS413160D3SZ3.3	02881960	3	D	16,0	16,0	55,0	125,0	3	□
JS413200D3SZ3.3	02881961	3	D	20,0	20,0	75,0	150,0	3	□

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

Cutting data – JS413 Side milling

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480 — 710) *1975 (1600 — 2300)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	470 (360 — 580) *1550 (1200 — 1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	315 (240 — 390) *1025 (790 — 1200)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	610 (500 — 730) *2000 (1700 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	330 (250 — 410) *1075 (830 — 1300)*

Cutting data – JS413 Slot milling

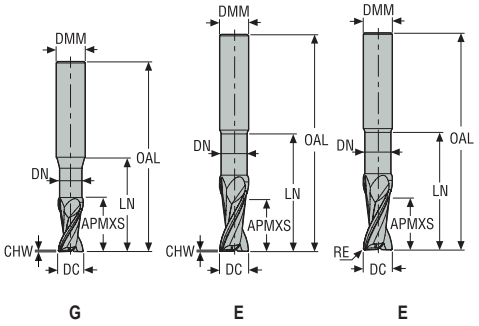
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (400 — 600) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	400 (300 — 490) *1300 (990 — 1600)*
N3	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	265 (200 — 330) *870 (660 — 1000)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	500 (400 — 600) *1650 (1400 — 1900)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	270 (210 — 330) *890 (690 — 1000)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS452

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius or chamfer



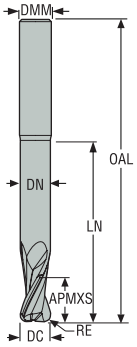
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm		
JS452020G2CZ2.0-HEMI	02881848	2	G	2,0	6,0	4,0	57,0	8,0	1,9	0,1	–	2	■
JS452030G2CZ2.0-HEMI	02881849	2	G	3,0	6,0	6,0	57,0	10,0	2,8	0,1	–	2	■
JS452040G2CZ2.0-HEMI	02881850	2	G	4,0	6,0	8,0	57,0	14,0	3,8	0,1	–	2	■
JS452050G2CZ2.0-HEMI	02881851	2	G	5,0	6,0	8,0	57,0	17,0	4,7	0,1	–	2	■
JS452060E2CZ2.0-HEMI	02881852	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	–	2	■
JS452060E2R050Z2.0-HEMI	02881853	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	0,5	2	■
JS452060E2R100Z2.0-HEMI	02881854	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	1,0	2	■
JS452080E2CZ2.0-HEMI	02881778	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	–	2	■
JS452080E2R050Z2.0-HEMI	02881855	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	0,5	2	■
JS452080E2R100Z2.0-HEMI	02881779	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	1,0	2	■
JS452100E2CZ2.0-HEMI	02881856	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,1	–	2	■
JS452100E2R050Z2.0-HEMI	02881857	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	0,5	2	■
JS452100E2R100Z2.0-HEMI	02881858	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	1,0	2	■
JS452120E2CZ2.0-HEMI	02881859	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	–	2	■
JS452120E2R050Z2.0-HEMI	02881860	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	0,5	2	■
JS452120E2R100Z2.0-HEMI	02881861	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	1,0	2	■
JS452120E2R200Z2.0-HEMI	02881780	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	2,0	2	■
JS452140E2CZ2.0-HEMI	02881862	2	E	14,0	14,0	28,0	88,0	41,0	13,3	0,1	–	2	■
JS452160E2CZ2.0-HEMI	02881863	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	–	2	■
JS452160E2R050Z2.0-HEMI	02881864	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	0,5	2	■
JS452160E2R100Z2.0-HEMI	02881782	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	2	■
JS452160E2R200Z2.0-HEMI	02881783	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	2	■
JS452200E2CZ2.0-HEMI	02881865	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	2	■
JS452200E2R050Z2.0-HEMI	02881866	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	2	■
JS452200E2R100Z2.0-HEMI	02881768	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	2	■

■ Stocked standard.

JS452

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius



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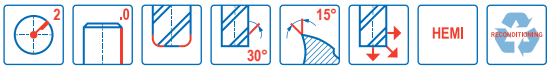


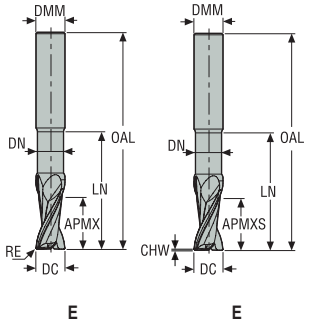
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS452080E3R020.0Z2-HEMI	03003413	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	■
JS452100E3R050.0Z2-HEMI	03003415	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	■
JS452120E3R050.0Z2-HEMI	03003419	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	■
JS452160E3R050.0Z2-HEMI	03003426	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	■
JS452200E3R050.0Z2-HEMI	03003433	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	■

■ Stocked standard.

JS452

High performance – Aluminium – Square – 2 Flutes – Weldon – Corner radius or chamfer



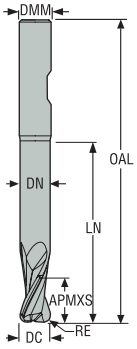
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS452060E2CZ2.3-HEMI	02881867	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	–	2	☐
JS452060E2R050Z2.3-HEMI	02881868	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	0,5	2	☐
JS452060E2R100Z2.3-HEMI	02881869	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	1,0	2	☐
JS452080E2CZ2.3-HEMI	02881947	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	–	2	☐
JS452080E2R050Z2.3-HEMI	02881870	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	0,5	2	☐
JS452080E2R100Z2.3-HEMI	02922247	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	1,0	2	☐
JS452100E2CZ2.3-HEMI	02881871	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,1	–	2	☐
JS452100E2R050Z2.3-HEMI	02881872	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	0,5	2	☐
JS452100E2R100Z2.3-HEMI	02881873	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	1,0	2	☐
JS452120E2CZ2.3-HEMI	02881874	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	–	2	☐
JS452120E2R050Z2.3-HEMI	02881875	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	0,5	2	☐
JS452120E2R100Z2.3-HEMI	02881876	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	1,0	2	☐
JS452120E2R200Z2.3-HEMI	02881948	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	2,0	2	☐
JS452140E2CZ2.3-HEMI	02881877	2	E	14,0	14,0	28,0	88,0	41,0	13,3	0,1	–	2	☐
JS452160E2CZ2.3-HEMI	02881878	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	–	2	☐
JS452160E2R050Z2.3-HEMI	02881879	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	0,5	2	☐
JS452160E2R100Z2.3-HEMI	02881949	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	2	☐
JS452160E2R200Z2.3-HEMI	02881950	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	2	☐
JS452200E2CZ2.3-HEMI	02881880	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	2	☐
JS452200E2R050Z2.3-HEMI	02881881	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	2	☐
JS452200E2R100Z2.3-HEMI	02881953	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	2	☐

☐ Weldon available. Delivery time is 3 days.

JS452

High performance – Aluminium – Square – 2 Flutes – Weldon – Corner radius



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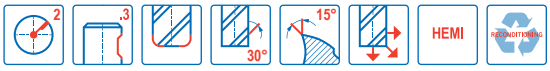


- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS452080E3R020.3Z2-HEMI	03003447	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	☐
JS452100E3R050.3Z2-HEMI	03003449	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	☐
JS452120E3R050.3Z2-HEMI	03003453	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	☐
JS452160E3R050.3Z2-HEMI	03003460	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	☐
JS452200E3R050.3Z2-HEMI	03003467	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	☐

☐ Weldon available. Delivery time is 3 days.

Cutting data – JS452 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	485 (370 — 600) *1600 (1300 — 1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	325 (250 — 400) *1075 (830 — 1300)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 670) *1825 (1500 — 2100)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	450 (340 — 560) *1475 (1200 — 1800)*

Cutting data – JS452 Slot milling

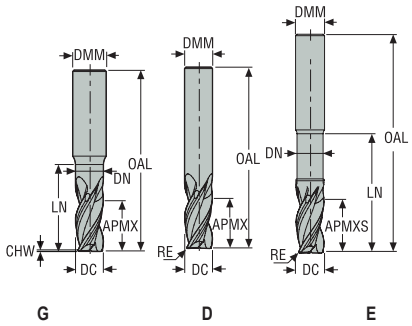
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
N3	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	265 (210 — 330) *870 (690 — 1000)*
TS1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
TP1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	400 (310 — 500) *1300 (1100 — 1600)*

Remark: if cornerradius is >15% of DC then a_p= -30%, f_z= -20%
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS453

High performance – Aluminium – Square – 3 Flutes – Cylindrical – Corner radius or chamfer



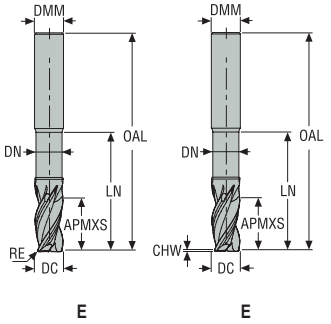
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453020G2CZ3.0-HEMI	02881896	2	G	2,0	6,0	4,0	57,0	7,0	1,9	0,1	–	3	■
JS453030G2CZ3.0-HEMI	02881897	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	–	3	■
JS453040G2CZ3.0-HEMI	02881898	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,1	–	3	■
JS453050G2CZ3.0-HEMI	02881899	2	G	5,0	6,0	10,0	57,0	14,0	4,75	0,1	–	3	■
JS453060D2CZ3.0-HEMI	02881900	2	D	6,0	6,0	12,0	57,0	–	–	0,1	–	3	■
JS453060D2R050Z3.0-HEMI	02881901	2	D	6,0	6,0	12,0	57,0	–	–	–	0,5	3	■
JS453080D2CZ3.0-HEMI	02881812	2	D	8,0	8,0	16,0	63,0	–	–	0,1	–	3	■
JS453080D2R050Z3.0-HEMI	02881902	2	D	8,0	8,0	16,0	63,0	–	–	–	0,5	3	■
JS453100D2CZ3.0-HEMI	02881903	2	D	10,0	10,0	20,0	72,0	–	–	0,1	–	3	■
JS453100D2R050Z3.0-HEMI	02881904	2	D	10,0	10,0	20,0	72,0	–	–	–	0,5	3	■
JS453120D2CZ3.0-HEMI	02881905	2	D	12,0	12,0	24,0	88,0	–	–	0,1	–	3	■
JS453120D2R050Z3.0-HEMI	02881906	2	D	12,0	12,0	24,0	88,0	–	–	–	0,5	3	■
JS453120E2R300.0Z3-HEMI	02905280	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	3,0	3	■
JS453140D2CZ3.0-HEMI	02881907	2	D	14,0	14,0	28,0	88,0	–	–	0,1	–	3	■
JS453160D2CZ3.0-HEMI	02881908	2	D	16,0	16,0	32,0	100,0	–	–	0,1	–	3	■
JS453160D2R050Z3.0-HEMI	02881909	2	D	16,0	16,0	32,0	100,0	–	–	–	0,5	3	■
JS453160E2R100.0Z3-HEMI	02905281	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	3	■
JS453160E2R200.0Z3-HEMI	02905282	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	3	■
JS453160E2R250.0Z3-HEMI	02905283	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,5	3	■
JS453160E2R300.0Z3-HEMI	02905284	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	3,0	3	■
JS453160E2R400.0Z3-HEMI	02905285	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	3	■
JS453200E2C.0Z3-HEMI	02905286	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	3	■
JS453200E2R050.0Z3-HEMI	02905287	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	3	■
JS453200E2R100.0Z3-HEMI	02905288	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	3	■
JS453200E2R200.0Z3-HEMI	02905289	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	2,0	3	■
JS453200E2R300.0Z3-HEMI	02905291	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	3,0	3	■

■ Stocked standard.

JS453

High performance – Aluminium – Square – 3 Flutes – Cylindrical – Corner radius or chamfer



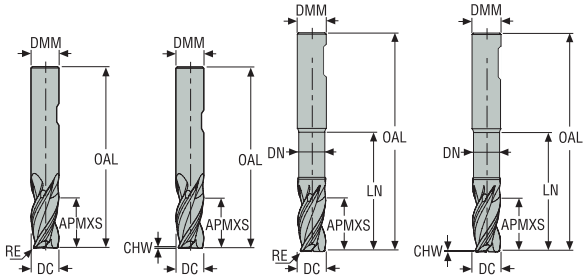
- Tolerances:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453120E3R300.0Z3-HEMI	02905294	3	E	12,0	12,0	24,0	110,0	54,0	11,4	–	3,0	3	■
JS453160E3R100.0Z3-HEMI	02905295	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	1,0	3	■
JS453160E3R200.0Z3-HEMI	02905296	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	2,0	3	■
JS453160E3R300.0Z3-HEMI	02905298	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	3,0	3	■
JS453160E3R400.0Z3-HEMI	02905299	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	4,0	3	■
JS453200E3C.0Z3-HEMI	02905300	3	E	20,0	20,0	36,0	150,0	90,0	19,0	0,1	–	3	■
JS453200E3R050.0Z3-HEMI	02905301	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	0,5	3	■
JS453200E3R100.0Z3-HEMI	02905302	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	1,0	3	■
JS453200E3R200.0Z3-HEMI	02905303	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	2,0	3	■
JS453200E3R300.0Z3-HEMI	02905305	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	3,0	3	■

■ Stocked standard.

JS453

High performance – Aluminium – Square – 3 Flutes – Weldon – Corner radius or chamfer



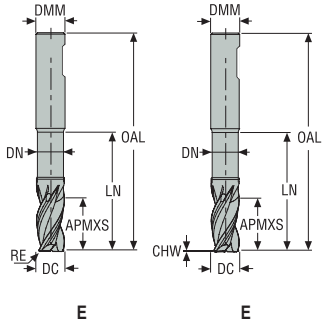
- Tolerances:
- DMM=h5
- DC=e7
- RE=±0,02 mm
- CHW= ±0,02 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453060D2CZ3.3-HEMI	02881910	2	D	6,0	6,0	12,0	57,0	–	–	0,1	–	3	☐
JS453060D2R050Z3.3-HEMI	02881911	2	D	6,0	6,0	12,0	57,0	–	–	–	0,5	3	☐
JS453080D2CZ3.3-HEMI	02881964	2	D	8,0	8,0	16,0	63,0	–	–	0,1	–	3	☐
JS453080D2R050Z3.3-HEMI	02881954	2	D	8,0	8,0	16,0	63,0	–	–	–	0,5	3	☐
JS453100D2CZ3.3-HEMI	02881913	2	D	10,0	10,0	20,0	72,0	–	–	0,1	–	3	☐
JS453100D2R050Z3.3-HEMI	02881914	2	D	10,0	10,0	20,0	72,0	–	–	–	0,5	3	☐
JS453120D2CZ3.3-HEMI	02881915	2	D	12,0	12,0	24,0	88,0	–	–	0,1	–	3	☐
JS453120D2R050Z3.3-HEMI	02881916	2	D	12,0	12,0	24,0	88,0	–	–	–	0,5	3	☐
JS453120E2R300.3Z3-HEMI	02905308	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	3,0	3	☐
JS453140D2CZ3.3-HEMI	02881917	2	D	14,0	14,0	28,0	88,0	–	–	0,1	–	3	☐
JS453160D2CZ3.3-HEMI	02881918	2	D	16,0	16,0	32,0	100,0	–	–	0,1	–	3	☐
JS453160D2R050Z3.3-HEMI	02881919	2	D	16,0	16,0	32,0	100,0	–	–	–	0,5	3	☐
JS453160E2R100.3Z3-HEMI	02905309	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	3	☐
JS453160E2R200.3Z3-HEMI	02905310	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	3	☐
JS453160E2R250.3Z3-HEMI	02905311	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,5	3	☐
JS453160E2R300.3Z3-HEMI	02905312	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	3,0	3	☐
JS453160E2R400.3Z3-HEMI	02905313	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	3	☐
JS453200E2C.3Z3-HEMI	02905314	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	3	☐
JS453200E2R050.3Z3-HEMI	02905315	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	3	☐
JS453200E2R100.3Z3-HEMI	02905316	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	3	☐
JS453200E2R200.3Z3-HEMI	02905317	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	2,0	3	☐
JS453200E2R300.3Z3-HEMI	02905319	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	3,0	3	☐

☐ Weldon available. Delivery time is 3 days.

JS453

High performance – Aluminium – Square – 3 Flutes – Weldon – Corner radius or chamfer



- Tolerances:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453120E3R300.3Z3-HEMI	02905322	3	E	12,0	12,0	24,0	110,0	54,0	11,4	–	3,0	3	☐
JS453160E3R100.3Z3-HEMI	02905323	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	1,0	3	☐
JS453160E3R200.3Z3-HEMI	02905324	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	2,0	3	☐
JS453160E3R300.3Z3-HEMI	02905326	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	3,0	3	☐
JS453160E3R400.3Z3-HEMI	02905327	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	4,0	3	☐
JS453200E3C.3Z3-HEMI	02905328	3	E	20,0	20,0	36,0	150,0	90,0	19,0	0,1	–	3	☐
JS453200E3R050.3Z3-HEMI	02905329	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	0,5	3	☐
JS453200E3R100.3Z3-HEMI	02905330	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	1,0	3	☐
JS453200E3R200.3Z3-HEMI	02905331	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	2,0	3	☐
JS453200E3R300.3Z3-HEMI	02905333	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	3,0	3	☐

☐ Weldon available. Delivery time is 3 days.

Cutting data – JS453 Side milling

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 660) *1825 (1500 — 2100)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	480 (370 — 600) *1575 (1300 — 1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	320 (250 — 400) *1050 (830 — 1300)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 660) *1825 (1500 — 2100)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	445 (340 — 550) *1450 (1200 — 1800)*

Cutting data – JS453 Slot milling

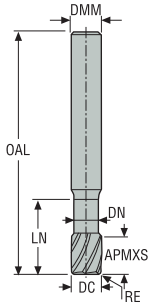
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	400 (300 — 490) *1300 (990 — 1600)*
N3	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	265 (200 — 330) *870 (660 — 1000)*
TS1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
TP1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	400 (300 — 500) *1300 (990 — 1600)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

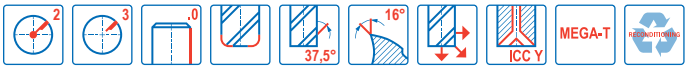
JHP490

High performance – Aluminium – Square – 2-3 Flutes – Cylindrical – Corner radius – ICC



E

- Tolerances:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Regrind possible

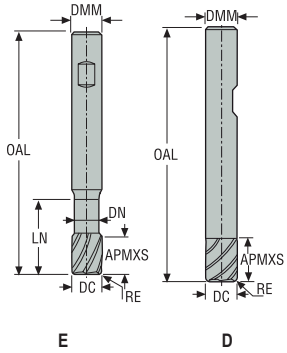


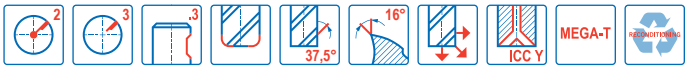
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
490V100R050Z2.0A-MEGA-T	02623870	2	E	■	10,0	10,0	12,0	65,0	20,0	9,0	0,5	2	■
490V120R200Z2.0A-MEGA-T	02623883	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	■
490V160R050Z3.0A-MEGA-T	02623889	2	E	■	16,0	16,0	18,0	85,0	32,0	14,5	0,5	3	■
490V200R050Z3.0A-MEGA-T	02623908	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	■
490V250R050Z3.0A-MEGA-T	02623926	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	■
490VL100R100Z2.0A-MEGA-T	02623876	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	■
490VL120R050Z3.0A-MEGA-T	02623880	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	■
490VL120R100Z2.0A-MEGA-T	02623886	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	■
490VL160R050Z3.0A-MEGA-T	02623891	3	E	■	16,0	16,0	18,0	95,0	45,0	14,5	0,5	3	■
490VL200R200Z3.0A-MEGA-T	02623916	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	■
490VXL250R050Z3.0A-MEGA-T	02623927	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	■

■ Stocked standard.

JHP490

High performance – Aluminium – Square – 2-3 Flutes – Weldon – Corner radius – ICC





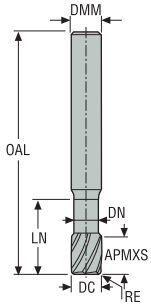
- Tolerances:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
490V120R200Z2.0A-MEGA-TW	02669371	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	□
490V160R050Z3A-MEGA-T	02623888	2	E	■	16,0	16,0	18,0	85,0	32,0	14,5	0,5	3	■
490160R200Z3A-MEGA-T	02623898	2	D	■	16,0	16,0	34,0	95,0	–	–	2,0	3	■
490V200R050Z3A-MEGA-T	02623907	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	■
490V250R050Z3A-MEGA-T	02623925	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	■
490VL100R100Z2.0A-MEGA-TW	02669368	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	□
490VL120R050Z3.0A-MEGA-TW	02669374	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	□
490VL120R100Z2.0A-MEGA-TW	02669375	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	□
490VL160R050Z3.0A-MEGA-TW	02669382	3	E	■	16,0	16,0	18,0	95,0	45,0	14,5	0,5	3	□
490VL200R200Z3.0A-MEGA-TW	02669388	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	□
490VXL250R050Z3.0A-MEGA-TW	02669397	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	□

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

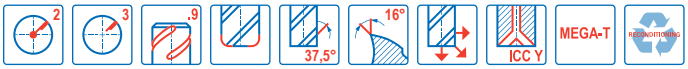
JHP490

High performance – Aluminium – Square – 2-3 Flutes – Safelock – Corner radius – ICC



E

- Tolerances:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
490V100R050Z2.9A-MEGA-T	02927984	2	E	■	10,0	10,0	12,0	65,0	20,0	9,0	0,5	2	□
490V120R200Z2.9A-MEGA-T	02927988	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	□
490V160R050Z3.9A-MEGA-T	02927990	2	E	■	16,0	16,0	18,0	85,0	32,0	14,0	0,5	3	□
490V200R050Z3.9A-MEGA-T	02927992	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	□
490V250R050Z3.9A-MEGA-T	02927993	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	□
490VL100R100Z2.9A-MEGA-T	02927994	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	□
490VL120R050Z3.9A-MEGA-T	02927995	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	□
490VL120R100Z2.9A-MEGA-T	02927996	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	□
490VL160R050Z3.9A-MEGA-T	02927997	3	E	■	16,0	16,0	18,0	95,0	32,0	14,0	0,5	3	□
490VL200R200Z3.9A-MEGA-T	02927998	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	□
490VXL250R050Z3.9A-MEGA-T	02927999	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	□

□ Safelock available. Subject to change, refer to current Price and Stock List.

Cutting data – JHP490 Side milling roughing

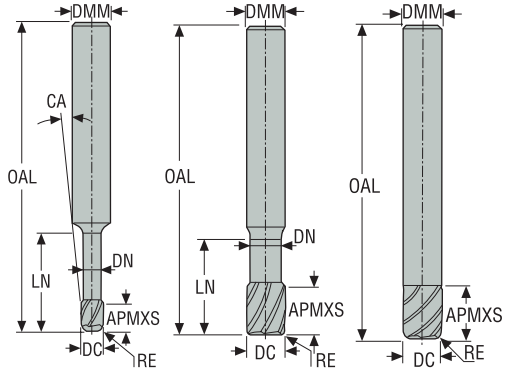
SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
N1	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	700 (550 — 860) *2325 (1900 — 2800)*
N2	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	455 (350 — 550) *1500 (1200 — 1800)*
N3	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	540 (440 — 650) *1775 (1500 — 2100)*

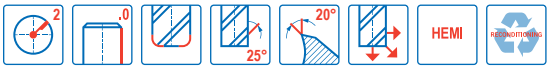
Cutting data – JHP490 Slot milling

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
N1	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	650 (500 — 790) *2125 (1700 — 2500)*
N2	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	420 (330 — 510) *1375 (1100 — 1600)*
N3	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	500 (400 — 590) *1650 (1400 — 1900)*

JH40

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius





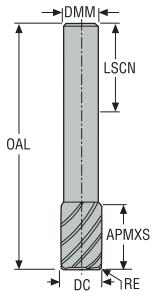
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,1 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
40K060-HEMI	00022089	1	D	6,0	6,0	13,0	50,0	–	–	0,1	–	2	■
40K080-HEMI	00022090	1	D	8,0	8,0	13,0	50,0	–	–	0,1	–	2	■
40K100-HEMI	00022091	1	D	10,0	10,0	16,0	50,0	–	–	0,1	–	2	■
40K120-HEMI	00022092	1	D	12,0	12,0	16,0	65,0	–	–	0,1	–	2	■
40020-HEMI	00022093	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,1	3,5	2	■
40030-HEMI	00022094	2	E	3,0	3,0	4,0	40,0	8,0	2,9	0,1	–	2	■
40040-HEMI	00022095	2	E	4,0	4,0	5,0	50,0	12,0	3,8	0,1	–	2	■
40050-HEMI	00022120	2	E	5,0	5,0	8,0	50,0	14,0	4,8	0,1	–	2	■
40060-HEMI	00022250	2	E	6,0	6,0	8,0	65,0	18,0	5,7	0,1	–	2	■
40080-HEMI	00022580	2	E	8,0	8,0	10,0	70,0	22,0	7,7	0,1	–	2	■
40100-HEMI	00022663	2	E	10,0	10,0	14,0	80,0	28,0	9,7	0,1	–	2	■
40120-HEMI	00022667	2	E	12,0	12,0	16,0	90,0	35,0	11,5	0,1	–	2	■
40160-HEMI	00022668	2	E	16,0	16,0	20,0	90,0	40,0	15,5	0,1	–	2	■
40200-HEMI	00022701	2	E	20,0	20,0	25,0	100,0	50,0	19,5	0,1	–	2	■

■ Stocked standard.

JH40

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius



P

- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,1 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LSCN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
40020-RS	02479642	2	P	2,0	1,9	3,0	40,0	28,0	0,1	2	■
40030-RS	02479643	2	P	3,0	2,9	4,0	60,0	28,0	0,1	2	■
40040-RS	02479644	2	P	4,0	3,8	5,0	60,0	28,0	0,1	2	■
40050-RS	02479645	2	P	5,0	4,8	8,0	70,0	28,0	0,1	2	■
40060-RS	02479646	2	P	6,0	5,8	8,0	65,0	36,0	0,1	2	■
40080-RS	02479647	2	P	8,0	7,8	10,0	70,0	36,0	0,1	2	■
40100-RS	02479648	2	P	10,0	9,7	14,0	100,0	40,0	0,1	2	■
40120-RS	02479649	2	P	12,0	11,7	16,0	90,0	45,0	0,1	2	■
40L060-RS	02479650	3	P	6,0	5,8	8,0	100,0	36,0	0,1	2	■
40L080-RS	02479651	3	P	8,0	7,8	10,0	100,0	36,0	0,1	2	■
40L120-RS	02479652	3	P	12,0	11,7	16,0	125,0	45,0	0,1	2	■
40L160-RS	02479653	3	P	16,0	15,7	20,0	125,0	48,0	0,1	2	■
40L200-RS	02479654	3	P	20,0	19,7	25,0	125,0	50,0	0,1	2	■

■ Stocked standard.

Cutting data – JH40 Side milling

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*
N11	E/M/A	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	425 (320 — 520) *1400 (1100 — 1700)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*

Cutting data – JH40 Slot milling

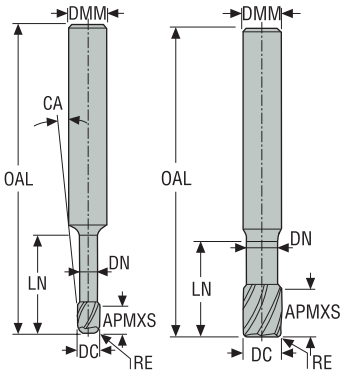
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.60 *0,60*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510 — 700) *1975 (1700 — 2200)*
N11	E/M/A	0.40 *0,40*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
TS1	A	1.0 *1,0*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510 — 700) *1975 (1700 — 2200)*

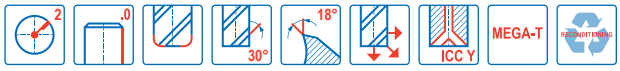
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH421

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius – ICC





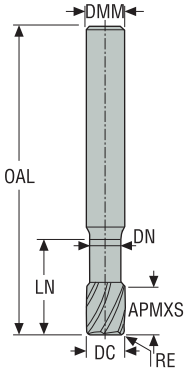
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm			
421020R020Z2-MEGA-T	02434927	2	G	–	2,0	3,0	3,0	40,0	8,0	1,8	0,2	3,0	2	■
421030R020Z2-MEGA-T	02434939	2	E	–	3,0	3,0	4,0	40,0	12,0	2,7	0,2	–	2	■
421040R020Z2-MEGA-T	02434940	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,2	3,0	2	■
421040R030Z2-MEGA-T	02434941	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,3	3,0	2	■
421050R100Z2-MEGA-T	02434942	2	G	–	5,0	6,0	6,0	50,0	18,0	4,5	1,0	1,5	2	■
421060R025Z2-MEGA-T	02434946	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,25	–	2	■
421060R050Z2-MEGA-T	02434947	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,5	–	2	■
421060R100Z2-MEGA-T	02434958	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	1,0	–	2	■
421080R030Z2-MEGA-T	02434960	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,3	–	2	■
421080R060Z2-MEGA-T	02434964	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,6	–	2	■
421080R100Z2-MEGA-T	02434967	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	1,0	–	2	■
421100R030Z2-MEGA-T	02434968	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,3	–	2	■
421100R080Z2-MEGA-T	02434970	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,8	–	2	■
421100R150Z2-MEGA-T	02434971	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	1,5	–	2	■
421100R250Z2-MEGA-T	02438614	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	2,5	–	2	■
421100R310Z2-MEGA-T	02438683	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	3,1	–	2	■
421120R030Z2-MEGA-T	02434983	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,3	–	2	■
421120R050Z2-MEGA-T	02434986	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,5	–	2	■
421120R100Z2-MEGA-T	02434988	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,0	–	2	■
421120R150Z2-MEGA-T	02434989	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,5	–	2	■
421120R200Z2-MEGA-T	02434990	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,0	–	2	■
421120R250Z2AMEGA-T	02435008	2	E	■	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	■
421120R250Z2-MEGA-T	02435007	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	■
421120R310Z2-MEGA-T	02435009	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	3,1	–	2	■

■ Stocked standard.

JH421

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius – ICC



E

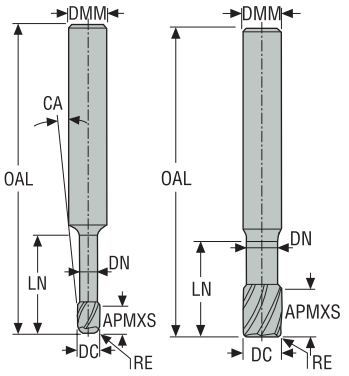
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible

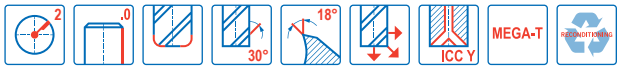
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
421160R050Z2-MEGA-T	02435010	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	0,5	2	■
421160R200Z2-MEGA-T	02435014	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,0	2	■
421160R250Z2AMEGA-T	02435020	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	■
421160R250Z2-MEGA-T	02435012	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	■
421160R310Z2-MEGA-T	02435036	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	3,1	2	■
421160R400Z2AMEGA-T	02438684	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	■
421160R400Z2-MEGA-T	02435039	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	■
421200R160Z2-MEGA-T	02435042	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	1,6	2	■
421200R200Z2-MEGA-T	02435044	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,0	2	■
421200R250Z2AMEGA-T	02438685	2	E	■	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	■
421200R250Z2-MEGA-T	02435046	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	■
421200R310Z2-MEGA-T	02435049	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	3,1	2	■
421200R400Z2-MEGA-T	02435051	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	4,0	2	■
421200R500Z2-MEGA-T	02435055	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	5,0	2	■

■ Stocked standard.

JH421

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius – ICC





- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm			
421L080R020Z2-MEGA-T	02435068	3	E	–	8,0	8,0	6,0	75,0	40,0	7,2	0,2	–	2	■
421L100R050Z2-MEGA-T	02435070	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	0,5	–	2	■
421L100R250Z2-MEGA-T	02435074	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	2,5	–	2	■
421L100R310Z2-MEGA-T	02438690	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	3,1	–	2	■
421L120R050Z2-MEGA-T	02435340	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	0,5	–	2	■
421L120R100Z2-MEGA-T	02435343	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	1,0	–	2	■
421L120R200Z2-MEGA-T	02435373	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,0	–	2	■
421L120R250Z2-MEGA-T	02435374	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,5	–	2	■
421L120R310Z2-MEGA-T	02438692	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	3,1	–	2	■
421L160R050Z2-MEGA-T	02435375	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	0,5	–	2	■
421L160R100Z2-MEGA-T	02435380	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	1,0	–	2	■
421L160R200Z2-MEGA-T	02435381	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,0	–	2	■
421L160R250Z2AMEGA-T	02435383	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	2,5	–	2	■
421L160R250Z2-MEGA-T	02435382	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,5	–	2	■
421L160R310Z2-MEGA-T	02435384	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	3,1	–	2	■
421L160R400Z2AMEGA-T	02435386	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	4,0	–	2	■
421L200R050Z2-MEGA-T	02435387	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	0,5	–	2	■
421L200R200Z2-MEGA-T	02435391	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	2,0	–	2	■
421L200R310Z2-MEGA-T	02435398	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	3,1	–	2	■
421L200R500Z2-MEGA-T	02435401	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	5,0	–	2	■

■ Stocked standard.

Cutting data – JH421 Side milling

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.400	1.0	0.030	0.044	0.060	0.075	0.090	0.12	0.15	0.18	0.20	0.22	0.25	0.28	620 (520 — 720)
		0,400	*1,0*	*0,0012*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0048*	*0,0060*	*0,0070*	*0,0080*	*0,0085*	*0,010*	*0,011*	*2025 (1800 — 2300)*
N11	E/M/A	0.400	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	410 (310 — 510)
		0,400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*1350 (1100 — 1600)*
TS1	A	0.400	1.0	0.030	0.044	0.060	0.075	0.090	0.12	0.15	0.18	0.20	0.22	0.25	0.28	620 (520 — 720)
		0,400	*1,0*	*0,0012*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0048*	*0,0060*	*0,0070*	*0,0080*	*0,0085*	*0,010*	*0,011*	*2025 (1800 — 2300)*
TP1	M	0.400	1.0	0.024	0.036	0.048	0.060	0.070	0.095	0.12	0.14	0.16	0.18	0.20	0.24	410 (310 — 500)
		0,400	*1,0*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0055*	*0,0065*	*0,0070*	*0,0080*	*0,0095*	*1350 (1100 — 1600)*

Cutting data – JH421 Slot milling

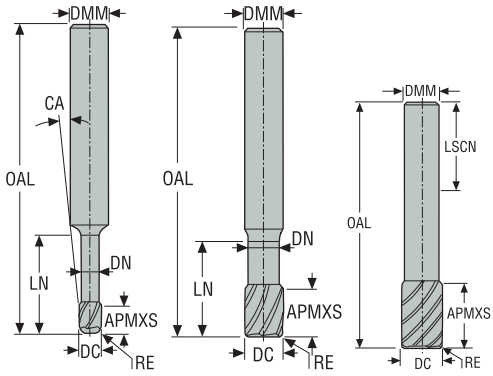
SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.50	0.014	0.022	0.028	0.036	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.18	610 (510 — 700)
		0,50	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0070*	*2000 (1700 — 2200)*
N11	E/M/A	0.50	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.080	0.10	405 (310 — 500)
		0,50	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0032*	*0,0040*	*1325 (1100 — 1600)*
TS1	A	0.50	0.014	0.022	0.028	0.036	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.18	610 (510 — 700)
		0,50	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0070*	*2000 (1700 — 2200)*
TP1	M	0.50	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	405 (310 — 500)
		0,50	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*1325 (1100 — 1600)*

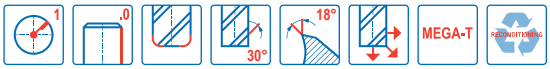
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH410

High performance – Aluminium – Square – 1 Flute – Cylindrical – Corner radius





- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	LSCN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm			
410020R050-MEGA-T	02451548	2	G	2,0	6,0	3,0	50,0	6,0	36,0	1,7	0,5	12,0	1	■
410030R050-MEGA-T	02451578	2	G	3,0	6,0	4,0	50,0	8,0	36,0	2,7	0,5	7,5	1	■
410ML030R050-MEGA-T	02451580	2	G	3,0	6,0	4,0	60,0	15,0	36,0	2,7	0,5	5,0	1	■
410040R050-MEGA-T	02451581	2	G	4,0	6,0	5,0	60,0	8,0	36,0	3,6	0,5	5,5	1	■
410ML040R050-MEGA-T	02451585	2	G	4,0	6,0	5,0	60,0	15,0	36,0	3,6	0,5	3,5	1	■
410050R050-MEGA-T	02451586	2	G	5,0	6,0	7,0	65,0	11,0	36,0	4,5	0,5	2,5	1	■
410ML050R050-MEGA-T	02451589	2	G	5,0	6,0	7,0	65,0	18,0	36,0	4,5	0,5	1,5	1	■
410TL050R050-MEGA-T	02451587	2	G	5,0	6,0	7,0	65,0	26,0	36,0	4,5	0,5	1,5	1	■
410060R050-MEGA-T	02451591	2	E	6,0	6,0	8,0	70,0	11,0	36,0	5,3	0,5	–	1	■
410ML060R050-MEGA-T	02451593	2	E	6,0	6,0	8,0	70,0	18,0	36,0	5,3	0,5	–	1	■
410TL060R050-MEGA-T	02451592	2	E	6,0	6,0	8,0	70,0	31,0	36,0	5,3	0,5	–	1	■
410070RSR050-MEGA-T	02451594	2	P	7,0	6,0	9,0	65,0	–	36,0	–	0,5	–	1	■
410090RSR050-MEGA-T	02451596	2	P	9,0	8,0	11,0	65,0	–	36,0	–	0,5	–	1	■
410110RSR050-MEGA-T	02451598	2	P	11,0	10,0	13,0	70,0	–	40,0	–	0,5	–	1	■
410130RSR100-MEGA-T	02451600	2	P	13,0	12,0	15,0	70,0	–	45,0	–	1,0	–	1	■
410150RSR100-MEGA-T	02451603	2	P	15,0	14,0	17,0	80,0	–	45,0	–	1,0	–	1	■
410170RSR100-MEGA-T	02451605	2	P	17,0	16,0	19,0	80,0	–	48,0	–	1,0	–	1	■
410L070RSR200-MEGA-T	02451595	3	P	7,0	6,0	9,0	85,0	–	36,0	–	2,0	–	1	■
410L090RSR200-MEGA-T	02451597	3	P	9,0	8,0	11,0	85,0	–	36,0	–	2,0	–	1	■
410L110RSR200-MEGA-T	02451599	3	P	11,0	10,0	13,0	90,0	–	40,0	–	2,0	–	1	■
410L130RSR200-MEGA-T	02451601	3	P	13,0	12,0	15,0	90,0	–	45,0	–	2,0	–	1	■
410L150RSR200-MEGA-T	02451604	3	P	15,0	14,0	17,0	110,0	–	45,0	–	2,0	–	1	■
410L170RSR200-MEGA-T	02451606	3	P	17,0	16,0	19,0	110,0	–	48,0	–	2,0	–	1	■

■ Stocked standard.

Cutting data – JH410 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*
N11	E/M/A	0.318 *0,318*	0.65 *0,65*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	495 (380 — 610) *1625 (1300 — 2000)*
TS1	A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*

Cutting data – JH410 Slot milling

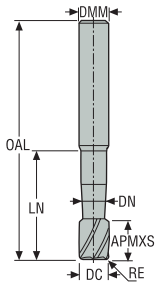
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.75 *0,75*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530 — 730) *2075 (1800 — 2300)*
N11	E/M/A	0.36 *0,36*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	420 (320 — 520) *1375 (1100 — 1700)*
TS1	A	1.0 *1,0*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530 — 730) *2075 (1800 — 2300)*

For cutting data recalculations, see pages 573 - 580

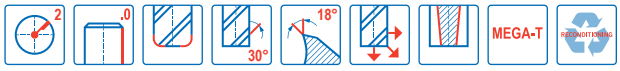
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH440

High speed – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius



E



- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
440060-MEGA-T	00022702	2	E	6,0	6,0	8,0	60,0	30,0	5,4	1,5	2	■
440080-MEGA-T	00022865	2	E	8,0	8,0	10,0	60,0	30,0	7,2	2,0	2	■

■ Stocked standard.

Cutting data – JH440 Copy milling roughing

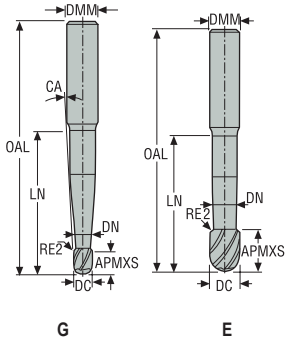
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
N1	E/M/A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
N2	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	510 (390 — 640) *1675 (1300 — 2000)*
N3	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	340 (260 — 420) *1125 (860 — 1300)*
N11	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	255 (130 — 370) *840 (430 — 1200)*
TS1	A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
TP1	A	0.300 *0,300*	0.60 *0,60*	0.060 *0,0024*	0.080 *0,0032*	510 (380 — 630) *1675 (1300 — 2000)*

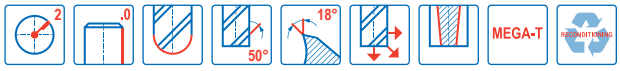
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH450

High speed – Aluminium – Ball nose – 2 Flutes – Cylindrical





- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE2	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
450020-MEGA-T	00022977	2	G	2,0	3,0	1,75	40,0	10,0	1,8	1,0	3,0	2	■
450030-MEGA-T	00022978	2	E	3,0	3,0	2,5	40,0	12,0	2,7	2,0	–	2	■
450040-MEGA-T	00022979	2	G	4,0	6,0	3,5	50,0	21,0	3,6	2,0	3,0	2	■
450050-MEGA-T	00022980	2	G	5,0	6,0	4,5	50,0	22,5	4,5	2,0	2,0	2	■
450060-MEGA-T	00023020	2	E	6,0	6,0	5,5	55,0	25,0	5,4	2,0	–	2	■
450080-MEGA-T	00023032	2	E	8,0	8,0	7,0	65,0	30,0	7,2	2,0	–	2	■
450100-MEGA-T	00023040	2	E	10,0	10,0	8,5	75,0	35,0	9,0	3,0	–	2	■
450120-MEGA-T	00029842	2	E	12,0	12,0	10,5	75,0	40,0	11,0	3,0	–	2	■
450160-MEGA-T	00023050	2	E	16,0	16,0	14,0	90,0	50,0	14,5	4,0	–	2	■
450200-MEGA-T	00023053	2	E	20,0	20,0	17,0	100,0	50,0	18,0	4,0	–	2	■
450L100-MEGA-T	00023056	3	G	10,0	12,0	8,5	125,0	50,0	9,0	3,0	1,5	2	■
450L120-MEGA-T	00023091	3	E	12,0	12,0	10,5	150,0	60,0	11,0	3,0	–	2	■
450L160-MEGA-T	00023095	3	E	16,0	16,0	14,0	150,0	70,0	14,5	4,0	–	2	■

■ Stocked standard.

Cutting data – JH450 Copy milling roughing

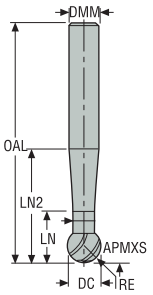
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	690 (670 — 930) *2275 (2200 — 3000)*
N2	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	470 (410 — 680) *1550 (1400 — 2200)*
N3	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	315 (280 — 450) *1025 (920 — 1400)*
N11	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (420 — 680) *1550 (1400 — 2200)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	700 (630 — 860) *2300 (2100 — 2800)*
TP1	M	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (410 — 680) *1550 (1400 — 2200)*

For cutting data recalculations, see pages 573 - 580

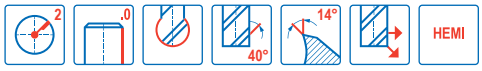
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH460

High speed – Aluminium – Ball nose – 2 Flutes – Cylindrical



E



- Tolerances:
- DMM=h5
- DC=-0,02/-0,06 mm
- RE= ±0.02 mm
- SA=250°

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm		
460030-HEMI	00040372	2	E	3,0	3,0	2,3	60,0	4,8	9,9	1,5	1,5	2	■
460040-HEMI	00040373	2	E	4,0	4,0	3,1	60,0	5,6	12,1	2,0	2,0	2	■
460050-HEMI	00040376	2	E	5,0	5,0	3,9	70,0	6,4	14,4	2,5	2,5	2	■
460060-HEMI	00040377	2	E	6,0	6,0	4,7	80,0	9,7	19,1	3,0	3,0	2	■
460080-HEMI	00040378	2	E	8,0	8,0	6,2	85,0	11,2	23,6	4,0	4,0	2	■
460100-HEMI	00040379	2	E	10,0	10,0	7,8	100,0	15,6	30,8	5,0	5,0	2	■
460120-HEMI	00040380	2	E	12,0	12,0	9,4	125,0	17,2	35,3	6,0	6,0	2	■

■ Stocked standard.

Cutting data – JH460 Copy milling roughing

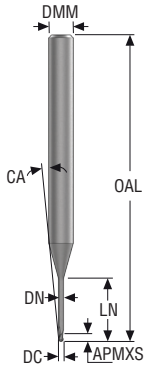
SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
N1	E/M/A	0.500 *0,500*	0.20 *0,20*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (500 — 680) *1925 (1700 — 2200)*
N11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	610 (510 — 700) *2000 (1700 — 2200)*
S11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	120 (110 — 130) *395 (370 — 420)*
S12	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	90 (82 — 100) *295 (270 — 320)*
S13	E/M/A	0.300 *0,300*	0.20 *0,20*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	75 (65 — 81) *245 (220 — 260)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.13 *0,0050*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	620 (520 — 720) *2025 (1800 — 2300)*
TP1	M	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	405 (360 — 450) *1325 (1200 — 1400)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

SMB413/414/416

Miniature – Aluminium – Ball nose – 2 Flutes – Cylindrical



G

- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC = 0/-0,01 mm
- RE = ±0,005 mm

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	DN	LN	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm			
SMB414020G4B.0Z2	–	10109385	4	G	2,0	4	2,0	50	1,9	12,0	3,75 °	2	■
SMB414020G4B.0Z2	M9	10109139	4	G	2,0	4	2,0	50	1,9	12,0	3,75 °	2	■
SMB414030G4B.0Z2	–	10109386	4	G	3,0	4	3,0	50	2,85	16,0	1,68 °	2	■
SMB414030G4B.0Z2	M9	10109140	4	G	3,0	4	3,0	50	2,85	16,0	1,68 °	2	■
SMB413025G5B.0Z2	–	10109133	5	G	2,5	3	2,5	50	2,4	20,0	0,71 °	2	■
SMB413025G5B.0Z2	M9	10109136	5	G	2,5	3	2,5	50	2,4	20,0	0,71 °	2	■
SMB414025G5B.0Z2	–	10109387	5	G	2,5	4	2,5	50	2,4	20,0	1,94 °	2	■
SMB414025G5B.0Z2	M9	10109141	5	G	2,5	4	2,5	50	2,4	20,0	1,94 °	2	■
SMB416025G5B.0Z2	–	10109390	5	G	2,5	6	2,5	55	2,4	20,0	3,87 °	2	■
SMB416025G5B.0Z2	M9	10109145	5	G	2,5	6	1,0	55	0,95	20,0	3,87 °	2	■
SMB414010G6B.0Z2	–	10109381	6	G	1,0	4	1,0	50	0,95	10,0	5,5 °	2	■
SMB414010G6B.0Z2	M9	10109142	6	G	1,0	4	1,0	50	0,95	10,0	5,5 °	2	■
SMB413015G6B.0Z2	–	10109134	6	G	1,5	3	1,5	50	1,4	20,0	1,9 °	2	■
SMB413015G6B.0Z2	M9	10109137	6	G	1,5	3	1,5	50	1,4	20,0	1,9 °	2	■
SMB414015G6B.0Z2	–	10109388	6	G	1,5	4	2,5	55	2,4	20,0	2,92 °	2	■
SMB414015G6B.0Z2	M9	10109143	6	G	1,5	4	1,5	55	1,4	20,0	2,92 °	2	■
SMB416015G6B.0Z2	–	10109391	6	G	1,5	6	1,5	55	1,4	20,0	4,56 °	2	■
SMB416015G6B.0Z2	M9	10109146	6	G	1,5	6	1,5	55	1,4	20,0	4,56 °	2	■
SMB413010G7B.0Z2	–	10109135	7	G	1,0	3	1,0	50	0,95	18,0	2,63 °	2	■
SMB413010G7B.0Z2	M9	10109138	7	G	1,0	3	1,0	50	0,95	18,0	2,63 °	2	■
SMB414010G7B.0Z2	–	10109389	7	G	1,0	4	1,0	50	0,95	18,0	3,64 °	2	■
SMB414010G7B.0Z2	M9	10109144	7	G	1,0	4	1,0	50	0,95	18,0	3,64 °	2	■
SMB416010G7B.0Z2	–	10109392	7	G	1,0	6	1,0	55	0,95	18,0	5,23 °	2	■
SMB416010G7B.0Z2	M9	10109147	7	G	1,0	6	1,0	55	0,95	18,0	5,23 °	2	■

■ Stocked standard.

Cutting data – SMB413 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z			v_c
				1	1.5	2.5	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*

Cutting data – SMB414 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z					v_c
				1	1.5	2	2.5	3	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*

Cutting data – SMB416 Copy milling roughing

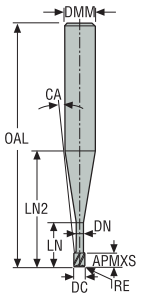
SMG		a_e/DC	a_p/DC	f_z			v_c
				1	1.5	2.5	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*

For cutting data recalculations, see pages 573 - 580

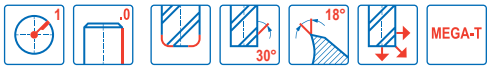
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JM403/JM404/JM406

Miniature – Aluminium – Square – 1 Flute – Cylindrical – Corner radius



G



- Tolerances:
- Run-out=<0,005 mm
- DMM= h5
- DC= < Ø0,6= -0,005/-0,013 mm
- DC= ≥ Ø0,6= -0,005/-0,015 mm
- RE= ±0,01 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm			
403ML005R005-MEGA-T	02568434	2	G	0,5	3,0	0,5	40,0	1,5	6,7	0,45	0,05	11,0	1	■
403ML008R005-MEGA-T	02568450	2	G	0,8	3,0	0,8	40,0	2,5	7,1	0,75	0,05	9,0	1	■
403ML010R010-MEGA-T	02568456	2	G	1,0	3,0	1,0	40,0	4,0	8,3	0,95	0,1	7,5	1	■
406ML015R010-MEGA-T	02568478	5	G	1,5	6,0	1,5	50,0	5,0	14,0	1,4	0,1	9,5	1	■
404ML020R010-MEGA-T	02577246	5	G	2,0	4,0	2,0	40,0	6,0	10,4	1,9	0,1	6,0	1	■

■ Stocked standard.

Cutting data – JM403/JM404/406 Side milling

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	0.8	1	1.5	2	
N1	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	365 (310 — 420) *1200 (1100 — 1300)*
N2	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	235 (200 — 270) *770 (660 — 880)*
N3	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	155 (140 — 180) *510 (460 — 590)*

Cutting data – JM403/JM404/406 Slot milling

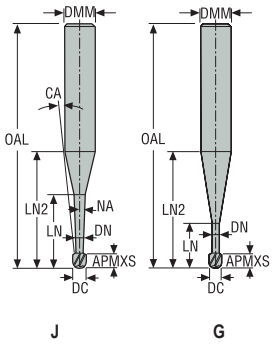
SMG		a_p/DC	f_z					v_c
			0.5	0.8	1	1.5	2	
N1	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	315 (270 — 360) *1025 (890 — 1100)*
N2	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	200 (170 — 230) *660 (560 — 750)*
N3	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	135 (120 — 150) *445 (400 — 490)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JM413/JM416

Miniature – Aluminium – Ball nose – 2 Flute – Cylindrical



- Tolerances:
- Run-out=<0,005 mm
- DMM=h5
- DC= < Ø 0,6= -0,005/-0,013 mm
- DC= ≥ Ø 0,6= -0,005/-0,015 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm				
413ML005TN-MEGA-T	02568709	2	J	0,5	3,0	0,375	40,0	1,5	6,6	0,45	0,25	0,9	11,5	2	■
413L005-MEGA-T	02568711	3	G	0,5	3,0	0,375	40,0	2,5	7,7	0,45	0,25	0,0	10,0	2	■
413L008-MEGA-T	02568727	3	G	0,8	3,0	0,6	40,0	4,0	8,6	0,75	0,4	0,0	8,0	2	■
413L010-MEGA-T	02568736	3	G	1,0	3,0	0,75	40,0	5,0	9,3	0,95	0,5	0,0	7,0	2	■
416L015-MEGA-T	02568772	3	G	1,5	6,0	1,125	50,0	7,5	16,5	1,4	0,75	0,0	8,5	2	■
416L020-MEGA-T	02568779	3	G	2,0	6,0	1,5	50,0	10,0	18,1	1,9	1,0	0,0	7,0	2	■

■ Stocked standard.

Cutting data – JM413/416 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z					v_c
				0,5	0.8	1	1.5	2	
N1	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*
N2	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	245 (240 — 320) *800 (790 — 1000)*
N3	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	165 (160 — 210) *540 (530 — 680)*
N11	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	320 (300 — 430) *1050 (990 — 1400)*
TS1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*
TP1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

HARD

Seco offers a complete range of high performance solid carbide square shoulder end mills, ballnose cutters and finish end mills for high productivity for hardened steel.

- JHP170, JHF181, JH120, JH130, JH930, JH142, JME142 and JME144 for radius type.
- JH112, JH150, JH160 and JMB112 for ball-nose type.

Seco

Tool Selection Hard

Name		JHP170	JHF181	JH120	JH130	JH930	JH142
Page(s)		382	385	388	390	143, 392	203, 395
Family name		HPM	HFM	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Type of mill							
Shank	Cylindrical	■	■	■	■	■	■
	Weldon	■					
Number of Flutes		3-4	3-4-5	4	5-6, 8	5-6, 8	2-4-5-6
ICC			■				
Diameter range	Metric	2-20	1-10	2-16	6-20	6-20	2-12
	Inch						
Length availability		2	1,2,3,4	2	2	2	2,3,6
Operation							
SMG							
H3		●	●	●	●	●	●
H5		●	●	●	●	●	●
H7		●	●	●	●	●	●
H8		●	●	●	●	●	●
H11		●	●	●	●	●	
H12		●	●	●	●	●	
H21		●	●	●	●	●	●
H31		●	●	●	●	●	●

■ Stock standard □ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

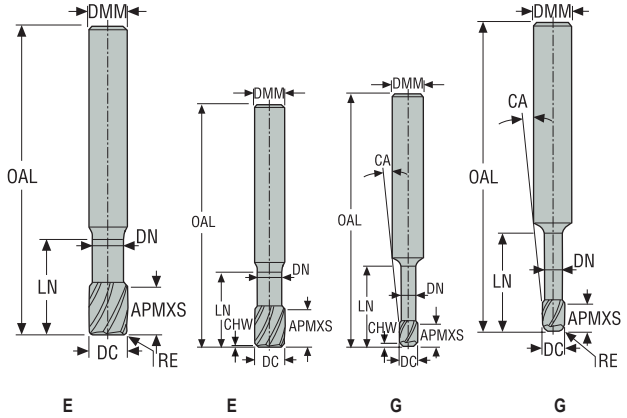
Tool Selection Hard

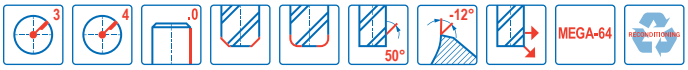
Name		JH112	JH150	JH160	JME142	JME144	JMB112
Page(s)		208, 398	401	403	405	410	412
Family name		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Type of mill					r	r	
Shank	Cylindrical	■	■	■	■	■	■
	Weldon						
Number of Flutes		2	4	4	2	4	2
ICC							
Diameter range	Metric	2-12	6-12	3-12	0,2-3,0	1,0-3,0	0,2-3,0
	Inch						
Length availability		1,2,3,4,5,6	2	2	1,2,3,4,5,6	2,3,4	1,2,3,4,5,6
Operation							
SMG							
H3		●	●	●	●	●	●
H5		●	●	●	●	●	●
H7		●	●	●	●	●	●
H8		●	●	●	●	●	●
H11			●	●	●	●	●
H12			●	●	●	●	●
H21		●	●	●	●	●	●
H31		●	●	●	●	●	●

■ Stock standard □ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

JHP170

High performance – Hardened steel – Square – 3-4 Flutes – Cylindrical – Corner radius or chamfer





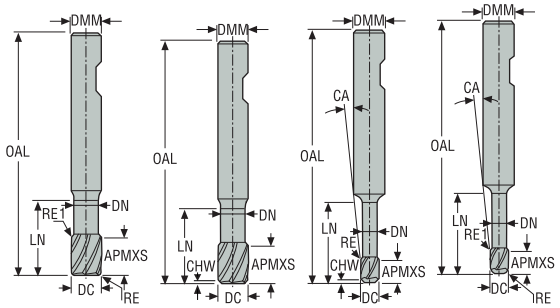
- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2- Ø4=+0,05 mm
- CHW= Ø5-Ø16=+0,1 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

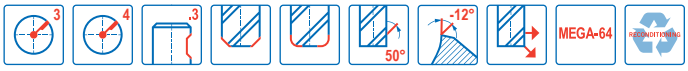
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm			
170020.0-MEGA-64	02462685	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	■
170020R020.0-MEGA-64	02587615	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	14,5	3	■
170020R050.0-MEGA-64	02587617	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	15,0	3	■
170030.0-MEGA-64	02462686	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	■
170030R020.0-MEGA-64	02587618	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	9,5	3	■
170030R050.0-MEGA-64	02587619	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	9,5	3	■
170040.0-MEGA-64	02462687	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	■
170040R020.0-MEGA-64	02587620	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	5,5	4	■
170040R050.0-MEGA-64	02587621	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	5,5	4	■
170050.0-MEGA-64	02462688	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	■
170050R020.0-MEGA-64	02587622	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	2,5	4	■
170050R050.0-MEGA-64	02587623	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	2,5	4	■
170060.0-MEGA-64	02462689	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	■
170060R020.0-MEGA-64	02587624	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	■
170060R050.0-MEGA-64	02587625	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	■
170080.0-MEGA-64	02462690	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	■
170080R020.0-MEGA-64	02587626	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	■
170080R050.0-MEGA-64	02587627	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	■
170080R100.0-MEGA-64	02587628	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	■
170100.0-MEGA-64	02462691	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	■
170100R050.0-MEGA-64	02587629	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	■
170100R100.0-MEGA-64	02587630	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	■
170120.0-MEGA-64	02462692	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	■
170120R050.0-MEGA-64	02587631	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	■
170120R100.0-MEGA-64	02587632	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	■
170160.0-MEGA-64	02462693	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	■
170160R050.0-MEGA-64	02587633	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	■

■ Stocked standard.

JHP170

High performance – Hardened steel – Square – 3-4 Flutes – Weldon – Corner radius or chamfer





- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2-Ø4=+0,05 mm
- CHW= Ø5-Ø16= +0,1 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm			
170020-MEGA-64	02452924	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	■
170020R020.0-MEGA-64W	02669319	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	–	3	□
170020R050.0-MEGA-64W	02669320	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	–	3	□
170030-MEGA-64	02452925	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	■
170030R020.0-MEGA-64W	02669321	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	–	3	□
170030R050.0-MEGA-64W	02669322	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	–	3	□
170040-MEGA-64	02452927	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	■
170040R020.0-MEGA-64W	02669323	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	–	4	□
170040R050.0-MEGA-64W	02669324	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	–	4	□
170050-MEGA-64	02452928	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	■
170050R020.0-MEGA-64W	02669325	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	–	4	□
170050R050.0-MEGA-64W	02669326	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	–	4	□
170060-MEGA-64	02452929	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	■
170060R020.0-MEGA-64W	02669327	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	□
170060R050.0-MEGA-64W	02669328	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	□
170080-MEGA-64	02452930	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	■
170080R020.0-MEGA-64W	02669329	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	□
170080R050.0-MEGA-64W	02669331	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	□
170080R100.0-MEGA-64W	02669332	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	□
170100-MEGA-64	02452931	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	■
170100R050.0-MEGA-64W	02669333	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	□
170100R100.0-MEGA-64W	02669334	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	□
170120-MEGA-64	02452932	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	■
170120R050.0-MEGA-64W	02669335	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	□
170120R100.0-MEGA-64W	02669336	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	□
170160-MEGA-64	02452933	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	■
170160R050.0-MEGA-64W	02669337	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	□
170200R050-MEGA-64	02611637	2	E	20,0	20,0	20,0	100,0	40,0	19,2	–	0,5	–	4	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.

Cutting data – JHP170 Side milling

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
H3	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73 — 110)*
H5	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*
H7	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73 — 110)*
H8	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59 — 71) *215 (200 — 230)*
H11	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (71 — 86) *260 (240 — 280)*
H12	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	75 (69 — 83) *245 (230 — 270)*
H21	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59 — 71) *215 (200 — 230)*
H31	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*

Cutting data – JHP170 Slot milling

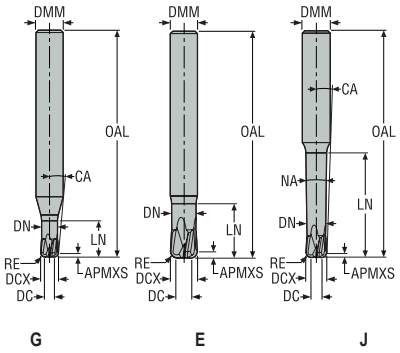
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
H3	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H5	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160 — 180)*
H7	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H8	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160 — 180)*
H11	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	65 (58 — 70) *215 (200 — 220)*
H12	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	60 (53 — 64) *195 (180 — 200)*
H21	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160 — 180)*
H31	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160 — 180)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHF181

High feed – Hardened steel – Square – 3-5 Flutes – Cylindrical – Corner radius – ICC



- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	ICC	DCX	DC	DMM	APMXS	OAL	LN	DN	NA	RE	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm	mm	mm			
JHF181020G1R050.0Z4-HXT	03067297	1	G	–	2,0	1,0	6,0	0,5	50,0	4,0	1,8	0,0	0,5	10,0	4	■
JHF181030G1R075.0Z4-HXT	03067298	1	G	–	3,0	1,5	6,0	0,75	50,0	6,0	2,7	0,0	0,75	7,5	4	■
JHF181040G1R100.0Z4-HXT	03067299	1	G	–	4,0	2,0	6,0	1,0	50,0	8,0	3,6	0,0	1,0	5,0	4	■
JHF181060E1R150.0Z4-HXT	03067300	1	E	–	6,0	3,0	6,0	1,5	50,0	12,0	5,4	0,0	1,5	–	4	■
JHF181080E1R200.0Z4-HXT	03067301	1	E	–	8,0	4,0	8,0	2,0	55,0	16,0	7,3	0,0	2,0	–	4	■
JHF181100E1R200.0Z4-HXT	03067302	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	0,0	2,0	–	4	■
JHF181100E1R200.0Z5-HXT	03067303	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	0,0	2,0	–	5	■
JHF181120E1R300.0Z4-HXT	03067304	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	0,0	3,0	–	4	■
JHF181120E1R300.0Z5-HXT	03067305	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	0,0	3,0	–	5	■
JHF181160E1R300.0Z4-HXT	03067306	1	E	–	16,0	10,0	16,0	3,0	80,0	32,0	14,8	0,0	3,0	–	4	■
JHF181020G2R050.0Z4-HXT	03067307	2	G	–	2,0	1,0	6,0	0,5	50,0	8,0	1,8	0,0	0,5	7,5	4	■
JHF181030G2R075.0Z4-HXT	03067308	2	G	–	3,0	1,5	6,0	0,75	50,0	12,0	2,7	0,0	0,75	5,0	4	■
JHF181040G2R100.0Z4-HXT	03067309	2	G	–	4,0	2,0	6,0	1,0	50,0	16,0	3,6	0,0	1,0	3,0	4	■
JHF181060E2R150.0Z4A-HXT	03067311	2	E	■	6,0	3,0	6,0	1,5	65,0	24,0	5,4	0,0	1,5	–	4	■
JHF181060E2R150.0Z4-HXT	03067310	2	E	–	6,0	3,0	6,0	1,5	65,0	24,0	5,4	0,0	1,5	–	4	■
JHF181080E2R200.0Z4A-HXT	03067313	2	E	■	8,0	4,0	8,0	2,0	70,0	32,0	7,3	0,0	2,0	–	4	■
JHF181080E2R200.0Z4-HXT	03067312	2	E	–	8,0	4,0	8,0	2,0	70,0	32,0	7,3	0,0	2,0	–	4	■
JHF181100E2R200.0Z4A-HXT	03067315	2	E	■	10,0	6,0	10,0	2,0	85,0	40,0	9,2	0,0	2,0	–	4	■
JHF181100E2R200.0Z4-HXT	03067314	2	E	–	10,0	6,0	10,0	2,0	85,0	40,0	9,2	0,0	2,0	–	4	■
JHF181120E2R300.0Z4A-HXT	03067317	2	E	■	12,0	6,0	12,0	3,0	100,0	48,0	11,0	0,0	3,0	–	4	■
JHF181120E2R300.0Z4-HXT	03067316	2	E	–	12,0	6,0	12,0	3,0	100,0	48,0	11,0	0,0	3,0	–	4	■
JHF181020J3R050.0Z4-HXT	03067318	3	J	–	2,0	1,0	6,0	0,5	50,0	10,0	1,8	0,9	0,5	6,8	4	■
JHF181030J3R075.0Z4-HXT	03067319	3	J	–	3,0	1,5	6,0	0,75	50,0	15,0	2,7	0,9	0,75	4,4	4	■
JHF181040J3R100.0Z4-HXT	03067320	3	J	–	4,0	2,0	6,0	1,0	60,0	20,0	3,6	0,9	1,0	2,6	4	■
JHF181060J3R150.0Z4-HXT	03067321	3	J	–	6,0	3,0	8,0	1,5	65,0	30,0	5,4	0,9	1,5	1,9	4	■
JHF181080J3R200.0Z4-HXT	03067325	3	J	–	8,0	4,0	10,0	2,0	85,0	40,0	7,3	0,9	2,0	1,5	4	■
JHF181100J3R200.0Z4-HXT	03067327	3	J	–	10,0	6,0	12,0	2,0	100,0	50,0	9,2	0,9	2,0	1,2	4	■
JHF181020J4R050.0Z3-HXT	03067329	4	J	–	2,0	1,0	6,0	0,5	50,0	14,0	1,8	0,9	0,5	5,6	3	■
JHF181030J4R075.0Z3-HXT	03067330	4	J	–	3,0	1,5	6,0	0,75	60,0	21,0	2,7	0,9	0,75	3,4	3	■
JHF181040J4R100.0Z3-HXT	03067331	4	J	–	4,0	2,0	6,0	1,0	65,0	28,0	3,6	0,9	1,0	2,0	3	■
JHF181060J4R150.0Z3-HXT	03067332	4	J	–	6,0	3,0	8,0	1,5	80,0	42,0	5,4	0,9	1,5	1,4	3	■
JHF181080J4R200.0Z3-HXT	03067333	4	J	–	8,0	4,0	10,0	2,0	100,0	56,0	7,3	0,9	2,0	1,1	3	■
JHF181100J4R200.0Z3-HXT	03067334	4	J	–	10,0	6,0	12,0	2,0	125,0	70,0	9,2	0,9	2,0	0,9	3	■

■ Stocked standard.

Seco

Cutting data – JHF181 Side milling roughing

SMG		a_e/DCX	a_p/DCX	f_z								v_c
				2	3	4	6	8	10	12	16	
P6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	305 (290 — 320) *1000 (960 — 1000)*
P7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	290 (270 — 300) *950 (890 — 980)*
P8	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	270 (260 — 290) *890 (860 — 950)*
P11	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	280 (270 — 290) *920 (890 — 950)*
K1	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 240) *690 (630 — 780)*
K2	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	185 (160 — 200) *610 (530 — 650)*
K3	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	155 (140 — 170) *510 (460 — 550)*
K4	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	150 (130 — 160) *490 (430 — 520)*
K5	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	150 (120 — 170) *490 (400 — 550)*
K6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	220 (180 — 260) *720 (600 — 850)*
K7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	190 (160 — 220) *620 (530 — 720)*
S1	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	60 (40 — 79) *195 (140 — 250)*
S2	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	48 (33 — 64) *155 (110 — 200)*
S3	E	0.18 *0,18*	0.014 *0,014*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	42 (28 — 55) *140 (92 — 180)*
S11	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	200 (180 — 220) *660 (600 — 720)*
S12	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	155 (140 — 170) *510 (460 — 550)*
S13	E	0.18 *0,18*	0.034 *0,034*	0.032 *0,0013*	0.046 *0,0018*	0.065 *0,0026*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.24 *0,0095*	125 (110 — 130) *410 (370 — 420)*
H3	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H5	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H7	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H8	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H11	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 230) *690 (630 — 750)*
H12	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	190 (180 — 210) *620 (600 — 680)*
H21	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H31	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	125 (120 — 130) *410 (400 — 420)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JHF181 Slot milling

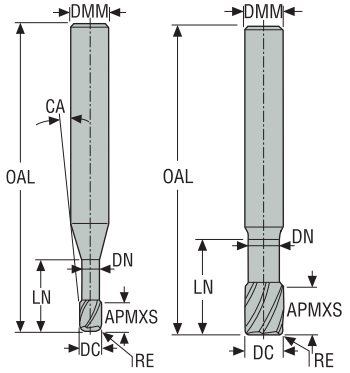
SMG		a_p/DCX	f_z								v_c
			2	3	4	6	8	10	12	16	
P6	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	270 (260 — 280) *890 (860 — 910)*
P7	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	255 (240 — 270) *840 (790 — 880)*
P8	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	240 (230 — 250) *790 (760 — 820)*
P11	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	250 (240 — 260) *820 (790 — 850)*
K1	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 210) *610 (560 — 680)*
K2	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	130 (120 — 140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	130 (110 — 150) *425 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	195 (160 — 230) *640 (530 — 750)*
K7	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	48 (33 — 64) *155 (110 — 200)*
S2	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	39 (26 — 51) *130 (86 — 160)*
S3	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	33 (23 — 44) *110 (76 — 140)*
S11	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	170 (150 — 190) *560 (500 — 620)*
S12	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	130 (120 — 140) *425 (400 — 450)*
S13	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	100 (89 — 110) *330 (300 — 360)*
H3	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H5	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H7	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H8	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H11	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 200) *610 (560 — 650)*
H12	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	170 (160 — 180) *560 (530 — 590)*
H21	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H31	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	110 (98 — 120) *360 (330 — 390)*

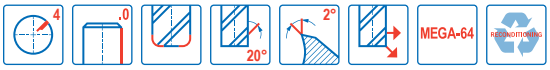
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH120

High speed – Hardened steel – Square – 4 Flutes – Cylindrical – Corner radius





- Tolerances:
- DMM=h5
- DC=-0,02/-0,03 mm
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
120020-MEGA-64	00019437	2	G	2,0	6,0	2,5	50,0	5,0	1,9	0,2	10,5	4	■
120025-MEGA-64	00019448	2	G	2,5	6,0	3,0	50,0	6,0	2,4	0,25	8,5	4	■
120030-MEGA-64	00019450	2	G	3,0	6,0	4,0	50,0	7,0	2,8	0,3	7,0	4	■
120035-MEGA-64	00019460	2	G	3,5	6,0	4,5	50,0	8,0	3,2	0,35	5,5	4	■
120040-MEGA-64	00019462	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,4	4,5	4	■
120050-MEGA-64	00019476	2	G	5,0	6,0	6,0	50,0	12,0	4,6	0,5	2,5	4	■
120060-MEGA-64	00019479	2	E	6,0	6,0	7,0	55,0	14,0	5,6	0,6	–	4	■
120080-MEGA-64	00019481	2	E	8,0	8,0	10,0	60,0	18,0	7,4	0,8	–	4	■
120100-MEGA-64	00019494	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	4	■
120120-MEGA-64	00019501	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,2	–	4	■
120160-MEGA-64	00019503	2	E	16,0	16,0	18,0	90,0	35,0	15,4	1,6	–	4	■

■ Stocked standard.

Cutting data – JH120 Side milling

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57 — 130) *295 (190 — 420)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H7	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57 — 130) *295 (190 — 420)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	275 (230 — 320) *900 (760 — 1000)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	250 (210 — 290) *820 (690 — 950)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	135 (120 — 150) *445 (400 — 490)*

Cutting data – JH120 Slot milling

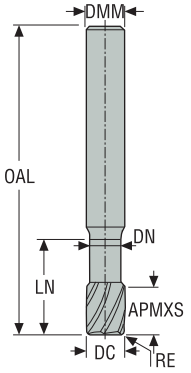
SMG		a_p/DC	f_z											v_c
			2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34 — 78) *180 (120 — 250)*
H5	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	120 (98 — 140) *395 (330 — 450)*
H7	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34 — 78) *180 (120 — 250)*
H8	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110 — 140) *410 (370 — 450)*
H11	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
H12	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	145 (120 — 170) *475 (400 — 550)*
H21	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110 — 140) *410 (370 — 450)*
H31	M	0.18 *0,18*	0.0055 *0,00022*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (70 — 92) *260 (230 — 300)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

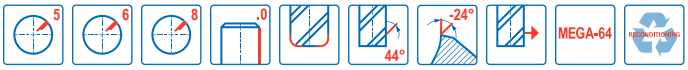
JH130

High speed – Hardened steel – Square – 5-8 Flutes – Cylindrical – Corner radius



E

- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
130060-MEGA-64	00019504	2	E	6,0	6,0	6,0	55,0	12,0	5,6	0,2	5	■
130080-MEGA-64	00019507	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,2	5	■
130100-MEGA-64	00019511	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,3	6	■
130120-MEGA-64	00019512	2	E	12,0	12,0	12,0	80,0	24,0	11,4	0,5	6	■
130160-MEGA-64	00019514	2	E	16,0	16,0	16,0	90,0	30,0	15,4	0,5	8	■
130200-MEGA-64	00019542	2	E	20,0	20,0	20,0	100,0	35,0	19,2	0,5	8	■

■ Stocked standard.

Cutting data – JH130 Side milling finishing

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990 — 1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920 — 1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140 — 170) *510 (460 — 550)*

Cutting data – JH130 Side milling roughing

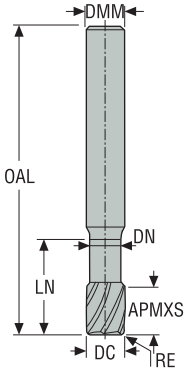
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990 — 1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920 — 1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140 — 170) *510 (460 — 550)*

For cutting data recalculations, see pages 573 - 580

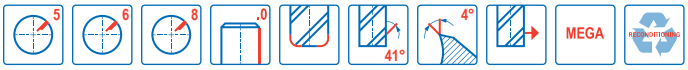
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH930

High speed – Universal – Square – 5-8 Flutes – Cylindrical – Corner radius



E



- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	■

■ Stocked standard.

Cutting data – JH930 Side milling

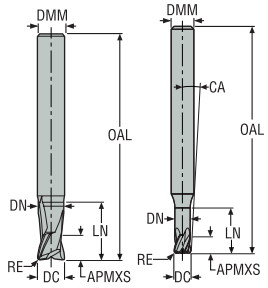
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300 — 1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200 — 1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100 — 1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920 — 1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990 — 1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920 — 1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890 — 1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920 — 1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530 — 720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760 — 1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660 — 1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62 — 100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110 — 160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110 — 140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81 — 110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860 — 1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730 — 1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130 — 180) *510 (430 — 590)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH142

High speed – High precision – Torical – Hardened steel – 2-6 Flutes – Cylindrical – Corner radius



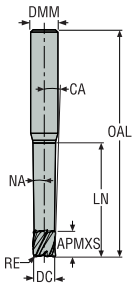
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	■

■ Stocked standard.

JH142

High speed – High precision – Torical – Hardened steel – 2-5 Flutes – Cylindrical – Corner radius



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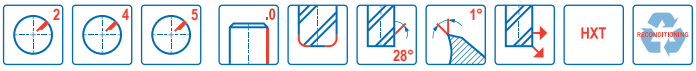


- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	2	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	4	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	2	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	4	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	2	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	4	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	2	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	4	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	2	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	4	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	2	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	4	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	2	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	4	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	4	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	5	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	4	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	5	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	5	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	5	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	5	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	5	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	5	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	5	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	5	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	5	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	5	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	4	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	4	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	4	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	4	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	4	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	4	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	4	■

■ Stocked standard.

Cutting data – JH142 Copy milling roughing

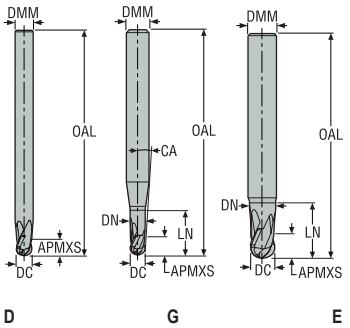
SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600 — 1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500 — 1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300 — 1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200 — 1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300 — 1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200 — 1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100 — 1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200 — 1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960 — 1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600 — 1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400 — 1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960 — 1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200 — 1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100 — 1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120 — 160) *460 (400 — 520)*

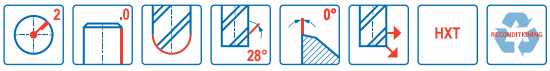
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH112

High speed – High precision – Hardened steel – Ball nose – 2 Flutes – Cylindrical





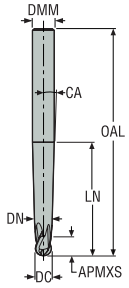
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm			
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	6,45	2	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	3,3	2	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	–	2	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,0	2	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	–	2	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	–	2	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	–	2	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	2,5	2	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	–	2	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	–	2	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	–	2	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	–	2	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	8,12	2	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	7,39	2	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	5,5	2	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	3,81	2	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	3,34	2	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,0	2	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	2,78	2	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	–	2	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	–	2	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	–	2	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	3,82	2	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	2,91	2	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	1,97	2	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	0,53	2	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	–	2	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	–	2	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	–	2	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	–	2	■

■ Stocked standard.

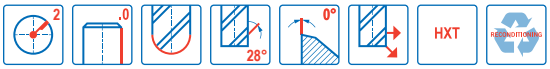
JH112

High speed – High precision – Hardened steel – Ball nose – 2 Flutes – Cylindrical



J

- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= <Ø0,6= 0/-0,008 mm
- DC= ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1.5= ±0.005 mm



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	DN	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm				
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	1,9	3,55	3,3	2	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	2,8	2,5	2,2	2	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	3,7	1,4	1,2	2	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	4,6	1,95	1,6	2	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	5,6	1,4	1,1	2	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	7,4	1,43	1,0	2	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	9,4	1,5	1,0	2	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	5,6	2,3	2,0	2	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	7,4	2,3	1,8	2	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	9,4	1,1	0,8	2	■

■ Stocked standard.

Cutting data – JH112 Copy milling finishing

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500 — 730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200 — 1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200 — 1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560 — 790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990 — 1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920 — 1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960 — 1400)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – JH112 Copy milling roughing

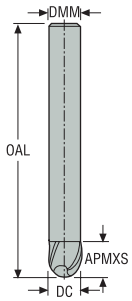
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890 — 1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760 — 1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730 — 1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830 — 1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200 — 1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560 — 780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH150

High speed – Hardened steel – Ball nose – 4 Flutes – Cylindrical



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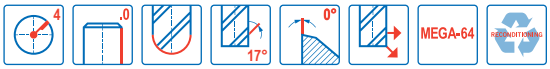


- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Regrind possible

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	4	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	4	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	4	■

■ Stocked standard.

Cutting data – JH150 Copy milling roughing

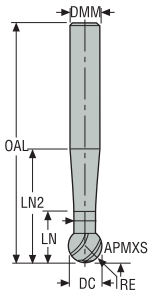
SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100 — 1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890 — 1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890 — 1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300 — 1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200 — 1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630 — 750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130 — 180) *410 (430 — 590)*

For cutting data recalculations, see pages 573 - 580

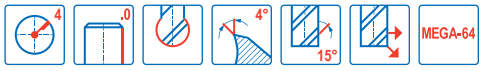
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH160

High speed – Hardened steel – Ball nose – 4 Flutes – Cylindrical



E



- Tolerances:
- DMM= h5
- DC= 0,02/-0,06 mm
- SA=250°

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm		
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	9,0	1,8	1,5	4	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	11,0	2,4	2,0	4	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	13,0	3,0	2,5	4	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	17,3	3,6	3,0	4	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	21,3	4,8	4,0	4	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	27,9	6,0	5,0	4	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	31,8	7,2	6,0	4	■

■ Stocked standard.

Cutting data – JH160 Copy milling finishing

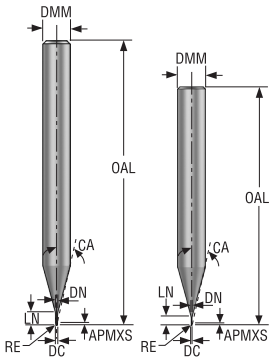
SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450 — 700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300 — 1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200 — 1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200 — 1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200 — 1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100 — 1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400 — 1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200 — 1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JME142

Miniature – Hardened steel – Square – 2 Flutes – Cylindrical – Corner radius



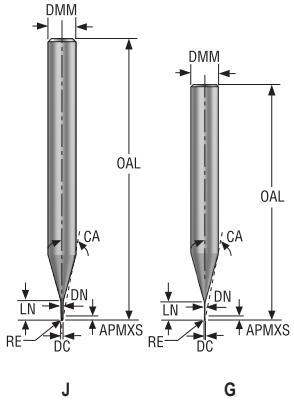
- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm				
JME142002G1R005Z2.0-HXT	03205080	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,05	0,0	15,12	2	■
JME142003G1R005Z2.0-HXT	03205082	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,05	0,0	14,77	2	■
JME142004G1R005Z2.0-HXT	03205084	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,05	0,0	14,39	2	■
JME142005G1R005Z2.0-HXT	03205086	1	G	0,5	4,0	0,375	40,0	0,75	0,46	0,05	0,0	14,01	2	■
JME142006G1R005Z2.0-HXT	03205099	1	G	0,6	4,0	0,45	40,0	0,9	0,56	0,05	0,0	13,67	2	■
JME142008G1R005Z2.0-HXT	03205121	1	G	0,8	6,0	0,6	50,0	1,2	0,76	0,05	0,0	13,98	2	■
JME142010G1R005Z2.0-HXT	03205139	1	G	1,0	6,0	0,75	50,0	1,5	0,95	0,05	0,0	13,49	2	■
JME142012G1R005Z2.0-HXT	03205151	1	G	1,2	6,0	0,9	50,0	1,8	1,15	0,05	0,0	13,02	2	■
JME142015G1R005Z2.0-HXT	03205161	1	G	1,5	6,0	1,125	50,0	2,25	1,45	0,05	0,0	12,3	2	■
JME142002J2R005Z2.0-HXT	03205081	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,05	0,9	14,23	2	■
JME142003J2R005Z2.0-HXT	03205083	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,05	0,9	13,67	2	■
JME142004J2R005Z2.0-HXT	03205085	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,05	0,9	13,1	2	■
JME142005J2R005Z2.0-HXT	03205087	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,05	0,9	12,54	2	■
JME142005J2R010Z2.0-HXT	03205093	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,1	0,9	12,61	2	■
JME142005G2R005Z2.0-HXT	03205088	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,05	0,0	13,5	2	■
JME142005G2R010Z2.0-HXT	03205094	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,1	0,0	13,55	2	■
JME142006J2R005Z2.0-HXT	03205100	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,05	0,9	11,76	2	■
JME142006J2R010Z2.0-HXT	03205107	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,1	0,9	11,83	2	■
JME142006G2R005Z2.0-HXT	03205101	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,05	0,0	9,48	2	■
JME142006G2R010Z2.0-HXT	03205108	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,1	0,0	9,51	2	■
JME142008J2R005Z2.0-HXT	03205122	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,05	0,9	10,92	2	■
JME142008J2R010Z2.0-HXT	03205129	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,1	0,9	10,98	2	■
JME142008J2R020Z2.0-HXT	03205135	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,2	0,9	11,1	2	■
JME142008G2R005Z2.0-HXT	03205123	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,05	0,0	9,15	2	■
JME142008G2R010Z2.0-HXT	03205130	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,1	0,0	9,17	2	■
JME142008G2R020Z2.0-HXT	03205136	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,2	0,0	9,22	2	■
JME142010G2R005Z2.0-HXT	03205140	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,05	0,0	8,29	2	■
JME142010G2R010Z2.0-HXT	03205145	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,1	0,0	8,31	2	■
JME142010G2R020Z2.0-HXT	03205148	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,2	0,0	8,36	2	■
JME142012G2R005Z2.0-HXT	03205152	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,05	0,0	7,97	2	■
JME142012G2R010Z2.0-HXT	03205155	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,1	0,0	7,99	2	■
JME142012G2R020Z2.0-HXT	03205158	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,2	0,0	8,04	2	■
JME142015G2R005Z2.0-HXT	03205162	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,05	0,0	7,6	2	■
JME142015G2R010Z2.0-HXT	03205167	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,1	0,0	9,7	2	■
JME142015G2R020Z2.0-HXT	03205171	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,2	0,0	9,76	2	■

■ Stocked standard.

JME142

Miniature – Hardened steel – Square – 2 Flutes – Cylindrical – Corner radius



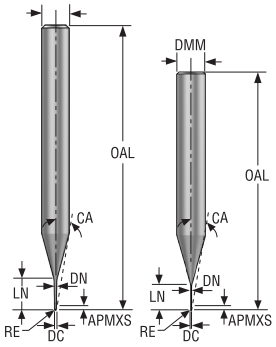
- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm				
JME142020G2R005Z2.0-HXT	03205180	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,05	0,0	8,52	2	■
JME142020G2R010Z2.0-HXT	03205185	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,1	0,0	8,55	2	■
JME142020G2R020Z2.0-HXT	03205188	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,2	0,0	8,6	2	■
JME142020G2R030Z2.0-HXT	03205191	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,3	0,0	8,66	2	■
JME142030G2R005Z2.0-HXT	03205201	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,05	0,0	5,81	2	■
JME142005J3R005Z2.0-HXT	03205089	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,05	0,9	11,24	2	■
JME142005J3R010Z2.0-HXT	03205095	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,1	0,9	11,29	2	■
JME142005G3R005Z2.0-HXT	03205090	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,05	0,0	11,55	2	■
JME142005G3R010Z2.0-HXT	03205096	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,1	0,0	11,59	2	■
JME142006J3R005Z2.0-HXT	03205103	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,05	0,9	10,58	2	■
JME142006J3R010Z2.0-HXT	03205109	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,1	0,9	10,63	2	■
JME142006G3R005Z2.0-HXT	03205104	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,05	0,0	8,46	2	■
JME142006G3R010Z2.0-HXT	03205110	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,1	0,0	8,48	2	■
JME142008J3R005Z2.0-HXT	03205124	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,05	0,9	9,36	2	■
JME142008G3R005Z2.0-HXT	03205126	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,05	0,0	9,89	2	■
JME142010G3R005Z2.0-HXT	03205141	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,05	0,0	8,84	2	■
JME142010G3R010Z2.0-HXT	03205146	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,1	0,0	8,86	2	■
JME142010G3R020Z2.0-HXT	03205149	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,2	0,0	8,91	2	■
JME142015G3R005Z2.0-HXT	03205163	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,05	0,0	7,05	2	■
JME142015G3R010Z2.0-HXT	03205169	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,1	0,0	7,06	2	■
JME142015G3R020Z2.0-HXT	03205172	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,2	0,0	7,1	2	■

■ Stocked standard.

JME142

Miniature – Hardened steel – Square – 2 Flutes – Cylindrical – Corner radius



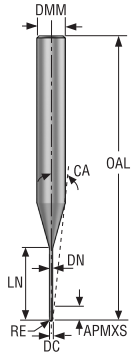
- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm				
JME142020G3R005Z2.0-HXT	03205181	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,05	0,0	5,9	2	■
JME142020G3R010Z2.0-HXT	03205186	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,1	0,0	5,92	2	■
JME142020G3R020Z2.0-HXT	03205189	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,2	0,0	5,95	2	■
JME142030G3R010Z2.0-HXT	03205206	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,1	0,0	4,15	2	■
JME142005J4R010Z2.0-HXT	03205097	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,1	0,9	9,76	2	■
JME142005G4R005Z2.0-HXT	03205092	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,05	0,0	10,42	2	■
JME142005G4R010Z2.0-HXT	03205098	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,1	0,0	10,45	2	■
JME142006J4R005Z2.0-HXT	03205105	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,05	0,9	8,79	2	■
JME142008G4R005Z2.0-HXT	03205128	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,05	0,0	8,49	2	■
JME142010G4R010Z2.0-HXT	03205147	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,1	0,0	7,48	2	■
JME142010G4R020Z2.0-HXT	03205150	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,2	0,0	7,52	2	■
JME142012G4R010Z2.0-HXT	03205157	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,1	0,0	6,62	2	■
JME142012G4R020Z2.0-HXT	03205160	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,2	0,0	6,65	2	■
JME142015G4R010Z2.0-HXT	03205170	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,1	0,0	5,55	2	■
JME142015G4R020Z2.0-HXT	03205173	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,2	0,0	5,58	2	■

■ Stocked standard.

JME142

Miniature – Hardened steel – Square – 2 Flutes – Cylindrical – Corner radius



G

- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JME142020G4R010Z2.0-HXT	03205187	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,1	4,19	2	■
JME142020G4R020Z2.0-HXT	03205190	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,2	4,21	2	■

■ Stocked standard.

Cutting data – JME142 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z													v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1,5	1,8	2	2,5	3	
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	90 (59 — 110) *295 (200 — 360)*
H5	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	90 (59 — 110) *295 (200 — 360)*
H8	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (170 — 240) *670 (560 — 780)*
H12	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
H21	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140 — 190) *520 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (110 — 140) *395 (370 — 450)*

Cutting data – JME142 Slot milling

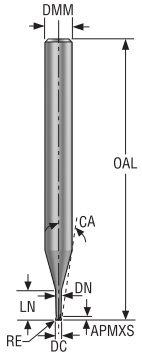
SMG		a_p/DC	f_z													v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	65 (43 — 85) *215 (150 — 270)*
H5	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (97 — 130) *395 (320 — 420)*
H7	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	65 (43 — 85) *215 (150 — 270)*
H8	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (97 — 130) *395 (320 — 420)*
H11	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
H12	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
H21	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (98 — 140) *395 (330 — 450)*
H31	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	90 (73 — 100) *295 (240 — 320)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JME144

Miniature – Hardened steel – Square – 4 Flutes – Cylindrical – Corner radius



J

- Tolerances:
- Run-out= <0,005 mm
- DMM=h5
- DC = 0-0,01 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm				
JME144010J2R005Z4.0-HXT	03205214	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,05	0,9	9,08	4	■
JME144010J2R010Z4.0-HXT	03205217	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,1	0,9	9,13	4	■
JME144010J2R020Z4.0-HXT	03205220	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,2	0,9	9,22	4	■
JME144015J2R005Z4.0-HXT	03205227	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,05	0,9	7,52	4	■
JME144015J2R010Z4.0-HXT	03205229	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,1	0,9	7,56	4	■
JME144015J2R020Z4.0-HXT	03205232	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,2	0,9	7,63	4	■
JME144020J2R005Z4.0-HXT	03205234	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,05	0,9	5,97	4	■
JME144020J2R010Z4.0-HXT	03205236	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,1	0,9	6,0	4	■
JME144020J2R020Z4.0-HXT	03205239	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,2	0,9	6,06	4	■
JME144020J2R030Z4.0-HXT	03205241	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,3	0,9	6,12	4	■
JME144030J2R010Z4.0-HXT	03205243	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,1	0,9	2,66	4	■
JME144030J2R020Z4.0-HXT	03205246	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,2	0,9	2,69	4	■
JME144010J3R010Z4.0-HXT	03205218	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,1	0,9	8,3	4	■
JME144015J3R010Z4.0-HXT	03205230	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,1	0,9	6,06	4	■
JME144020J3R005Z4.0-HXT	03205235	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,05	0,9	4,29	4	■
JME144020J3R010Z4.0-HXT	03205237	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,1	0,9	4,31	4	■

■ Stocked standard.

Cutting data – JME144 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z					v_c
				1.0	1.2	1.5	2.0	3	
H3	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65 — 120) *310 (220 — 390)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65 — 120) *310 (220 — 390)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	210 (180 — 240) *690 (600 — 780)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	190 (160 — 220) *620 (530 — 720)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	125 (110 — 140) *410 (370 — 450)*

Cutting data – JME144 Slot milling

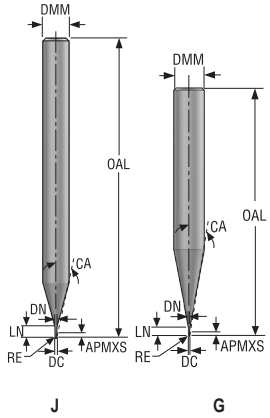
SMG		a_p/DC	f_z					v_c
			1.0	1.2	1.5	2.0	3,0	
H3	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H5	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H7	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H8	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H11	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	150 (130 — 170) *490 (430 — 550)*
H12	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	135 (120 — 160) *445 (400 — 520)*
H21	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H31	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	90 (73 — 100) *295 (240 — 320)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JMB112

Miniature – Hardened steel – Ball nose – 2 Flutes – Cylindrical



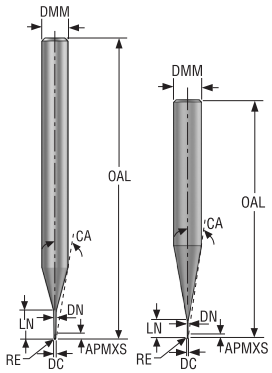
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= <Ø0,6= 0/-0,008 mm
- DC= ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm				
JMB112002G1BZ2.0-HXT	03204964	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,1	0,0	15,11	2	■
JMB112003G1BZ2.0-HXT	03204966	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,15	0,0	14,77	2	■
JMB112004G1BZ2.0-HXT	03204968	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,2	0,0	14,32	2	■
JMB112005G1BZ2.0-HXT	03204970	1	G	0,5	4,0	0,5	40,0	1,0	0,46	0,25	0,0	13,97	2	■
JMB112006G1BZ2.0-HXT	03204977	1	G	0,6	4,0	0,6	40,0	1,2	0,56	0,3	0,0	13,64	2	■
JMB112008G1BZ2.0-HXT	03204984	1	G	0,8	6,0	0,8	50,0	1,6	0,76	0,4	0,0	13,96	2	■
JMB112010G1BZ2.0-HXT	03204991	1	G	1,0	6,0	1,0	50,0	2,0	0,95	0,5	0,0	13,49	2	■
JMB112012G1BZ2.0-HXT	03205000	1	G	1,2	6,0	1,2	50,0	2,4	1,15	0,6	0,0	13,02	2	■
JMB112015G1BZ2.0-HXT	03205009	1	G	1,5	6,0	1,5	50,0	3,0	1,45	0,75	0,0	12,2	2	■
JMB112002J2BZ2.0-HXT	03204965	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,1	0,9	14,33	2	■
JMB112003J2BZ2.0-HXT	03204967	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,15	0,9	13,85	2	■
JMB112004J2BZ2.0-HXT	03204969	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,2	0,9	13,3	2	■
JMB112005J2BZ2.0-HXT	03204971	2	J	0,5	4,0	0,5	40,0	1,5	0,46	0,25	0,9	12,85	2	■
JMB112005G2BZ2.0-HXT	03204972	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	0,0	9,91	2	■
JMB112006J2BZ2.0-HXT	03204978	2	J	0,6	4,0	0,6	50,0	2,0	0,56	0,3	0,9	12,09	2	■
JMB112006G2BZ2.0-HXT	03204979	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	0,0	9,62	2	■
JMB112008J2BZ2.0-HXT	03204985	2	J	0,8	4,0	0,8	50,0	2,5	0,76	0,4	0,9	11,34	2	■
JMB112008G2BZ2.0-HXT	03204986	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	0,0	9,33	2	■
JMB112010J2BZ2.0-HXT	03204992	2	J	1,0	4,0	1,0	40,0	4,0	0,95	0,5	0,9	9,49	2	■
JMB112010G2BZ2.0-HXT	03204993	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	0,0	8,49	2	■
JMB112012J2BZ2.0-HXT	03205001	2	J	1,2	4,0	1,2	50,0	4,5	1,15	0,6	0,9	8,83	2	■
JMB112012G2BZ2.0-HXT	03205002	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	0,0	8,21	2	■
JMB112015J2BZ2.0-HXT	03205010	2	J	1,5	4,0	1,5	50,0	5,0	1,45	0,75	0,9	8,1	2	■
JMB112015G2BZ2.0-HXT	03205011	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	0,0	10,14	2	■
JMB112020J2BZ2.0-HXT	03205024	2	J	2,0	4,0	2,0	50,0	6,0	1,94	1,0	0,9	6,6	2	■
JMB112020G2BZ2.0-HXT	03205025	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	0,0	9,1	2	■
JMB112030J2BZ2.0-HXT	03205037	2	J	3,0	4,0	3,0	50,0	9,0	2,85	1,5	0,9	3,04	2	■
JMB112030G2BZ2.0-HXT	03205038	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	0,0	6,35	2	■

■ Stocked standard.

JMB112

Miniature – Hardened steel – Ball nose – 2 Flutes – Cylindrical



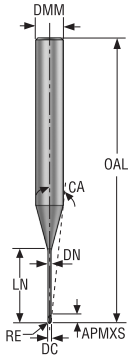
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= <Ø0,6= 0/-0,008 mm
- DC= ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm				
JMB112005J3BZ2.0-HXT	03204973	3	J	0,5	4,0	0,5	40,0	2,5	0,46	0,25	0,9	11,49	2	■
JMB112005G3BZ2.0-HXT	03204974	3	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	0,0	8,81	2	■
JMB112006J3BZ2.0-HXT	03204980	3	J	0,6	4,0	0,6	40,0	3,0	0,56	0,3	0,9	10,83	2	■
JMB112006G3BZ2.0-HXT	03204981	3	G	0,6	6,0	0,6	50,0	4,0	0,56	0,3	0,0	8,56	2	■
JMB112008J3BZ2.0-HXT	03204987	3	J	0,8	4,0	0,8	40,0	4,0	0,76	0,4	0,9	9,67	2	■
JMB112008G3BZ2.0-HXT	03204988	3	G	0,8	6,0	0,8	50,0	5,5	0,76	0,4	0,0	10,1	2	■
JMB112010J3BZ2.0-HXT	03204994	3	J	1,0	4,0	1,0	40,0	5,0	0,95	0,5	0,9	8,6	2	■
JMB112010G3BZ2.0-HXT	03204995	3	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	0,0	9,06	2	■
JMB112012J3BZ2.0-HXT	03205003	3	J	1,2	4,0	1,2	50,0	6,0	1,15	0,6	0,9	7,65	2	■
JMB112012G3BZ2.0-HXT	03205004	3	G	1,2	6,0	1,2	50,0	8,0	1,15	0,6	0,0	8,42	2	■
JMB112015J3BZ2.0-HXT	03205012	3	J	1,5	4,0	1,5	40,0	7,5	1,45	0,75	0,9	6,4	2	■
JMB112015G3BZ2.0-HXT	03205013	3	G	1,5	6,0	1,5	50,0	10,0	1,45	0,75	0,0	7,31	2	■
JMB112020J3BZ2.0-HXT	03205026	3	J	2,0	4,0	2,0	50,0	10,0	1,94	1,0	0,9	4,61	2	■
JMB112020G3BZ2.0-HXT	03205027	3	G	2,0	6,0	2,0	50,0	12,0	1,94	1,0	0,0	6,19	2	■
JMB112030J3BZ2.0-HXT	03205039	3	J	3,0	4,0	3,0	50,0	15,0	2,85	1,5	0,9	1,91	2	■
JMB112030G3BZ2.0-HXT	03205040	3	G	3,0	6,0	3,0	60,0	15,0	2,85	1,5	0,0	4,41	2	■

■ Stocked standard.

JMB112

Miniature – Hardened steel – Ball nose – 2 Flutes – Cylindrical



G

- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= <Ø0,6= 0/-0,008 mm
- DC= ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm				
JMB112006G4BZ2.0-HXT	03204983	4	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	0,0	9,86	2	■
JMB112008G4BZ2.0-HXT	03204990	4	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	0,0	8,65	2	■
JMB112010G4BZ2.0-HXT	03204998	4	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	0,0	7,63	2	■
JMB112015G4BZ2.0-HXT	03205015	4	G	1,5	6,0	1,5	70,0	15,0	1,45	0,75	0,0	5,7	2	■
JMB112020G4BZ2.0-HXT	03205029	4	G	2,0	6,0	2,0	60,0	18,0	1,94	1,0	0,0	4,68	2	■
JMB112030G4BZ2.0-HXT	03205042	4	G	3,0	6,0	3,0	80,0	30,0	2,85	1,5	0,0	2,51	2	■
JMB112010G6BZ2.0-HXT	03205054	6	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	0,0	4,99	2	■

■ Stocked standard.

Cutting data – JMB112 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z													v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.026	0.032	0.036	0.044	0.048	150 (130 — 170)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0010*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*490 (430 — 550)*
H5	M	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	220 (200 — 240)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*720 (660 — 780)*
H7	M	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.026	0.032	0.036	0.044	0.048	150 (130 — 170)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0010*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*490 (430 — 550)*
H8	M	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.048	0.050	220 (200 — 240)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0019*	*0,0020*	*720 (660 — 780)*
H11	M	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	280 (250 — 310)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*920 (830 — 1000)*
H12	M	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.048	0.050	255 (230 — 280)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0019*	*0,0020*	*840 (760 — 910)*
H21	M	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.048	0.050	220 (200 — 240)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0019*	*0,0020*	*720 (660 — 780)*
H31	M	0.0500	0.44	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.034	0.036	0.042	0.044	165 (150 — 180)
		0,0500	*0,44*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0017*	*540 (500 — 590)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

PLASTIC AND CFRP

Seco presents a complete solid carbide end mill product range for the machining of glass and carbon fiber reinforced plastics. It consists of diamond-coated and uncoated solid carbide and PCD end mills incorporating different geometries as well as with PCD-brazed cutting edges. This is a product range offering optimized tools for difficult cutting conditions on challenging workpiece materials.

- JC860, JC870, JC871, JC899, JPD890, J93F and J28 for sharp corner type.
- JC845, JC880, JC885 and JC898 for radius type.
- JC875, JC876, JC877 and JPD880 with 45° chamfer type.
- JC850 and JPD850 for ball-nose type.

Tool Selection Plastic and CFRP

Name		JC845	JC850	JC860	JC870	JC871
Page(s)		420	422	424	426	432
Family name		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Type of mill		r		90°	90°	90°
Shank	Cylindrical	■	■	■	■	■
	Weldon					
Number of Flutes		3	4	5,6,8,9		
ICC						
Diameter range	Metric	6-8	3-12	6-12	3-12	3-12
	Inch				1/4 -1/2	1/4 -1/2
Length availability		2	2	2	2	2
Operation						
SMG						
TS1						
TS2		●	●	●	●	●
TS3		●	●	●	●	●
TP1						
TP2		●	●	●	●	●
TP3		●	●	●	●	●
Honeycomb*				●	●	●

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

Tool Selection Plastic and CFRP

Name		JC875	JC876	JC877	JC880	JC885	JC898	JC899
Page(s)		438	442	446	450	452	454	456
Family name		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Type of mill		45°	45°	45°	r	r	r	90°
Shank	Cylindrical	■	■	■	■	■	■	■
	Weldon							
Number of Flutes		5,6,10	6,8,10,12,14	6,8,10,12,14	4	4	4	4
ICC							■	
Diameter range	Metric	3-10	3-12	3-12	4-20	4-10	8-15	8,5-14,8
	Inch	1/4	1/4-3/8	1/4				3/8
Length availability		2	2	2	2	2	2	2
Operation								
SMG								
TS1								
TS2		●	●	●	●	●		
TS3		●	●	●	●	●		
TP1								
TP2		●	●	●	●	●		
TP3		●	●	●	●	●		
Honeycomb*								

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

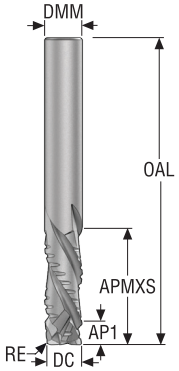
Tool Selection Plastic and CFRP

Name		JPD850	JPD880	JPD890	J93F	J28
Page(s)		459	461	463	465	467
Family name		PCD	PCD	PCD	VHM	VHM
Type of mill			45°	90°	90°	90°
Shank	Cylindrical	■	■	■	■	■
	Weldon					
Number of Flutes		2	2	2	2	1
ICC		■	■	■		
Diameter range	Metric	4-10	6-16	6-12	1,5-20	3-12
	Inch					
Length availability		2	2,3	2,3	1,2,3,4	2
Operation						
SMG						
TS1					●	●
TS2		●	●	●		
TS3		●	●	●		
TP1					●	
TP2		●	●	●		
TP3		●	●	●		
Honeycomb*						

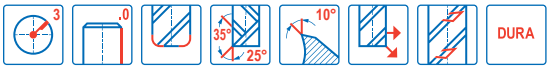
■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

JC845

Composite – Compression – 3 Flutes – Cylindrical – Corner radius



- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	AP1	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm		
JC845060D2R050.0Z3-DURA	02843006	2	D	6,0	6,0	18,0	4,2	65,0	0,5	3	■
JC845080D2R050.0Z3-DURA	02843007	2	D	8,0	8,0	24,0	5,2	75,0	0,5	3	■
JC845100D2R050.0Z3-DURA	02843008	2	D	10,0	10,0	30,0	6,3	85,0	0,5	3	■
JC845120D2R050.0Z5-DURA	02843009	2	D	12,0	12,0	36,0	8,3	100,0	0,5	5	■

■ Stocked standard.

Cutting data – JC845 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	185 (130 — 240) *610 (430 — 780)*
TS3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87 — 160) *410 (290 — 520)*
TP2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87 — 180) *410 (290 — 590)*
TP3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	85 (62 — 110) *280 (210 — 360)*

Cutting data – JC845 Slot milling

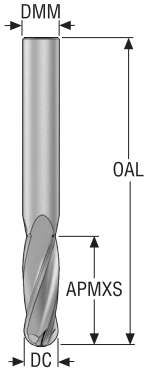
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	160 (110 — 210) *520 (370 — 680)*
TS3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (76 — 130) *345 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (75 — 160) *345 (250 — 520)*
TP3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (54 — 96) *245 (180 — 310)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JC850

Composite – Ball nose – 4 Flutes – Cylindrical



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
850030Z4.0-DURA	02719949	2	D	3,0	3,0	9,0	50,0	4	■
850040Z4.0-DURA	02719952	2	D	4,0	4,0	12,0	50,0	4	■
850060Z4.0-DURA	02719953	2	D	6,0	6,0	18,0	65,0	4	■
850080Z4.0-DURA	02719954	2	D	8,0	8,0	24,0	70,0	4	■
850100Z4.0-DURA	02719955	2	D	10,0	10,0	30,0	85,0	4	■
850120Z4.0-DURA	02719956	2	D	12,0	12,0	36,0	100,0	4	■

■ Stocked standard.

Cutting data – JC850 Copy milling

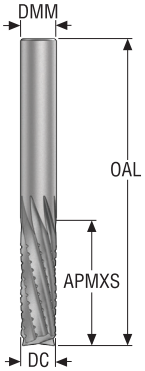
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	265 (220 — 320) *870 (730 — 1000)*
TS3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	160 (110 — 210) *520 (370 — 680)*
TP2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	215 (110 — 320) *710 (370 — 1000)*
TP3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	105 (54 — 150) *345 (180 — 490)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JC860

Honeycomb – Square – 5-9 Flutes – Cylindrical – Sharp



D

- Tolerances:
- DMM=h5
- DC= -0.02-0.08 mm
- FCEDC=frontal teeth

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Cylindrical
				mm	mm	mm	mm			
860060Z5.0-DURA	02720211	2	D	6,0	6,0	18,0	70,0	2	5	■
860080Z6.0-DURA	02720212	2	D	8,0	8,0	24,0	80,0	2	6	■
860100Z8.0-DURA	02720216	2	D	10,0	10,0	30,0	90,0	2	8	■
860120Z9.0-DURA	02720217	2	D	12,0	12,0	36,0	110,0	2	9	■

■ Stocked standard.

Cutting data – JC860 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	235 (200 — 270) *770 (660 — 880)*
TS3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	160 (130 — 180) *520 (430 — 590)*
TP2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	165 (130 — 200) *540 (430 — 650)*
TP3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	65 (50 — 110) *215 (170 — 360)*

Cutting data – JC860 Slot milling

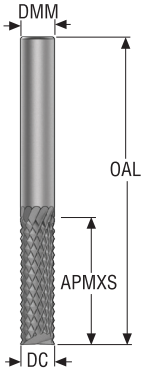
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (85 — 120) *345 (280 — 390)*
TP2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	110 (84 — 130) *360 (280 — 420)*
TP3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	44 (34 — 78) *145 (120 — 250)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JC870

Composite – Router – Square – Cylindrical – Sharp



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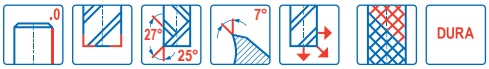


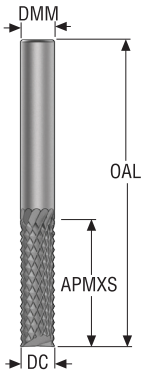
- Tolerances:
- DMM=h5
- DC=-0,02/-0,08 mm
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Cylindrical
				mm	mm	mm	mm			
870030.0-DURA	02720219	2	D	3,0	3,0	9,0	50,0	2	8	■
870040.0-DURA	02720226	2	D	4,0	4,0	12,0	50,0	2	8	■
870060.0-DURA	02720228	2	D	6,0	6,0	18,0	65,0	2	10	■
870080.0-DURA	02720229	2	D	8,0	8,0	24,0	75,0	2	12	■
870100.0-DURA	02720231	2	D	10,0	10,0	30,0	85,0	2	12	■
870120.0-DURA	02720232	2	D	12,0	12,0	36,0	100,0	2	14	■

■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC870

Composite – Router – Square – Cylindrical – Sharp – *Inch*



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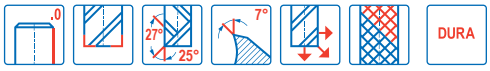


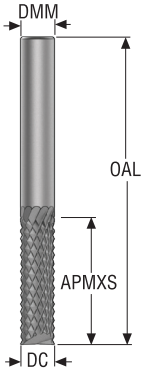
- Tolerances:
- DMM= h5
- DC= -.0008/-.0030 *Inch*
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	Cylindrical
				inch	inch	inch	inch		
8700250.0-DURA	02720784	2	D	0.250	0.250	0.750	2.250	2	■
8700375.0-DURA	02720785	2	D	0.375	0.375	1.250	3.500	2	■

■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

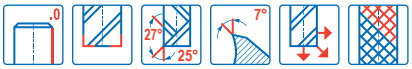
JC870

Composite – Router – Square – Cylindrical – Sharp



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,08 mm
- Router (downcut)*

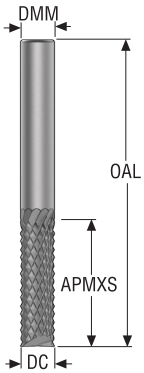


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Cylindrical
				mm	mm	mm	mm			
870030.0	02742789	2	D	3,0	3,0	9,0	50,0	2	8	■
870040.0	02742792	2	D	4,0	4,0	12,0	50,0	2	8	■
870050.0	02742793	2	D	5,0	5,0	15,0	50,0	2	10	■
870060.0	02742794	2	D	6,0	6,0	18,0	65,0	2	10	■
870080.0	02742795	2	D	8,0	8,0	24,0	75,0	2	12	■
870100.0	02742796	2	D	10,0	10,0	30,0	85,0	2	12	■
870120.0	02742797	2	D	12,0	12,0	36,0	100,0	2	14	■

■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC870

Composite – Router – Square – Cylindrical – Sharp – *Inch*



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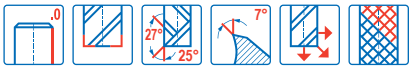


- Tolerances:
- DMM= h5
- DC= -.0008/-.0030 *Inch*
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Cylindrical
				inch	inch	inch	inch			
8700250.0	02742798	2	D	0.250	0.250	0.750	2.250	2	10	■
8700500.0	02742800	2	D	0.500	0.500	1.500	4.250	2	14	■

■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

Cutting data – JC870 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Cutting data – JC870 Slot milling

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	39 (30 — 68) *130 (99 — 220)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JC870 Side milling roughing – *Inch*

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Cutting data – JC870 Slot milling – *Inch*

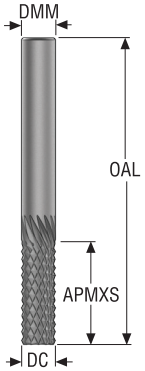
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JC871

Composite – Router – Square – Cylindrical – Sharp



D

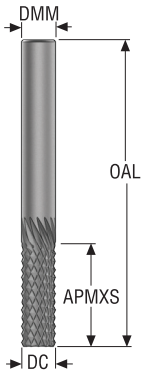
- Tolerances:
- DMM= h5
- DC= -0,02/-0,08 mm
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
871030.0-DURA	02720249	2	D	3,0	3,0	9,0	50,0	8	■
871040.0-DURA	02720250	2	D	4,0	4,0	12,0	50,0	8	■
871060.0-DURA	02720252	2	D	6,0	6,0	18,0	65,0	10	■
871080.0-DURA	02720253	2	D	8,0	8,0	24,0	75,0	12	■
871100.0-DURA	02720254	2	D	10,0	10,0	30,0	85,0	12	■
871120.0-DURA	02720257	2	D	12,0	12,0	36,0	100,0	14	■

■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC871

Composite – Router – Square – Cylindrical – Sharp – *Inch*



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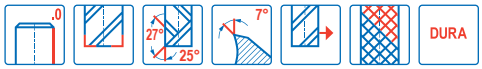


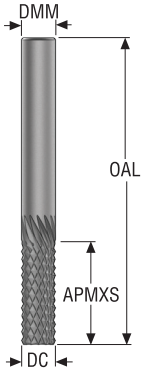
- Tolerances:
- DMM= h5
- DC= -.0008/-.0030 *Inch*
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				inch	inch	inch	inch		
8710250.0-DURA	02720788	2	D	0.250	0.250	0.750	2.250	10	■
8710375.0-DURA	02720789	2	D	0.375	0.375	1.250	3.500	12	■
8710500.0-DURA	02720790	2	D	0.500	0.500	1.500	4.250	14	■

■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC871

Composite – Router – Square – Cylindrical – Sharp



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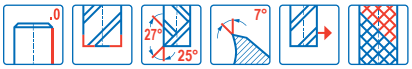


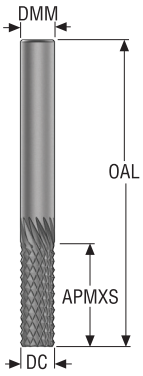
- Tolerances:
- DMM= h5
- DC= -0,02/-0,08 mm
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
871030.0	02742801	2	D	3,0	3,0	9,0	50,0	8	■
871040.0	02742803	2	D	4,0	4,0	12,0	50,0	8	■
871060.0	02742806	2	D	6,0	6,0	18,0	65,0	10	■
871080.0	02742807	2	D	8,0	8,0	24,0	75,0	12	■
871100.0	02742808	2	D	10,0	10,0	30,0	85,0	12	■
871120.0	02742809	2	D	12,0	12,0	36,0	100,0	14	■

■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC871

Composite – Router – Square – Cylindrical – Sharp – *Inch*



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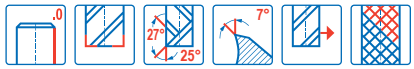


- Tolerances:
- DMM=h5
- DC= -.0008/-.0030 *Inch*
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				inch	inch	inch	inch		
8710500.0	02742814	2	D	0.500	0.500	1.500	4.250	14	■

■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

Cutting data – JC871 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Cutting data – JC871 Slot milling

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	155 (140 — 180) *510 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (84 — 120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (79 — 130) *345 (260 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	40 (31 — 70) *130 (110 — 220)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JC871 Side milling roughing – *Inch*

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Cutting data – JC871 Slot milling – *Inch*

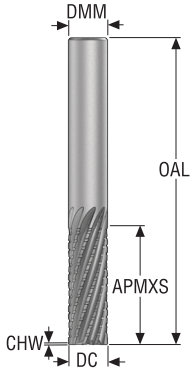
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

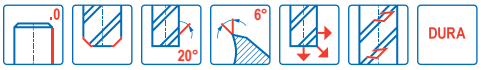
JC875

Composite – Square – 5-10 Flutes – Cylindrical – Chamfer



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,08 mm

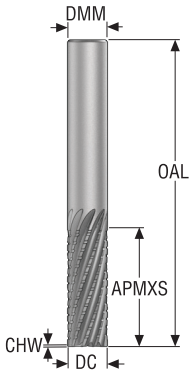


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JC875030D2.0-DURA	02968155	2	D	3,0	3,0	9,0	50,0	0,05	5	■
JC875050D2.0-DURA	02968157	2	D	5,0	5,0	15,0	50,0	0,05	6	■
JC875060D2.0-DURA	02968158	2	D	6,0	6,0	18,0	65,0	0,06	6	■
JC875080D2.0-DURA	02968159	2	D	8,0	8,0	24,0	70,0	0,08	10	■
JC875100D2.0-DURA	02968160	2	D	10,0	10,0	30,0	80,0	0,1	10	■

■ Stocked standard.

JC875

Composite – Square – 6-10 Flutes – Cylindrical – Chamfer – *Inch*



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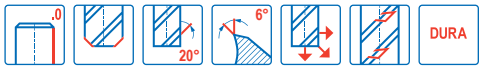


- Tolerances:
- DMM=h5
- DC= -.0008/-.0030 *Inch*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				inch	inch	inch	inch	inch		
JC875.250D2.0-DURA	02968162	2	D	0.250	0.250	0.750	3.000	0.002	6	■

■ Stocked standard.

Cutting data – JC875 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	5	6	8	10	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	190 (160 — 220) *620 (530 — 720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (96 — 150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	50 (39 — 89) *165 (130 — 290)*

Cutting data – JC875 Slot milling

SMG		a_p/DC	f_z					v_c
			3	5	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (86 — 120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (81 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	42 (33 — 74) *140 (110 — 240)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JC875 Side milling – *Inch*

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	190 (160 — 220) *620 (530 — 720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (96 — 150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	50 (39 — 89) *165 (130 — 290)*

Cutting data – JC875 Slot milling – *Inch*

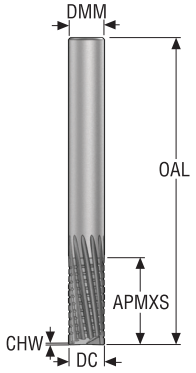
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (86 — 120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (81 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	42 (33 — 74) *140 (110 — 240)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

JC876

Composite – Square – 6-14 Flutes – Cylindrical – Chamfer



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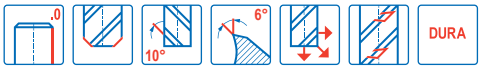


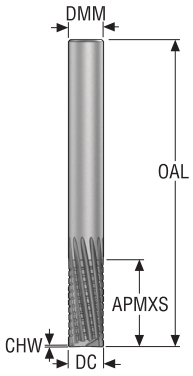
- Tolerances:
- DMM=h5
- DC=-0,02 -0,08 mm
- Left hand helix

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JC876030D2C.0Z6-DURA	03135004	2	D	3,0	3,0	7,5	50,0	0,035	6	■
JC876040D2C.0Z6-DURA	03135005	2	D	4,0	4,0	10,0	54,0	0,045	6	■
JC876060D2C.0Z8-DURA	03135006	2	D	6,0	6,0	15,0	62,0	0,075	8	■
JC876060D2C.0Z10-DURA	03135007	2	D	6,0	6,0	15,0	62,0	0,075	10	■
JC876080D2C.0Z10-DURA	03135009	2	D	8,0	8,0	20,0	70,0	0,1	10	■
JC876100D2C.0Z12-DURA	03135011	2	D	10,0	10,0	25,0	82,0	0,125	12	■
JC876120D2C.0Z14-DURA	03135012	2	D	12,0	12,0	30,0	95,0	0,15	14	■

■ Stocked standard.

JC876

Composite – Square – 8-14 Flutes – Cylindrical – Chamfer – *Inch*



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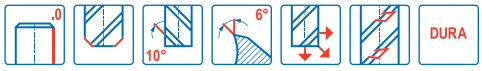


- Tolerances:
- DMM=h5
- DC= -.0008/-.0030 *Inch*
- Left hand helix

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				inch	inch	inch	inch	inch		
JC876.250D2C.0Z8-DURA	03135125	2	D	0.250	0.250	0.625	2.500	0.003	8	■
JC876.375D2C.0Z12-DURA	03135127	2	D	0.375	0.375	1.000	3.000	0.005	12	■

■ Stocked standard.

Cutting data – JC876 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (120 — 170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (110 — 180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	75 (44 — 100) *245 (150 — 320)*

Cutting data – JC876 Slot milling

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (94 — 140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	60 (36 — 81) *195 (120 — 260)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JC876 Side milling roughing – *Inch*

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (120 — 170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (110 — 180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	75 (44 — 100) *245 (150 — 320)*

Cutting data – JC876 Slot milling – *Inch*

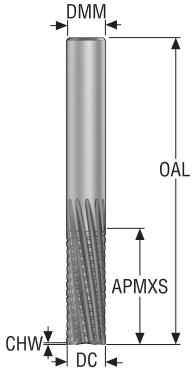
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (94 — 140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	60 (36 — 81) *195 (120 — 260)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

JC877

Composite – Square – 6-14 Flutes – Cylindrical – Chamfer



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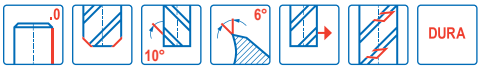


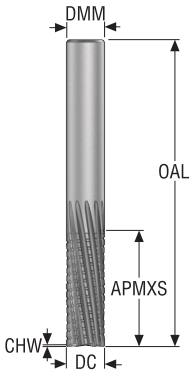
- Tolerances:
- DMM=h5
- DC=-0,02, -0,08 mm
- Left hand helix

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JC877030D2C.0Z6-DURA	03135013	2	D	3,0	3,0	9,0	50,0	0,035	6	■
JC877040D2C.0Z6-DURA	03135014	2	D	4,0	4,0	12,0	54,0	0,045	6	■
JC877060D2C.0Z8-DURA	03135015	2	D	6,0	6,0	18,0	62,0	0,075	8	■
JC877060D2C.0Z10-DURA	03135016	2	D	6,0	6,0	18,0	62,0	0,075	10	■
JC877080D2C.0Z10-DURA	03135018	2	D	8,0	8,0	24,0	70,0	0,1	10	■
JC877100D2C.0Z12-DURA	03135020	2	D	10,0	10,0	30,0	82,0	0,125	12	■
JC877120D2C.0Z14-DURA	03135021	2	D	12,0	12,0	36,0	95,0	0,15	14	■

■ Stocked standard.

JC877

Composite – Square – 8-14 Flutes – Cylindrical – Chamfer – *Inch*



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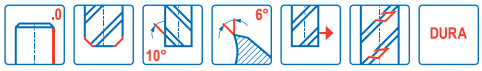


- Tolerances:
- DMM=h5
- DC= -.0008/-.0030 *Inch*
- Left hand helix

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				inch	inch	inch	inch	inch		
JC877.250D2C.0Z8-DURA	03135129	2	D	0.250	0.250	0.750	2.500	0.003	8	■

■ Stocked standard.

Cutting data – JC877 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	195 (170 — 220) *640 (560 — 720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (98 — 160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (40 — 91) *215 (140 — 290)*

Cutting data – JC877 Slot milling

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	170 (150 — 200) *115 (92 — 130)*
TP2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	115 (86 — 140) *55 (35 — 80)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – JC877 Side milling roughing – *Inch*

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	195 (170 — 220) *640 (560 — 720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (98 — 160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	65 (40 — 91) *215 (140 — 290)*

Cutting data – JC877 Slot milling – *Inch*

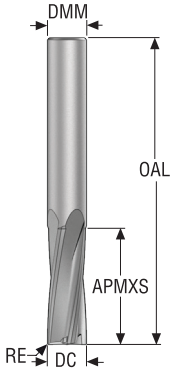
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (85 — 120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (80 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	55 (32 — 74) *180 (110 — 240)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

JC880

Composite – Square – 4 Flutes – Cylindrical – Corner radius



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
880040R020Z4.0-DURA	02843012	2	D	4,0	4,0	12,0	50,0	0,2	4	■
880050R020Z4.0-DURA	02843013	2	D	5,0	5,0	15,0	50,0	0,2	4	■
880060R020Z4.0-DURA	02720258	2	D	6,0	6,0	18,0	65,0	0,2	4	■
880080R020Z4.0-DURA	02720259	2	D	8,0	8,0	24,0	70,0	0,2	4	■
880100R020Z4.0-DURA	02720260	2	D	10,0	10,0	30,0	80,0	0,2	4	■
880120R020Z4.0-DURA	02720261	2	D	12,0	12,0	36,0	100,0	0,2	4	■
880160R020Z4.0-DURA	02720262	2	D	16,0	16,0	48,0	110,0	0,2	4	■
880200R020Z4.0-DURA	02720263	2	D	20,0	20,0	60,0	130,0	0,2	4	■

■ Stocked standard.

Cutting data – JC880 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z							v_c
				4	6	8	10	12	16	20	
TS2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	130 (93 — 170) *425 (310 — 550)*
TP2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	125 (95 — 150) *410 (320 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (40 — 92) *165 (140 — 300)*

Cutting data – JC880 Slot milling

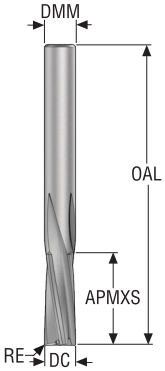
SMG		a_p/DC	f_z								v_c
			4	5	6	8	10	12	16	20	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	100 (71 — 130) *330 (240 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (76 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	40 (31 — 70) *130 (110 — 220)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JC885

Composite – Square – 4 Flutes – Cylindrical – Corner radius



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm
- Left hand helix

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JC885040D2R020.0Z4-DURA	02843014	2	D	4,0	4,0	12,0	50,0	0,2	4	■
JC885060D2R020.0Z4-DURA	02843016	2	D	6,0	6,0	18,0	70,0	0,2	4	■
JC885080D2R020.0Z4-DURA	02843017	2	D	8,0	8,0	24,0	80,0	0,2	4	■

■ Stocked standard.

Cutting data – JC885 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z				v_c
				4	6	8	10	
TS2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	130 (99 — 170) *425 (330 — 550)*
TP2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	125 (94 — 150) *410 (310 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (33 — 92) *165 (110 — 300)*

Cutting data – JC885 Slot milling

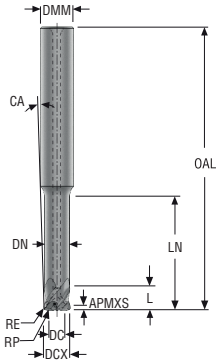
SMG		a_p/DC	f_z				v_c
			4	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
TS3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	100 (76 — 130) *330 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	100 (75 — 120) *330 (250 — 390)*
TP3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	40 (26 — 70) *130 (86 — 220)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

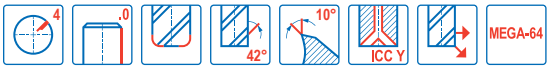
JC898

High feed – Stacked materials – Corner radius – 4 Flutes – Cylindrical – Corner radius



G

- Tolerances:
- DMM=h5
- DC= e7
- RE= ±0,1 mm



Designation	Item number	Length index	Tool shape	ICC	DC	DCX	DMM	APMXS	L	OAL	LN	DN	RE	RP	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm	mm	mm	mm			
JC898080G3HZ4A.0-M64	03245308	3	G	■	4,0	8,0	10,0	0,43	6,0	88,0	35,0	7,6	0,5	0,87	1,5 °	4	■
JC898150G3HZ4A.0-M64	03245309	3	G	■	7,5	15,0	16,0	0,796	12,0	125,0	70,0	14,3	0,94	1,63	0,4 °	4	■

■ Stocked standard.

Cutting data – JC898 Side milling

SMG		a_e/DCX	a_p/DCX	f_z		v_c
				8	15	
S12+TS2/TP2	D	0,30 *0,30*	0,020 *0,020*	0,1 *0,0040*	0,15 *0,0060*	90 (80-120) *300 (270-400)*
TP2+TS2/TP2	D	0,30 *0,30*	0,034 *0,034*	0,12 *0,0048*	0,25 *0,0100*	120 (90-150) *400 (300-490)*

Cutting data – JC898 Slot milling

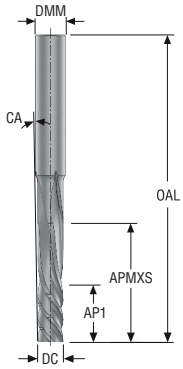
SMG		a_p/DCX	f_z		v_c
			8	15	
S12+TP2/TS2	D	0.020 *0.020*	0.08 *0,0032*	0.10 *0,0040*	90 (80-120) *300 (270-400)*
N1+TP2/TS2	D	0.034 *0.034*	0.1 *0,0040*	0.10 *0,0040*	120 (90-150) *400 (300-490)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

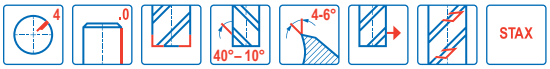
JC899

High performance – Stacked materials – Square – 4 Flutes – Cylindrical – Sharp



F

- Tolerances:
- DMM=h5
- DC= ±0,02 mm

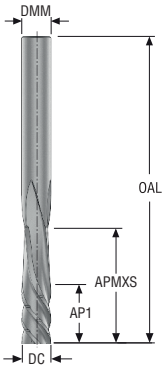


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	AP1	OAL	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm			
JC899085F3S.0Z4-STAX	03245482	3	F	■	8,5	10,0	38,0	19,0	100,0	0,8 °	4	■
JC899148F3S.0Z4-STAX	03245480	3	F	■	14,8	16,0	55,0	30,0	150,0	0,53 °	4	■
JC899148F4S.0Z4-STAX	03245481	4	F	■	14,8	16,0	62,0	37,0	150,0	0,48 °	4	■

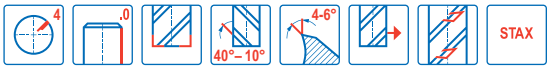
■ Stocked standard.

JC899

High performance – Stacked materials – Square – 4 Flutes – Cylindrical – Sharp – *Inch*



D



- Tolerances:
- DMM=h5
- DC= ±0,0008 *Inch*

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	AP1	OAL	PCEDC	Cylindrical
					inch	inch	inch	inch	inch		
JC8990375D4S.0Z4-STAX	03245483	4	D	■	0.373	0.375	1.500	0.625	4.000	4	■

■ Stocked standard.

Cutting data – JC899 Finishing

SMG		a_e/DC	a_p/DC	f_z		v_c
				8.5	14.8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,04 *0,0016*	0,075 *0,0030*	40 (30 — 50) *140 (100 — 170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,06 *0,0032*	0,09 *0,0036*	60 (50 — 75) *200 (170 — 250)*

Cutting data – JC899 Finishing – *Inch*

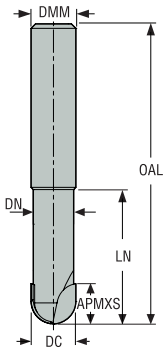
SMG		a_e/DC	a_p/DC	f_z	v_c
				3/8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,05 *0,0022*	40 (30 — 50) *140 (100 — 170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,07 *0,0028*	60 (50 — 75) *200 (170 — 250)*

For cutting data recalculations, see pages 573 - 580

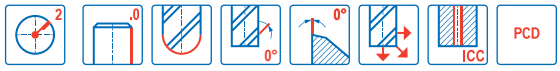
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JPD850

Composite – Ball nose – 2 Flutes – Cylindrical – ICC



E



- Tolerances:
- DMM=h5
- DC= h10
- ICC= 2 straight channels

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm		
JPD850060E2B.0Z2A	02968184	2	E	■	6,0	6,0	7,0	58,0	18,0	5,4	2	■
JPD850080E2B.0Z2A	02968185	2	E	■	8,0	8,0	8,0	64,0	24,0	7,2	2	■
JPD850100E2B.0Z2A	02968186	2	E	■	10,0	10,0	10,0	73,0	30,0	9,0	2	■

■ Stocked standard.

Cutting data – JPD850 Copy milling

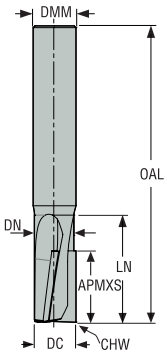
SMG		a_e/DC	a_p/DC	f_z					v_c
				4	5	6	8	10	
TS2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	550 (470 — 820) *1800 (1600 — 2600)*
TS3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	310 (270 — 460) *1025 (890 — 1500)*
TP2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	890 (750 — 1300) *2925 (2500 — 4200)*
TP3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	580 (500 — 870) *1900 (1700 — 2800)*

For cutting data recalculations, see pages 573 - 580

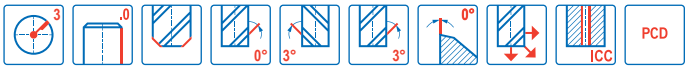
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JPD880

Composite – Square – 3 Flutes – Cylindrical – Chamfer – ICC



E



- Tolerances:
- DMM=h5
- DC=h10
- ICC=Y

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JPD880060G2C.0Z3A	02968190	2	G	■	6,0	8,0	13,0	64,0	20,0	5,3	0,1	3	■
JPD880080E2C.0Z3A	02968191	2	E	■	8,0	8,0	15,0	64,0	20,0	7,3	0,1	3	■
JPD880100E2C.0Z3A	02968192	2	E	■	10,0	10,0	13,0	73,0	30,0	9,2	0,1	3	■
JPD880120E2C.0Z3A	02968194	2	E	■	12,0	12,0	13,0	83,0	30,0	11,0	0,1	3	■
JPD880160E2C.0Z3A	02968196	2	E	■	16,0	16,0	13,0	90,0	35,0	14,8	0,1	3	■
JPD880100E3C.0Z3A	02968193	3	E	■	10,0	10,0	20,0	73,0	30,0	9,2	0,1	3	■
JPD880160E3C.0Z3A	02968197	3	E	■	16,0	16,0	20,0	90,0	35,0	14,8	0,1	3	■

■ Stocked standard.

Cutting data – JPD880 Side milling

SMG		a_e/DC	a_p/DC	f_z					v_c
				6	8	10	12	16	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	510 (430 — 750) *1675 (1500 — 2400)*
TS3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	275 (230 — 410) *900 (760 — 1300)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	810 (680 — 940) *2650 (2300 — 3000)*
TP3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	520 (440 — 780) *1700 (1500 — 2500)*

Cutting data – JPD880 Slot milling

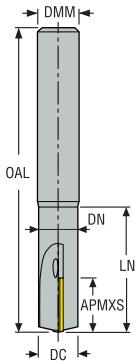
SMG		a_p/DC	f_z					v_c
			6	8	10	12	16	
TS2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	385 (330 — 570) *1275 (1100 — 1800)*
TS3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	210 (180 — 310) *690 (600 — 1000)*
TP2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	620 (520 — 710) *2025 (1800 — 2300)*
TP3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	395 (340 — 590) *1300 (1200 — 1900)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JPD890

Composite – Square – 2 Flutes – Cylindrical – Chamfer – ICC



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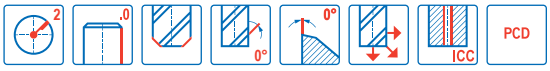


- Tolerances:
- DMM=h5
- DC=h10
- ICC=2 straight channels

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JPD890060G2S.0Z2A	02791382	2	G	■	6,0	8,0	13,0	64,0	20,0	5,4	0,1	2	■
JPD890080E2S.0Z2A	02791383	2	E	■	8,0	8,0	15,0	64,0	20,0	7,4	0,1	2	■
JPD890100E2S.0Z2A	02791384	2	E	■	10,0	10,0	13,0	73,0	30,0	9,4	0,1	2	■
JPD890120E2S.0Z2A	02791386	2	E	■	12,0	12,0	13,0	83,0	30,0	11,4	0,1	2	■
JPD890100E3S.0Z2A	02791385	3	E	■	10,0	10,0	20,0	73,0	30,0	9,4	0,1	2	■
JPD890120E3S.0Z2A	02791387	3	E	■	12,0	12,0	20,0	83,0	30,0	11,4	0,1	2	■

■ Stocked standard.

Cutting data – JPD890 Side milling

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	415 (360 — 620) *1350 (1200 — 2000)*
TS3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	305 (260 — 450) *1000 (860 — 1400)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	670 (560 — 770) *2200 (1900 — 2500)*
TP3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	580 (490 — 860) *1900 (1700 — 2800)*

Cutting data – JPD890 Slot milling

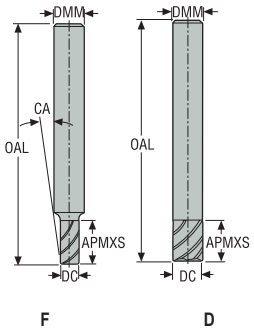
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	375 (320 — 550) *1225 (1100 — 1800)*
TS3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	225 (190 — 330) *740 (630 — 1000)*
TP2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	600 (500 — 690) *1975 (1700 — 2200)*
TP3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	420 (360 — 630) *1375 (1200 — 2000)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

J93F

General purpose – Plastic – Square – 2 Flutes – Cylindrical – Sharp



- Tolerances:
- DMM= h5
- DC= Ø1-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
93015-F	02605874	2	F	1,5	3,0	6,0	40,0	4,0	2	■
93020-F	02605888	2	F	2,0	3,0	9,0	40,0	2,5	2	■
93030-F	02606060	2	D	3,0	3,0	12,0	40,0	–	2	■
93040-F	02606061	2	D	4,0	4,0	14,0	50,0	–	2	■
93060-F	02606063	2	D	6,0	6,0	20,0	65,0	–	2	■
93080-F	02606064	2	D	8,0	8,0	20,0	70,0	–	2	■
93100-F	02606065	2	D	10,0	10,0	25,0	80,0	–	2	■
93120-F	02606066	2	D	12,0	12,0	25,0	90,0	–	2	■
93160-F	02606068	2	D	16,0	16,0	30,0	90,0	–	2	■
93L060-F	02606071	3	D	6,0	6,0	40,0	100,0	–	2	■
93L080-F	02606072	3	D	8,0	8,0	40,0	100,0	–	2	■
93L100-F	02606073	3	D	10,0	10,0	40,0	100,0	–	2	■
93L120-F	02606074	3	D	12,0	12,0	45,0	100,0	–	2	■
93L160-F	02606077	3	D	16,0	16,0	45,0	100,0	–	2	■
93L200-F	02606078	3	D	20,0	20,0	55,0	125,0	–	2	■
93XL120-F	02606079	4	D	12,0	12,0	30,0	150,0	–	2	■
93XL160-F	02606080	4	D	16,0	16,0	65,0	150,0	–	2	■
93XL200-F	02606081	4	D	20,0	20,0	65,0	150,0	–	2	■

■ Stocked standard.

Cutting data – J93F Side milling

SMG		a_e/DC	a_p/DC	f_z										v_c
				1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	590 (480 — 710) *1925 (1600 — 2300)*
TP1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	570 (460 — 680) *1875 (1600 — 2200)*

Cutting data – J93F Slot milling

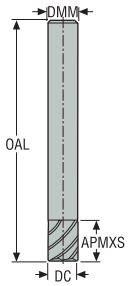
SMG		a_p/DC	f_z										v_c
			1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
TP1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	485 (390 — 580) *1600 (1300 — 1900)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

J28

General purpose – Plastic – Square – 1 Flute – Cylindrical – Sharp



D

- Tolerances:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø12= -0,02/-0,044 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
28030	00029353	2	D	3,0	3,0	10,0	40,0	1	■
28040	00029361	2	D	4,0	4,0	14,0	50,0	1	■
28050	00029363	2	D	5,0	5,0	16,0	60,0	1	■
28060	00029366	2	D	6,0	6,0	20,0	65,0	1	■
28080	00029369	2	D	8,0	8,0	25,0	75,0	1	■
28100	00029370	2	D	10,0	10,0	25,0	75,0	1	■
28120	00029372	2	D	12,0	12,0	25,0	75,0	1	■

■ Stocked standard.

Cutting data – J28 Side milling a_e/DC=0,4

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS1	A/D	0.300 *0,300*	1.5 *1,5*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	490 (370 — 610) *1600 (1300 — 2000)*

Cutting data – J28 Slot milling

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS1	A/D	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	400 (310 — 490) *1300 (1100 — 1600)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

GRAPHITE

Seco diamond-coated solid carbide end mills are designed specifically for machining graphite. They offer up to 10 times more tool life than milling cutters with conventional coatings. Available in a variety of geometries and an extensive diameter range, these tools feature the best possible substrate to ensure the perfect adhesion of the diamond coating across a range of cutting parameters.

- JD620, JD630, JD640 and JME642 for radius type.
- JD660, SMB614, SMB616 and JMB642 for ball-nose type.

Tool Selection Graphite

Name		JD620	JD630	JD640	JD660
Page(s)		472	474	476	478
Family name		DIAMOND	DIAMOND	DIAMOND	DIAMOND
Type of mill					
Shank	Cylindrical	■	■	■	■
	Weldon				
Number of Flutes		2	3	4	2
ICC					
Diameter range	Metric	3-12	3-8	6-12	3-6
	Inch				
Length availability		2,3,4	2,3,4	2,3,4	1,2,3,4,5
Operation					
SMG					
GR		●	●	●	●

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

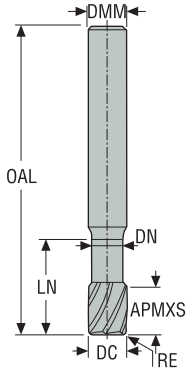
Tool Selection Graphite

Name		SMB614/616	JME642	JMB642/JMB662
Page(s)		480	482	484
Family name		MINI DIAMOND	MINI DIAMOND	MINI DIAMOND
Type of mill				
Shank	Cylindrical	■	■	■
	Weldon			
Number of Flutes		2	2	2
ICC				
Diameter range	Metric	0,6-3	0,2-2,0	0,2-3,0
	Inch			
Length availability		1,3,5,6,7	1,3,5,6,7	1,3,5,6,7
Operation				
SMG				
GR		●	●	●

■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

JD620

Diamond – Graphite – Square – 2 Flutes – Cylindrical – Corner radius



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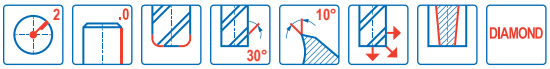


- Tolerances:
- Run-out= <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
620V030R050-DIAMOND	00023425	2	E	3,0	3,0	5,0	60,0	30,0	2,85	0,5	2	■
620V040R050-DIAMOND	00023427	2	E	4,0	4,0	5,0	60,0	30,0	3,85	0,5	2	■
620V060R050-DIAMOND	00023429	2	E	6,0	6,0	10,0	80,0	40,0	5,8	0,5	2	■
620V080R050-DIAMOND	00023431	2	E	8,0	8,0	10,0	80,0	40,0	7,7	0,5	2	■
620V100R050-DIAMOND	00023435	2	E	10,0	10,0	10,0	80,0	40,0	9,7	0,5	2	■
620V120R050-DIAMOND	00023437	2	E	12,0	12,0	10,0	80,0	40,0	11,7	0,5	2	■
620VL060R050-DIAMOND	00023444	3	E	6,0	6,0	10,0	100,0	70,0	5,8	0,5	2	■
620VL080R050-DIAMOND	00023446	3	E	8,0	8,0	10,0	100,0	70,0	7,8	0,5	2	■
620VL080R100-DIAMOND	00023447	3	E	8,0	8,0	10,0	100,0	70,0	7,8	1,0	2	■
620VL100R050-DIAMOND	00023448	3	E	10,0	10,0	10,0	100,0	70,0	9,8	0,5	2	■
620VL100R100-DIAMOND	00023449	3	E	10,0	10,0	10,0	100,0	70,0	9,8	1,0	2	■
620VL120R050-DIAMOND	00023450	3	E	12,0	12,0	10,0	100,0	70,0	11,8	0,5	2	■
620VL120R100-DIAMOND	00023451	3	E	12,0	12,0	10,0	100,0	70,0	11,7	1,0	2	■
620VSL100R100-DIAMOND	00023452	4	E	10,0	10,0	10,0	150,0	100,0	9,8	1,0	2	■
620VSL120R100-DIAMOND	00023453	4	E	12,0	12,0	10,0	150,0	100,0	11,8	1,0	2	■

■ Stocked standard.

Cutting data – JD620 Side milling

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
GR1	D	0.500 *0,500*	0.50 *0,50*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	690 (580 — 800) *2275 (2000 — 2600)*

Cutting data – JD620 Slot milling

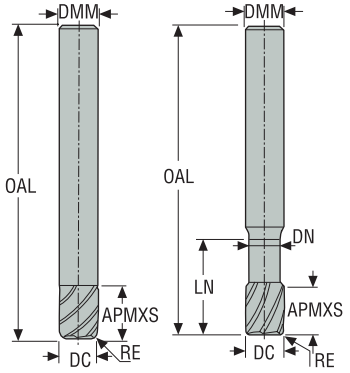
SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520 — 710) *2000 (1800 — 2300)*

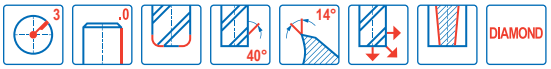
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JD630

Diamond – Graphite – Square – 3 Flutes – Cylindrical – Corner radius





- Tolerances:
- Run-out= <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
630030R015-DIAMOND	00023454	2	D	3,0	3,0	12,0	40,0	–	–	0,15	3	■
630040R020-DIAMOND	00023456	2	D	4,0	4,0	14,0	50,0	–	–	0,2	3	■
630050R030-DIAMOND	00023457	2	D	5,0	5,0	16,0	50,0	–	–	0,3	3	■
630060R030-DIAMOND	00023458	2	D	6,0	6,0	20,0	65,0	–	–	0,3	3	■
630080R050-DIAMOND	00023459	2	D	8,0	8,0	20,0	65,0	–	–	0,5	3	■
630V030R030-DIAMOND	00023464	3	E	3,0	3,0	5,0	40,0	15,0	2,9	0,3	3	■
630V040R030-DIAMOND	00023465	3	E	4,0	4,0	5,0	50,0	20,0	3,9	0,3	3	■
630VL030R020-DIAMOND	00023467	4	E	3,0	3,0	5,0	60,0	25,0	2,9	0,2	3	■
630VL040R020-DIAMOND	00023470	4	E	4,0	4,0	5,0	60,0	30,0	3,9	0,2	3	■
630VL050R020-DIAMOND	00023471	4	E	5,0	5,0	6,0	70,0	40,0	4,9	0,2	3	■
630VL060R050-DIAMOND	00023472	4	E	6,0	6,0	10,0	100,0	60,0	5,9	0,5	3	■

■ Stocked standard.

Cutting data – JD630 Side milling

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	4	5	6	8	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	680 (580 — 790) *2225 (2000 — 2500)*

Cutting data – JD630 Slot milling

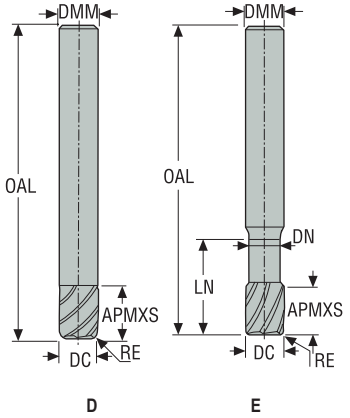
SMG		a_p/DC	f_z					v_c
			3	4	5	6	8	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	620 (520 — 720) *2025 (1800 — 2300)*

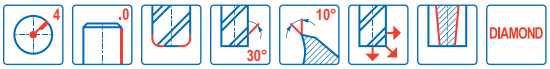
For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JD640

Diamond – Graphite – Square – 4 Flutes – Cylindrical – Corner radius





- Tolerances:
- Run-out= <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
640100R050-DIAMOND	00023474	2	D	10,0	10,0	25,0	75,0	–	–	0,5	4	■
640120R050-DIAMOND	00023475	2	D	12,0	12,0	25,0	80,0	–	–	0,5	4	■
640V060R050-DIAMOND	00023479	3	E	6,0	6,0	10,0	80,0	40,0	5,9	0,5	4	■
640V080R050-DIAMOND	00023480	3	E	8,0	8,0	10,0	80,0	40,0	7,8	0,5	4	■
640V100R050-DIAMOND	00023481	3	E	10,0	10,0	12,0	80,0	40,0	9,8	0,5	4	■
640V120R050-DIAMOND	00023483	3	E	12,0	12,0	15,0	80,0	40,0	11,8	0,5	4	■
640VL100R050-DIAMOND	00023486	4	E	10,0	10,0	12,0	125,0	80,0	9,8	0,5	4	■
640VL120R050-DIAMOND	02462698	4	E	12,0	12,0	15,0	125,0	80,0	11,7	0,5	4	■

■ Stocked standard.

Cutting data – JD640 Side milling

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	680 (570 — 780) *2225 (1900 — 2500)*

Cutting data – JD640 Slot milling

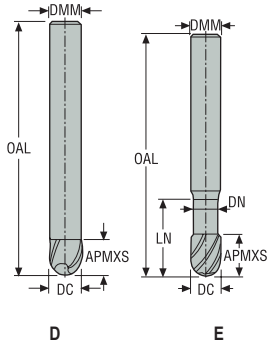
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
GR1	D	0.50 *0,50*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520 — 710) *2000 (1800 — 2300)*

For cutting data recalculations, see pages 573 - 580

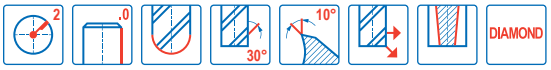
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JD660

Diamond – Graphite – Ball nose – 2 Flutes – Cylindrical



- Tolerances:
- Run-out=<0,01 mm
- DMM=h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- B=0,9°



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
660030-DIAMOND	00023488	1	D	3,0	3,0	8,0	40,0	–	–	1,5	2	■
660040-DIAMOND	00023489	1	D	4,0	4,0	14,0	50,0	–	–	2,0	2	■
660060-DIAMOND	00023491	1	D	6,0	6,0	20,0	65,0	–	–	3,0	2	■
660V030-DIAMOND	00023501	2	E	3,0	3,0	6,0	40,0	15,0	2,9	1,5	2	■
660V040-DIAMOND	00023502	2	E	4,0	4,0	6,0	40,0	15,0	3,9	2,0	2	■
660V060-DIAMOND	00023505	2	E	6,0	6,0	10,0	65,0	35,0	5,9	3,0	2	■
660L030-DIAMOND	00023494	3	D	3,0	3,0	20,0	60,0	–	–	1,5	2	■
660L040-DIAMOND	00023496	3	D	4,0	4,0	30,0	60,0	–	–	2,0	2	■
660L060-DIAMOND	00023498	3	D	6,0	6,0	40,0	100,0	–	–	3,0	2	■
660VL030-DIAMOND	00023511	4	E	3,0	3,0	6,0	60,0	30,0	2,9	1,5	2	■
660VL040-DIAMOND	00023512	4	E	4,0	4,0	6,0	60,0	30,0	3,9	2,0	2	■
660VL060-DIAMOND	00023516	4	E	6,0	6,0	10,0	100,0	70,0	5,8	3,0	2	■

■ Stocked standard.

Cutting data – JD660 Copy milling roughing

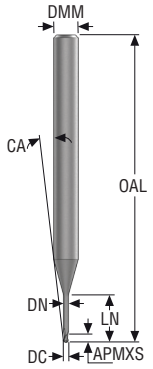
SMG		a_e/DC	a_p/DC	f_z			v_c
				3	4	6	
GR1	D	0.400 *0,400*	2.4 *2,4*	0.024 *0,00095*	0.032 *0,0013*	0.046 *0,0018*	920 (780 — 1000) *3025 (2600 — 3200)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

SMB614/616

Miniature – Graphite – Ball nose – 2 Flutes – Cylindrical



G

- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC Coated = -0,01/-0,025 mm
- DC Coated = 0/-0,015 mm
- RE = ±0,01 mm

Designation	Grade	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	DN	LN	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm			
SMB614010G4B.0Z2	–	10108702	4	G	1,0	4	1,0	50	0,95	7,5	6,54 °	2	■
SMB614010G4B.0Z2	DIA	10108776	4	G	1,0	4	1,0	50	0,95	7,5	6,54 °	2	■
SMB614020G4B.0Z2	–	10108703	4	G	2,0	4	2,0	50	1,9	12,0	3,74 °	2	■
SMB614020G4B.0Z2	DIA	10108777	4	G	2,0	4	2,0	50	1,9	12,0	3,74 °	2	■
SMB616020G4B.0Z2	–	10108768	4	G	2,0	6	2,0	50	1,9	12,0	5,99 °	2	■
SMB614030G4B.0Z2	–	10108704	4	G	3,0	4	3,0	50	2,85	20,0	1,36 °	2	■
SMB614030G4B.0Z2	DIA	10108778	4	G	3,0	4	3,0	50	2,85	20,0	1,36 °	2	■
SMB616030G4B.0Z2	–	10108769	4	G	3,0	6	3,0	55	2,85	20,0	3,47 °	2	■
SMB614020G5B.0Z2	–	10108705	5	G	2,0	4	2,0	50	1,9	16,0	2,96 °	2	■
SMB614020G5B.0Z2	DIA	10108779	5	G	2,0	4	2,0	50	1,9	16,0	3,13 °	2	■
SMB616020G5B.0Z2	–	10108770	5	G	2,0	6	2,0	50	1,9	16,0	4,96 °	2	■
SMB614006G6B.0Z2	–	10108706	6	G	0,6	4	0,6	50	0,55	6,0	7,72 °	2	■
SMB614006G6B.0Z2	DIA	10108780	6	G	0,6	4	0,6	50	0,55	6,0	7,72 °	2	■
SMB616006G6B.0Z2	–	10108771	6	G	0,6	6	0,6	50	0,55	6,0	9,43 °	2	■
SMB614008G6B.0Z2	–	10108707	6	G	0,8	4	0,8	50	0,75	10,0	5,69 °	2	■
SMB614008G6B.0Z2	DIA	10108781	6	G	0,8	4	0,8	50	0,75	10,0	5,69 °	2	■
SMB614010G6B.0Z2	–	10108708	6	G	1,0	4	0,5	50	0,95	12,0	4,88 °	2	■
SMB614010G6B.0Z2	DIA	10108782	6	G	1,0	4	0,5	50	0,95	12,0	4,88 °	2	■
SMB616010G6B.0Z2	–	10108772	6	G	1,0	6	1,0	50	0,95	12,0	6,69 °	2	■
SMB614020G6B.0Z2	–	10108709	6	G	2,0	4	2,0	50	1,9	20,0	2,46 °	2	■
SMB614020G6B.0Z2	DIA	10108783	6	G	2,0	4	2,0	50	1,9	20,0	2,46 °	2	■
SMB616020G6B.0Z2	–	10108773	6	G	2,0	6	2,0	55	1,9	20,0	4,23 °	2	■
SMB614006G7B.0Z2	–	10108710	7	G	0,6	4	0,6	50	0,55	10,0	5,87 °	2	■
SMB614006G7B.0Z2	DIA	10108784	7	G	0,6	4	0,6	50	0,55	10,0	5,87 °	2	■
SMB616006G7B.0Z2	–	10108774	7	G	0,6	6	0,6	50	0,55	10,0	7,59 °	2	■
SMB614010G7B.0Z2	–	10108711	7	G	1,0	4	1,0	50	0,95	18,0	3,64 °	2	■
SMB614010G7B.0Z2	DIA	10108785	7	G	1,0	4	1,0	50	0,95	18,0	3,64 °	2	■
SMB616010G7B.0Z2	–	10108775	7	G	1,0	6	1,0	55	0,95	18,0	5,23 °	2	■

■ Stocked standard.

Cutting data – SMB614 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.6	0.8	1	2	3	
GR1	D	0,0700 *0.0700*	0,10 *0.10*	0,018 *0.00070*	0,024 *0.00095*	0,030 *0.0012*	0,060 *0.0024*	0,090 *0.0036*	95 (54 — 120) *310 (180 — 390)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – SMB616 Copy milling roughing

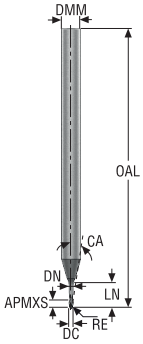
SMG		a_e/DC	a_p/DC	f_z				v_c
				0.6	1	2	3	
GR1	D	0,0700 *0.0700*	0,10 *0.10*	0,018 *0.00070*	0,030 *0.0012*	0,060 *0.0024*	0,090 *0.0036*	95 (54 — 120) *310 (180 — 390)*

For cutting data recalculations, see pages 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JME642

Miniature – Graphite – Square – Diamond – 2 Flutes – DMM 4 – Cylindrical – Corner radius



G

- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0/-0,015 mm
- RE= ±0,007 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JME642002G1R002.0Z2-DIA	03215524	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,02	14,32	2	■
JME642003G1R002.0Z2-DIA	03215525	1	G	0,3	4,0	0,5	40,0	0,5	0,28	0,02	14,1	2	■
JME642004G1R004.0Z2-DIA	03215526	1	G	0,4	4,0	0,6	40,0	2,0	0,37	0,04	11,67	2	■
JME642005G3R005.0Z2-DIA	03215527	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,05	10,97	2	■
JME642006G3R006.0Z2-DIA	03215528	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,06	10,31	2	■
JME642008G3R008.0Z2-DIA	03215529	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,08	9,31	2	■
JME642010G3R010.0Z2-DIA	03215530	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,1	8,04	2	■
JME642012G3R012.0Z2-DIA	03215531	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,12	7,09	2	■
JME642015G3R015.0Z2-DIA	03215532	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,15	5,8	2	■
JME642020G3R015.0Z2-DIA	03236441	3	G	2,0	4,0	2,2	60,0	10,0	1,9	0,15	4,11	2	■
JME642020G3R020.0Z2-DIA	03215533	3	G	2,0	4,0	3,0	60,0	10,0	1,9	0,2	4,11	2	■
JME642005G5R005.0Z2-DIA	03215534	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,05	9,43	2	■
JME642006G5R006.0Z2-DIA	03215535	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,06	8,5	2	■
JME642008G5R008.0Z2-DIA	03215536	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,08	7,02	2	■
JME642010G5R010.0Z2-DIA	03215537	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,1	6,06	2	■
JME642012G5R012.0Z2-DIA	03215538	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,12	5,23	2	■
JME642015G5R015.0Z2-DIA	03215539	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,15	4,25	2	■
JME642020G5R015.0Z2-DIA	03236442	5	G	2,0	4,0	2,2	60,0	16,0	1,9	0,15	2,87	2	■
JME642020G5R020.0Z2-DIA	03215540	5	G	2,0	4,0	3,0	60,0	16,0	1,9	0,2	2,87	2	■
JME642010G6R010.0Z2-DIA	03215541	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,1	4,86	2	■
JME642015G6R015.0Z2-DIA	03215542	6	G	1,5	4,0	2,4	50,0	18,0	1,4	0,15	3,13	2	■
JME642020G6R020.0Z2-DIA	03215543	6	G	2,0	4,0	3,0	60,0	25,0	1,9	0,2	1,97	2	■
JME642020G7R020.0Z2-DIA	03215544	7	G	2,0	4,0	3,0	60,0	30,0	1,9	0,2	1,68	2	■

■ Stocked standard.

Cutting data – JME642 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.80 *0,80*	0.024 *0,00095*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	175 (130 — 370) *570 (430 — 1200)*

Cutting data – JME642 Slot milling

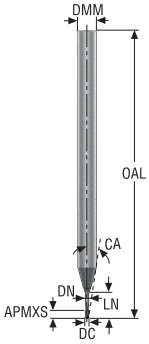
SMG		a_p/DC	f_z										v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.30 *0,30*	0.022 *0,00085*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	140 (110 — 300) *460 (370 — 980)*

Table based on LV3, please recalc based on length version chosen. See page(s). 573 - 580

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JMB642/JMB662

Miniature – Graphite – Ball nose – Diamond – 2 Flutes – DMM 4-6 – Cylindrical



G

- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0/-0,015 mm
- RE= ±0,007 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm			
JMB642002G1B.0Z2-DIA	03215373	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,1	14,5	2	■
JMB642003G1B.0Z2-DIA	03215374	1	G	0,3	4,0	0,5	40,0	0,6	0,28	0,15	14,17	2	■
JMB642004G1B.0Z2-DIA	03215375	1	G	0,4	4,0	2,0	40,0	0,8	0,37	0,2	13,8	2	■
JMB642005G3B.0Z2-DIA	03215376	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,25	11,19	2	■
JMB642006G3B.0Z2-DIA	03215377	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,3	10,55	2	■
JMB642008G3B.0Z2-DIA	03215378	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,4	9,38	2	■
JMB642010G3B.0Z2-DIA	03215379	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,5	8,33	2	■
JMB642012G3B.0Z2-DIA	03215380	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,6	7,38	2	■
JMB642015G3B.0Z2-DIA	03215381	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,75	6,08	2	■
JMB642020G3B.0Z2-DIA	03215382	3	G	2,0	4,0	3,0	60,0	10,0	1,9	1,0	4,35	2	■
JMB662030G3B.0Z2-DIA	03215384	3	G	3,0	6,0	3,0	60,0	15,0	2,8	1,5	4,38	2	■
JMB642005G5B.0Z2-DIA	03215387	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,25	9,6	2	■
JMB642006G5B.0Z2-DIA	03215388	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,3	8,68	2	■
JMB642008G5B.0Z2-DIA	03215389	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,4	7,18	2	■
JMB642010G5B.0Z2-DIA	03215390	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,5	6,22	2	■
JMB642012G5B.0Z2-DIA	03215391	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,6	5,4	2	■
JMB642015G5B.0Z2-DIA	03215392	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,75	4,4	2	■
JMB642020G5B.0Z2-DIA	03215393	5	G	2,0	4,0	3,0	60,0	16,0	1,9	1,0	2,99	2	■
JMB662030G5B.0Z2-DIA	03215395	5	G	3,0	6,0	3,0	60,0	24,0	2,8	1,5	3,0	2	■
JMB642010G6B.0Z2-DIA	03215396	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,5	4,96	2	■
JMB642015G6B.0Z2-DIA	03215397	6	G	1,5	4,0	2,4	60,0	18,0	1,4	0,75	3,21	2	■
JMB642020G6B.0Z2-DIA	03215398	6	G	2,0	4,0	3,0	60,0	25,0	1,9	1,0	2,03	2	■
JMB642020G7B.0Z2-DIA	03215399	7	G	2,0	4,0	3,0	60,0	30,0	1,9	1,0	1,72	2	■

■ Stocked standard.

Cutting data – JMB642/662 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Cutting data – JMB642/662 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Table based on LV3, please recalc based on length version chosen. See page(s) N/A-N/A

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

SECO X-HEADS

The new Seco Tools Exchangeable Head range is a comprehensive offering to meet most customer demands. Utilizing our proven solid carbide geometries, we offer various types to machine most materials and complete various machining operations. The connection is a proven exchangeable head design to give high process security and reliability. The shanks offer many types for short reach up to long reach applications. Straight necking and tapered necks to give the best combination of stability depending on the needs for your machining operation.

- XSE550, XSE720, XSE450, XHF580, XHF780 XVE540 and XVE510 for chamfer or radius type.
- XSB540, XSB720 and XVB510 for ball-nose type.
- XSC509, XVC506, XVC509 and XVC512 for conical type.
- XHT740 for barrel type.

Tool selection X-Heads

Name		XSE550	XSB540	XSE720	XSB720	XSE450	XSC509	XHT740
Page(s)		497-505	514	516-517	522	528-529	567	304
Family name		X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS HSM/ TORNADO
Type of mill								
Number of Flutes		3,4,5	4	6	6	3	6	4,6
ICC			■					
Diameter range	Metric	10-25	10-16	10-25	10-20	10-20	10-16	10-16
	Inch	3/8-1		3/8-1	3/8-1	3/8-1		
Length availability		1,2	1	3	3	2	1	2,3
Operation								
SMG								
P1-8		●	●	○	○		●	○
P11-12		●	○	●	●		●	●
M1-3		●	●	●	●		●	●
M4-5		●	●	●	●		●	
K1-7		●	●				●	
S1-3		●	○	●	●		○	○
S11-13		●	●	●	●		○	●
H3 H5 H7 H8 H11 H12 H21 H31		●	○					
N1		●	●			●	○	
N2-3		●	●			●	○	
N11		●	●			●	○	
TS1		●	●			●	●	
TP1		●	●			●	●	
GR		○	○				○	

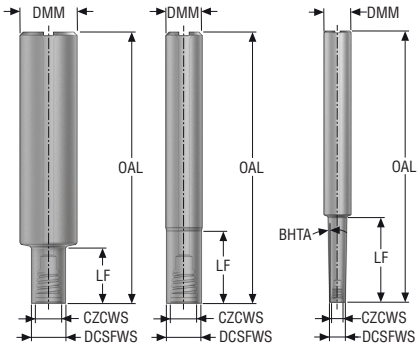
■ Stocked standard.
● Preferred choice, ○ Alternative choice

Tool selection X-Heads

Name		XHF580	XHF780	XVE540	XVE510	XVB510	XVC506/509/512	XVK310
Page(s)		537	542	555	560	563-564	567	571
Family name		X-HEADS HFM	X-HEADS HFM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM
Type of mill								
Number of Flutes		4	4	3,4	2	2	2	4
ICC		■		■				
Diameter range	Metric	10-16	10-16	10-20	10-12	10-16	10-16	12-20
	Inch	3/8-5/8	3/8-5/8	3/8-3/4		3/8-5/8		
Length availability		1	1	1	1	1	1	1
Operation								
SMG								
P1-8		●	○	●	●	●	●	●
P11-12		●	○	●	●	●	●	●
M1-3		●	●	●	●	●	●	●
M4-5		●	●	●	●	●	●	●
K1-7		●		●	●	●	●	●
S1-3		○	●	○	○	○	○	○
S11-13		○	●	○	○	○	○	○
H3 H5 H7 H8 H11 H12 H21 H31		○	○	○				○
N1				●	○	○	○	●
N2-3				●	○	○	○	●
N11				●	○	○	○	●
TS1				●	●	●	●	●
TP1				●	●	●	●	●
GR				○	○	○	○	○

■ Stocked standard.
● Preferred choice, ○ Alternative choice

Steel - Metric



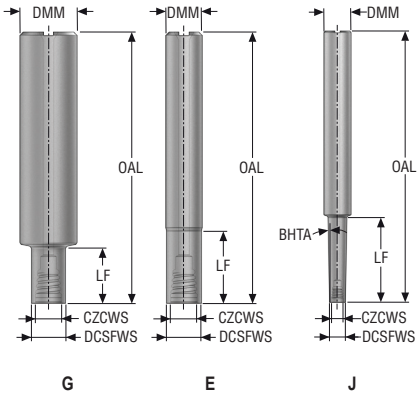
- Tolerances:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					mm	mm	mm	mm		
XE10160G1-065-00.0S	10138083	1	G	E10	9,6	16,0	5,0	65,0	0,0	■
XE10100E2-055-00.0S	10138092	2	E	E10	9,6	10,0	10,0	55,0	0,0	■
XE10100E2-075-00.0S	10138093	2	E	E10	9,6	10,0	20,0	75,0	0,0	■
XE10160G2-075-00.0S	10138088	2	G	E10	9,6	16,0	15,0	75,0	0,0	■
XE10160J3-120-01.0S	10138099	3	J	E10	9,6	16,0	35,0	120,0	1,0	■
XE10160J5-160-01.0S	10138100	5	J	E10	9,6	16,0	50,0	160,0	1,0	■
XE10160J3-140-05.0S	10138106	3	J	E10	9,6	16,0	36,6	140,0	5,0	■
XE10200J5-140-05.0S	10138108	5	J	E10	9,6	20,0	59,4	140,0	5,0	■
XE10320J6-250-10.0S	10138113	6	J	E10	9,6	32,0	63,5	250,0	10,0	■
XE12160G1-065-00.0S	10138084	1	G	E12	11,6	16,0	5,0	65,0	0,0	■
XE12120E2-065-00.0S	10138094	2	E	E12	11,6	12,0	12,0	65,0	0,0	■
XE12120E2-100-00.0S	10138095	2	E	E12	11,6	12,0	22,0	100,0	0,0	■
XE12160G2-080-00.0S	10138089	2	G	E12	11,6	16,0	18,0	80,0	0,0	■
XE12160J3-155-01.0S	10138101	3	J	E12	11,6	16,0	42,0	155,0	1,0	■
XE12160J5-170-01.0S	10138102	5	J	E12	11,6	16,0	60,0	170,0	1,0	■
XE12160J2-140-05.0S	10138107	2	J	E12	11,6	16,0	25,1	140,0	5,0	■
XE12200J4-155-05.0S	10138109	4	J	E12	11,6	20,0	48,0	155,0	5,0	■
XE12320J4-250-10.0S	10138114	4	J	E12	11,6	32,0	57,8	250,0	10,0	■
XE16200G1-070-00.0S	10138085	1	G	E16	15,4	20,0	5,0	70,0	0,0	■
XE16160E2-070-00.0S	10138096	2	E	E16	15,4	16,0	16,0	70,0	0,0	■
XE16200G2-090-00.0S	10138090	2	G	E16	15,4	20,0	24,0	90,0	0,0	■
XE16200G2-110-00.0S	10138091	2	G	E16	15,4	20,0	25,0	110,0	0,0	■
XE16200J3-190-01.0S	10138103	3	J	E16	15,4	20,0	56,0	190,0	1,0	■
XE16200J4-190-01.0S	10138104	4	J	E16	15,4	20,0	75,0	190,0	1,0	■
XE16250J3-170-05.0S	10138110	3	J	E16	15,4	25,0	54,9	170,0	5,0	■
XE20250G1-080-00.0S	10138086	1	G	E20	19,2	25,0	5,0	80,0	0,0	■
XE20200E2-120-00.0S	10138097	2	E	E20	19,2	20,0	30,0	120,0	0,0	■
XE20250J4-200-01.0S	10138105	4	J	E20	19,2	25,0	80,0	200,0	1,0	■
XE20320J3-180-05.0S	10138111	3	J	E20	19,2	32,0	73,2	180,0	5,0	■
XE25320G1-080-00.0S	10138087	1	G	E25	24,1	32,0	5,0	80,0	0,0	■
XE25250E2-140-00.0S	10138098	2	E	E25	24,1	25,0	40,0	140,0	0,0	■
XE25320J2-200-05.0S	10138112	2	J	E25	24,1	32,0	45,1	200,0	5,0	■

Spare Parts, included in delivery		Accessories		
CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Steel - Inch



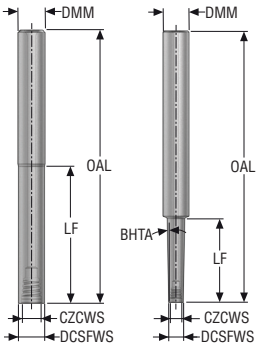
- Tolerances:
- DMM= h6
- DCSFWS= ±.002 inch
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					inch	inch	inch	inch		
XE10.500G1-2.50-00.0S	10138050	1	G	E10	0.360	0.500	0.250	2.500	0,0	■
XE10.375E2-2.50-00.0S	10138053	2	E	E10	0.360	0.375	0.402	2.500	0,0	■
XE10.500G2-3.00-00.0S	10138051	2	G	E10	0.360	0.500	1.000	3.000	0,0	■
XE10.625J3-4.50-01.0S	10138063	3	J	E10	0.360	0.625	1.402	4.500	1,0	■
XE10.625J5-6.50-01.0S	10138064	5	J	E10	0.360	0.625	2.000	6.500	1,0	■
XE10.625J4-4.00-03.0S	10138071	4	J	E10	0.360	0.625	1.799	4.000	3,0	■
XE10.750J9-6.00-03.0S	10138072	9	J	E10	0.360	0.750	3.720	6.000	3,0	■
XE12.500E1-3.00-00.0S	10138054	1	E	E12	0.480	0.500	0.250	3.000	0,0	■
XE12.500E2-2.50-00.0S	10138055	2	E	E12	0.480	0.500	0.500	2.500	0,0	■
XE12.500E2-4.50-00.0S	10138056	2	E	E12	0.480	0.500	1.000	4.500	0,0	■
XE12.625J3-6.00-01.0S	10138065	3	J	E12	0.480	0.625	1.650	6.000	1,0	■
XE12.625J4-7.50-01.0S	10138066	4	J	E12	0.480	0.625	2.400	7.500	1,0	■
XE12.750J5-6.50-01.0S	10138067	5	J	E12	0.480	0.750	2.850	6.500	1,0	■
XE12.750J4-4.50-03.0S	10138073	4	J	E12	0.480	0.750	2.201	4.500	3,0	■
XE12.750J5-6.00-03.0S	10138074	5	J	E12	0.480	0.750	2.575	6.000	3,0	■
XE12.625J2-6.50-05.0S	10138075	2	J	E12	0.480	0.625	0.827	6.500	5,0	■
XE16.625E1-3.00-00.0S	10138057	1	E	E16	0.606	0.625	0.250	3.000	0,0	■
XE16.625E2-3.00-00.0S	10138058	2	E	E16	0.606	0.625	0.650	3.000	0,0	■
XE16.625E2-4.50-00.0S	10138059	2	E	E16	0.606	0.625	1.000	4.500	0,0	■
XE16.750J3-7.50-01.0S	10138068	3	J	E16	0.606	0.750	2.252	7.500	1,0	■
XE16.750J4-7.50-01.0S	10138070	4	J	E16	0.606	0.750	3.000	7.500	1,0	■
XE16.750J6-7.50-01.0S	10138069	6	J	E16	0.606	0.750	3.748	7.500	1,0	■
XE16.750J2-6.50-05.0S	10138076	2	J	E16	0.606	0.750	0.821	6.500	5,0	■
XE161.00J3-7.00-05.0S	10138077	3	J	E16	0.606	1.000	2.250	7.000	5,0	■
XE20.750E1-3.00-00.0S	10138060	1	E	E20	0.724	0.750	0.250	3.000	0,0	■
XE20.750E2-4.50-00.0S	10138061	2	E	E20	0.724	0.750	1.000	4.500	0,0	■
XE251.00E1-3.50-00.0S	10138062	1	E	E25	0.961	1.000	0.250	3.500	0,0	■
XE251.00E2-4.50-00.0S	10218129	2	E	E25	0.961	1.000	1.500	4.500	0,0	■
XE251.25G2-6.50-00.0S	10138052	2	G	E25	0.961	1.250	2.500	6.500	0,0	■
XE251.25J2-7.50-05.0S	10218130	2	J	E25	0.961	1.250	1.654	7.500	5,0	■

Spare Parts, included in delivery		Accessories		
CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Solid carbide - Metric



E J

- Tolerances:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					mm	mm	mm	mm		
XE10100E5-100-00.0E	10138120	5	E	E10	9,6	10,0	50,0	100,0	0,0	■
XE10160J9-155-01.0E	10138126	9	J	E10	9,6	16,0	100,0	155,0	1,0	■
XE12120E4-100-00.0E	10138121	4	E	E12	11,6	12,0	48,0	100,0	0,0	■
XE12160J7-150-01.0E	10138127	7	J	E12	11,6	16,0	90,0	150,0	1,0	■
XE16160E5-135-00.0E	10138122	5	E	E16	15,4	16,0	80,0	135,0	0,0	■
XE16200J7-175-01.0E	10138128	7	J	E16	15,4	20,0	118,0	175,0	1,0	■
XE20200E2-095-00.0E	10138123	2	E	E20	19,2	20,0	38,0	95,0	0,0	■
XE20200E5-180-00.0E	10138124	5	E	E20	19,2	20,0	110,0	180,0	0,0	■
XE20250J4-200-02.0E	10138129	4	J	E20	19,2	25,0	83,0	200,0	2,0	■
XE25250E4-200-00.0E	10138125	4	E	E25	24,1	25,0	120,0	200,0	0,0	■
XE25320J2-190-05.0E	10218127	2	J	E25	24,1	32,0	45,1	190,0	5,0	■
XE25320J2-215-05.0E	10218128	2	J	E25	24,1	32,0	45,1	215,0	5,0	■

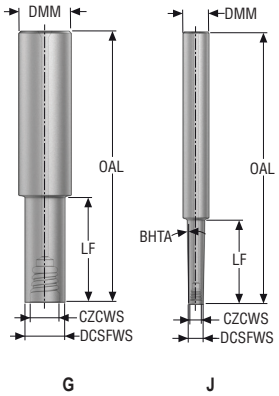
Spare Parts, included in delivery

Accessories

CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Solid carbide - inch



- Tolerances:
- DMM= h6
- DCSFWS= ±.002 inch
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					inch	inch	inch	inch		
XE10.625J5-6.50-01.0E	10138079	5	J	E10	0.360	0.625	2.000	6.500	1,0	■
XE12.625J4-7.50-01.0E	10138080	4	J	E12	0.480	0.625	2.400	7.500	1,0	■
XE16.750J4-7.50-01.0E	10138081	4	J	E16	0.606	0.750	3.000	7.500	1,0	■
XE201.00J4-8.00-01.0E	10138082	4	J	E20	0.724	1.000	3.150	8.000	1,0	■
XE251.25G2-6.50-00.0E	10138078	2	G	E25	0.961	1.250	2.500	6.500	0,0	■
XE251.25J2-8.50-05.0E	10218131	2	J	E25	0.961	1.250	1.654	8.500	5,0	■

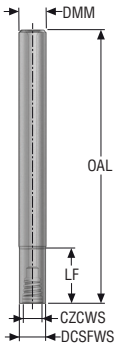
Spare Parts, included in delivery

Accessories

CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Densimet - Metric



E

- Tolerances:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					mm	mm	mm	mm		
XE10100E2-100-00.0DM	10138115	2	E	E10	9,6	10,0	20,0	100,0	0,0	■
XE12120E2-110-00.0DM	10138116	2	E	E12	11,6	12,0	25,0	110,0	0,0	■
XE16160E2-130-00.0DM	10138117	2	E	E16	15,4	16,0	35,0	130,0	0,0	■
XE20200E2-160-00.0DM	10138118	2	E	E20	19,2	20,0	45,0	160,0	0,0	■
XE25250E2-185-00.0DM	10138119	2	E	E25	24,1	25,0	65,0	185,0	0,0	■

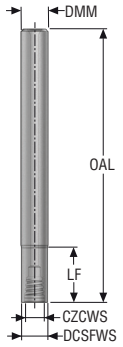
Spare Parts, included in delivery

Accessories

CZCWS	Spanner	Replacement blade	Replacement blade 1	Torque key
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ Stocked standard.

Densimet - Inch



E

- Tolerances:
- DMM= h6
- DCSFWS= ±.002 Inch

Designation	Item number	Length index	Tool shape	CZCWS	DCSFWS	DMM	LF	OAL	BHTA°	Cylindrical
					inch	inch	inch	inch		
XE251.00E2-7.28-00.0DM	10218132	2	E	E25	0.961	1.000	2.559	7.283	0,0	■

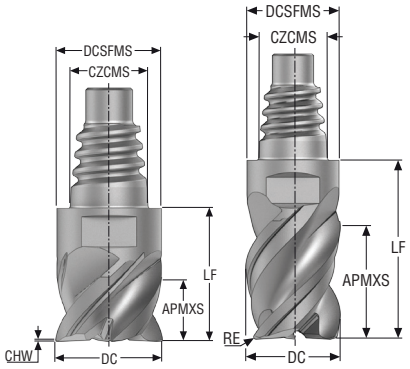
Spare Parts, included in delivery **Accessories**

CZCWS	Spanner	Replacement blade	Torque key
E25	XW-E25	XTWH-E25.20	XTW-E16.E25

■ Stocked standard.

XSE550

High performance – Universal – Square – 3 Flutes – Corner radius or chamfer



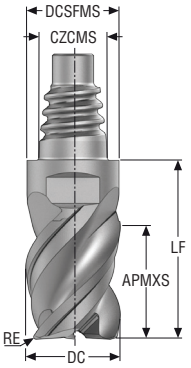
- Tolerances:
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E25250D1CZ3	10219207	1	D	E25	25,0	24,2	13,75	25,5	0,3125	–	3	20	■
XSE550E10100D1R050Z3	10138138	1	D	E10	10,0	9,7	5,5	12,3	–	0,5	3	8	■
XSE550E10100D1R100Z3	10219210	1	D	E10	10,0	9,7	5,5	12,3	–	1,0	3	8	■
XSE550E10100D1R200Z3	10219211	1	D	E10	10,0	9,7	5,5	12,3	–	2,0	3	8	■
XSE550E12120D1R050Z3	10138139	1	D	E12	12,0	11,7	6,6	14,4	–	0,5	3	10	■
XSE550E12120D1R100Z3	10219212	1	D	E12	12,0	11,7	6,6	14,4	–	1,0	3	10	■
XSE550E12120D1R200Z3	10219213	1	D	E12	12,0	11,7	6,6	14,4	–	2,0	3	10	■
XSE550E16160D1R050Z3	10138140	1	D	E16	16,0	15,5	8,8	18,6	–	0,5	3	12	■
XSE550E16160D1R100Z3	10219214	1	D	E16	16,0	15,5	8,8	18,6	–	1,0	3	12	■
XSE550E16160D1R200Z3	10219215	1	D	E16	16,0	15,5	8,8	18,6	–	2,0	3	12	■
XSE550E20200D1R050Z3	10138141	1	D	E20	20,0	19,3	11,0	21,2	–	0,5	3	16	■
XSE550E20200D1R100Z3	10219216	1	D	E20	20,0	19,7	11,0	21,2	–	1,0	3	16	■
XSE550E20200D1R200Z3	10219217	1	D	E20	20,0	19,7	11,0	21,2	–	2,0	3	16	■
XSE550E25250D1R050Z3	10219208	1	D	E25	25,0	24,2	13,75	25,5	–	0,5	3	20	■
XSE550E25250D1R100Z3	10219209	1	D	E25	25,0	24,2	13,75	25,5	–	1,0	3	20	■
XSE550E10100D2R050Z3	10138142	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	3	8	■
XSE550E10100D2R100Z3	10219218	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	3	8	■
XSE550E10100D2R200Z3	10219219	2	D	E10	10,0	9,7	12,0	18,7	–	2,0	3	8	■
XSE550E12120D2R050Z3	10138143	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	3	10	■
XSE550E12120D2R100Z3	10219220	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	3	10	■
XSE550E12120D2R200Z3	10219221	2	D	E12	12,0	11,7	14,4	22,1	–	2,0	3	10	■
XSE550E16160D2R050Z3	10138144	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	3	12	■
XSE550E16160D2R100Z3	10219222	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	3	12	■
XSE550E16160D2R200Z3	10219223	2	D	E16	16,0	15,5	19,2	29,2	–	2,0	3	12	■
XSE550E20200D2R100Z3	10219224	2	D	E20	20,0	19,7	24,0	34,3	–	1,0	3	16	■
XSE550E20200D2R200Z3	10219225	2	D	E20	20,0	19,7	24,0	34,3	–	2,0	3	16	■
XSE550E20200D2R050Z3	10138145	2	D	E20	20,0	19,3	24,0	34,3	–	0,5	3	16	■

■ Stocked standard.

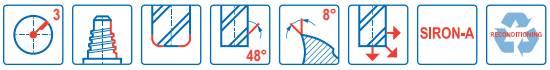
XSE550 – Inch

High performance – Universal – Square – 3 Flutes – Corner radius – Inch



D

- Tolerances:
- DC= e7
- RE= ±.0008 Inch
- Regrind possible if DC is ≥Ø.500 Inch



Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D1R030Z3	10138146	1	D	E10	0.375	0.364	0.206	0.484	0.030	3	8	■
XSE550E12.500D1R030Z3	10138147	1	D	E12	0.500	0.484	0.275	0.567	0.030	3	10	■
XSE550E20.750D1R030Z3	10138148	1	D	E20	0.750	0.728	0.413	0.835	0.030	3	16	■
XSE550E10.375D2R030Z3	10138149	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8	■
XSE550E12.500D2R030Z3	10138150	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10	■
XSE550E20.750D2R030Z3	10138151	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16	■

■ Stocked standard.

Cutting data – XSE550 – Side milling PCEDC 3

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	185 (140 — 220) *610 (460 — 720)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	175 (140 — 210) *570 (460 — 680)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 190) *510 (400 — 620)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	135 (110 — 170) *445 (370 — 550)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	130 (98 — 160) *425 (330 — 520)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	145 (110 — 180) *475 (370 — 590)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	140 (110 — 170) *460 (370 — 550)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	130 (97 — 160) *425 (320 — 520)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 100) *310 (270 — 320)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	60 (51 — 67) *195 (170 — 210)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	105 (92 — 120) *345 (310 — 390)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	90 (76 — 100) *295 (250 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	55 (44 — 68) *180 (150 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	43 (34 — 52) *140 (120 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	36 (28 — 43) *120 (92 — 140)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	140 (130 — 160) *460 (430 — 520)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	120 (110 — 130) *395 (370 — 420)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	115 (97 — 120) *375 (320 — 390)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	200 (170 — 220) *660 (560 — 720)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	180 (150 — 200) *590 (500 — 650)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	600 (560 — 780) *1975 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	390 (360 — 500) *1275 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	260 (240 — 330) *850 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	32 (26 — 40) *105 (86 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	28 (21 — 34) *90 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	24 (19 — 30) *80 (63 — 98)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	280 (170 — 390) *920 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	550 (450 — 660) *1800 (1500 — 2100)*

Seco

Cutting data – XSE550 – Slot milling PCEDC 3

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	75 (64 — 84) *245 (210 — 270)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	45 (39 — 51) *150 (130 — 160)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	85 (75 — 99) *280 (250 — 320)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	105 (88 — 110) *345 (290 — 360)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	100 (84 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	125 (100 — 130) *410 (330 — 420)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	540 (500 — 690) *1775 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	345 (330 — 440) *1125 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	230 (220 — 290) *750 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	20 (15 — 25) *65 (50 — 82)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	490 (410 — 600) *1600 (1400 — 1900)*

Cutting data – XSE550 – Side milling PCEDC 3 – inch

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	215 (190 — 240) *710 (630 — 780)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	160 (140 — 180) *520 (460 — 590)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	105 (93 — 110) *345 (310 — 360)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (60 — 75) *215 (200 — 240)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 130) *395 (370 — 420)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	100 (88 — 110) *330 (290 — 360)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (50 — 74) *195 (170 — 240)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	48 (39 — 57) *155 (130 — 180)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	40 (32 — 47) *130 (110 — 150)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (160 — 200) *560 (530 — 650)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	150 (150 — 180) *490 (500 — 590)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	125 (120 — 150) *410 (400 — 490)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	120 (120 — 140) *395 (400 — 450)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	200 (180 — 220) *660 (600 — 720)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 500) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*

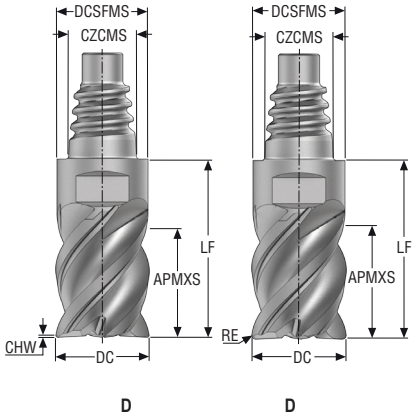
Universal
Steel and cast iron
Stainless steel and S-materials
Non ferrous
Hard
Plastic and cfrp
Graphite
X-Heads
Minimaster Plus
Minimaster

Cutting data – XSE550 – Slot milling PCEDC 3 inch

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	50 (46 — 58) *165 (160 — 190)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	80 (70 — 89) *260 (230 — 290)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	50 (41 — 60) *165 (140 — 190)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (140 — 180) *490 (460 — 590)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*

XSE550

High performance – Universal – Square – 4 Flutes – Corner radius or chamfer



- Tolerances:
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

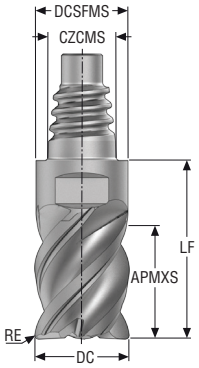
Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E10100D1CZ4	10219229	1	D	E10	10,0	9,7	5,5	12,3	0,125	–	4	8	■
XSE550E12120D1CZ4	10219230	1	D	E12	12,0	11,7	6,6	14,4	0,15	–	4	10	■
XSE550E16160D1CZ4	10219231	1	D	E16	16,0	15,5	88,0	18,6	0,2	–	4	12	■
XSE550E20200D1CZ4	10219232	1	D	E20	20,0	19,7	11,0	21,2	0,25	–	4	16	■
XSE550E25250D1CZ4	10219226	1	D	E25	25,0	24,2	13,75	25,5	0,3125	–	4	20	■
XSE550E10100D2CZ4	10138152	2	D	E10	10,0	9,7	12,0	18,7	0,125	–	4	8	■
XSE550E12120D2CZ4	10138153	2	D	E12	12,0	11,7	14,4	22,1	0,15	–	4	10	■
XSE550E16160D2CZ4	10138154	2	D	E16	16,0	15,5	19,2	29,2	0,2	–	4	12	■
XSE550E20200D2CZ4	10138155	2	D	E20	20,0	19,3	24,0	34,3	0,25	–	4	16	■
XSE550E10100D1R100Z4	10219233	1	D	E10	10,0	9,7	5,5	12,3	–	1,0	4	8	■
XSE550E10100D1R200Z4	10219234	1	D	E10	10,0	9,7	5,5	12,3	–	2,0	4	8	■
XSE550E12120D1R100Z4	10219235	1	D	E12	12,0	11,7	6,6	14,4	–	1,0	4	10	■
XSE550E12120D1R200Z4	10219236	1	D	E12	12,0	11,7	6,6	14,4	–	2,0	4	10	■
XSE550E16160D1R100Z4	10219237	1	D	E16	16,0	15,5	8,8	18,6	–	1,0	4	12	■
XSE550E16160D1R200Z4	10219238	1	D	E16	16,0	15,5	8,8	18,6	–	2,0	4	12	■
XSE550E20200D1R200Z4	10219239	1	D	E20	20,0	19,7	11,0	21,2	–	2,0	4	16	■
XSE550E25250D1R100Z4	10219227	1	D	E25	25,0	24,2	13,75	25,5	–	1,0	4	20	■
XSE550E25250D1R200Z4	10219228	1	D	E25	25,0	24,2	13,75	25,5	–	2,0	4	20	■
XSE550E10100D1R050Z4	10138156	1	D	E10	10,0	9,7	5,5	12,3	–	0,5	4	8	■
XSE550E12120D1R050Z4	10138157	1	D	E12	12,0	11,7	6,6	14,4	–	0,5	4	10	■
XSE550E16160D1R050Z4	10138158	1	D	E16	16,0	15,5	8,8	18,6	–	0,5	4	12	■
XSE550E20200D1R100Z4	10138159	1	D	E20	20,0	19,3	11,0	21,2	–	1,0	4	16	■
XSE550E10100D2R100Z4	10138161	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	4	8	■
XSE550E12120D2R100Z4	10138165	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	4	10	■
XSE550E16160D2R100Z4	10138169	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	4	12	■
XSE550E20200D2R100Z4	10138172	2	D	E20	20,0	19,3	24,0	34,3	–	1,0	4	16	■
XSE550E10100D2R050Z4	10138160	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	4	8	■
XSE550E10100D2R200Z4	10138162	2	D	E10	10,0	9,7	12,0	18,7	–	2,0	4	8	■
XSE550E10100D2R250Z4	10138163	2	D	E10	10,0	9,7	12,0	18,7	–	2,5	4	8	■

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E12120D2R050Z4	10138164	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	4	10	■
XSE550E12120D2R200Z4	10138166	2	D	E12	12,0	11,7	14,4	22,1	–	2,0	4	10	■
XSE550E12120D2R300Z4	10138167	2	D	E12	12,0	11,7	14,4	22,1	–	3,0	4	10	■
XSE550E16160D2R050Z4	10138168	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	4	12	■
XSE550E16160D2R200Z4	10138170	2	D	E16	16,0	15,5	19,2	29,2	–	2,0	4	12	■
XSE550E16160D2R300Z4	10138171	2	D	E16	16,0	15,5	19,2	29,2	–	3,0	4	12	■
XSE550E20200D2R200Z4	10138173	2	D	E20	20,0	19,3	24,0	34,3	–	2,0	4	16	■
XSE550E20200D2R300Z4	10138174	2	D	E20	20,0	19,3	24,0	34,3	–	3,0	4	16	■
XSE550E20200D2R400Z4	10138175	2	D	E20	20,0	19,3	24,0	34,3	–	4,0	4	16	■

■ Stocked standard.

XSE550 – Inch

High performance – Universal – Square – 4 Flutes – Corner radius – *Inch*



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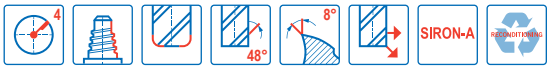


- Tolerances:
- DC= e7
- RE= ±.0008 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D1R030Z4	10138176	1	D	E10	0.375	0.364	0.206	0.484	0.030	4	8	■
XSE550E12.500D1R030Z4	10138177	1	D	E12	0.500	0.484	0.275	0.567	0.030	4	10	■
XSE550E20.750D1R030Z4	10138178	1	D	E20	0.750	0.728	0.413	0.835	0.030	4	16	■
XSE550E10.375D2R030Z4	10138179	2	D	E10	0.375	0.364	0.450	0.720	0.030	4	8	■
XSE550E12.500D2R030Z4	10138180	2	D	E12	0.500	0.484	0.600	0.906	0.030	4	10	■
XSE550E20.750D2R030Z4	10138181	2	D	E20	0.750	0.728	0.900	1.295	0.030	4	16	■

■ Stocked standard.

Seco

Cutting data – XSE550 – Side milling PCEDC 4

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	165 (130 — 200) *540 (430 — 650)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	145 (110 — 180) *475 (370 — 590)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	130 (97 — 160) *425 (320 — 520)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	125 (93 — 150) *410 (310 — 490)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 170) *460 (370 — 550)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	130 (98 — 160) *425 (330 — 520)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	120 (91 — 150) *395 (300 — 490)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	85 (72 — 100) *280 (240 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	55 (46 — 68) *180 (160 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	95 (83 — 120) *310 (280 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	80 (69 — 100) *260 (230 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	47 (36 — 58) *155 (120 — 190)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	36 (28 — 45) *120 (92 — 140)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	30 (23 — 37) *100 (76 — 120)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	130 (120 — 150) *425 (400 — 490)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	110 (96 — 120) *360 (320 — 390)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	105 (92 — 120) *345 (310 — 390)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	550 (450 — 660) *1800 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	355 (290 — 420) *1175 (960 — 1300)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	240 (200 — 280) *790 (660 — 910)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	310 (280 — 380) *1025 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	32 (26 — 40) *105 (86 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	28 (21 — 34) *90 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	24 (19 — 30) *80 (63 — 98)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	90 (77 — 120) *295 (260 — 390)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	70 (59 — 93) *230 (200 — 300)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	55 (47 — 74) *180 (160 — 240)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	275 (170 — 380) *900 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	550 (450 — 660) *1800 (1500 — 2100)*

Cutting data – XSE550 – Slot milling PCEDC 4

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	75 (64 — 94) *245 (210 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	44 (38 — 55) *145 (130 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 110) *280 (250 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	70 (60 — 90) *230 (200 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	40 (30 — 50) *130 (99 — 160)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	30 (23 — 37) *100 (76 — 120)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	25 (19 — 31) *80 (63 — 100)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	105 (88 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	100 (84 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	320 (260 — 380) *1050 (860 — 1200)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	215 (180 — 250) *710 (600 — 820)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	280 (250 — 340) *920 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	80 (65 — 100) *260 (220 — 320)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	60 (50 — 79) *195 (170 — 250)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	46 (39 — 61) *150 (130 — 200)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	500 (410 — 590) *1650 (1400 — 1900)*

Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

Cutting data – XSE550 – Side milling PCEDC 4 inch

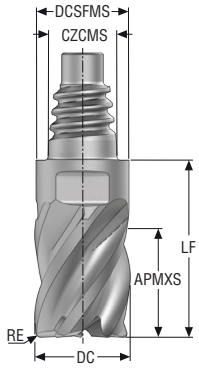
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	150 (140 — 170) *490 (460 — 550)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	95 (84 — 100) *310 (280 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	60 (54 — 68) *195 (180 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	110 (97 — 120) *360 (320 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	90 (80 — 100) *295 (270 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (47 — 70) *195 (160 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (37 — 54) *150 (130 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	38 (31 — 45) *125 (110 — 140)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	160 (160 — 190) *520 (530 — 620)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	140 (140 — 170) *460 (460 — 550)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	120 (120 — 140) *395 (400 — 450)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	115 (110 — 130) *375 (370 — 420)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 490) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
GR1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*

Cutting data – XSE550 – Slot milling PCEDC 4 inch

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (44 — 55) *165 (150 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	80 (70 — 90) *260 (230 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (40 — 60) *165 (140 — 190)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (150 — 180) *490 (500 — 590)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 350) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*

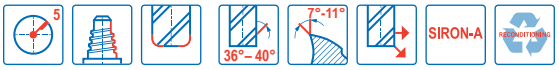
XSE550

High performance – Universal – Square – 5 Flutes – Corner radius



D

- Tolerances:
- DC= 0/-0,0508 mm
- RE= ±0,0254 mm
- Regrind possible if DC is ≥Ø12 mm

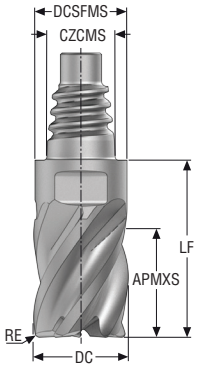


Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D2R050Z5	10138337	2	D	E10	10,0	9,7	12,0	18,7	0,5	5	8	■
XSE550E10100D2R100Z5	10138338	2	D	E10	10,0	9,7	12,0	18,7	1,0	5	8	■
XSE550E12120D2R050Z5	10138339	2	D	E12	12,0	11,7	14,4	22,1	0,5	5	10	■
XSE550E12120D2R100Z5	10138340	2	D	E12	12,0	11,7	14,4	22,1	1,0	5	10	■
XSE550E16160D2R050Z5	10138341	2	D	E16	16,0	15,5	19,2	29,2	0,5	5	12	■
XSE550E16160D2R100Z5	10138342	2	D	E16	16,0	15,5	19,2	29,2	1,0	5	12	■
XSE550E20200D2R050Z5	10138343	2	D	E20	20,0	19,3	24,0	34,3	0,5	5	16	■
XSE550E20200D2R100Z5	10138344	2	D	E20	20,0	19,3	24,0	34,3	1,0	5	16	■

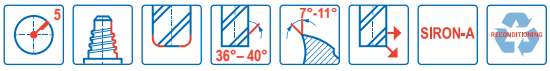
■ Stocked standard.

XSE550

High performance – Universal – Square – 5 Flutes – Corner radius – *Inch*



D



- Tolerances:
- DC= 0/-.002 Inch
- RE= ±.001 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XSE550E10.375D2R015Z5	10138345	2	D	E10	0.375	0.364	0.450	0.720	0.015	5	8	■
XSE550E10.375D2R030Z5	10138346	2	D	E10	0.375	0.364	0.450	0.720	0.030	5	8	■
XSE550E10.375D2R045Z5	10138347	2	D	E10	0.375	0.364	0.450	0.720	0.044	5	8	■
XSE550E12.500D2R030Z5	10138348	2	D	E12	0.500	0.484	0.600	0.906	0.030	5	10	■
XSE550E12.500D2R060Z5	10138349	2	D	E12	0.500	0.484	0.600	0.906	0.060	5	10	■
XSE550E12.500D2R120Z5	10138350	2	D	E12	0.500	0.484	0.600	0.906	0.120	5	10	■
XSE550E16.625D2R030Z5	10138351	2	D	E16	0.625	0.610	0.750	1.150	0.030	5	12	■
XSE550E16.625D2R060Z5	10138352	2	D	E16	0.625	0.610	0.750	1.150	0.060	5	12	■
XSE550E16.625D2R120Z5	10138353	2	D	E16	0.625	0.610	0.750	1.150	0.120	5	12	■
XSE550E20.750D2R030Z5	10138354	2	D	E20	0.750	0.728	0.900	1.295	0.030	5	16	■
XSE550E20.750D2R060Z5	10138355	2	D	E20	0.750	0.728	0.900	1.295	0.060	5	16	■
XSE550E20.750D2R120Z5	10138356	2	D	E20	0.750	0.728	0.900	1.295	0.120	5	16	■
XSE550E251.00D2R030Z5	10138357	2	D	E25	1.000	0.965	1.200	1.673	0.030	5	20	■
XSE550E251.00D2R060Z5	10138358	2	D	E25	1.000	0.965	1.200	1.673	0.060	5	20	■
XSE550E251.00D2R120Z5	10138359	2	D	E25	1.000	0.965	1.200	1.673	0.120	5	20	■

■ Stocked standard.

Universal
Steel and cast iron
Stainless steel and S-materials
Non ferrous
Hard
Plastic and cfrp
Graphite
X-Heads
Minimaster Plus
Minimaster

Cutting data – XSE550 – Side milling PCEDC 5

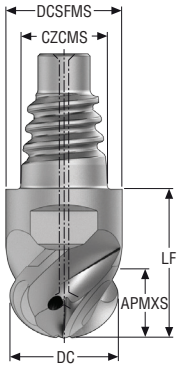
SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	165 (130 — 190) *540 (430 — 620)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	160 (130 — 190) *520 (430 — 620)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 160) *460 (370 — 520)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	125 (97 — 140) *410 (320 — 450)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	110 (97 — 130) *360 (320 — 420)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 150) *410 (370 — 490)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	110 (97 — 130) *360 (320 — 420)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	130 (120 — 150) *425 (400 — 490)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	115 (98 — 130) *375 (330 — 420)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	100 (83 — 110) *330 (280 — 360)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	95 (79 — 100) *310 (260 — 320)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	105 (89 — 130) *345 (300 — 420)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	155 (130 — 190) *510 (430 — 620)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	135 (120 — 160) *445 (400 — 520)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	27 (24 — 41) *90 (79 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	26 (21 — 35) *85 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	25 (19 — 30) *80 (63 — 98)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	65 (52 — 88) *215 (180 — 280)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	50 (40 — 68) *165 (140 — 220)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	41 (32 — 54) *135 (110 — 170)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
GR1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	520 (470 — 630) *1700 (1600 — 2000)*

Cutting data – XSE550 – Side milling PCEDC 5 inch

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	165 (160 — 190) *540 (530 — 620)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (140 — 170) *475 (460 — 550)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	125 (120 — 140) *410 (400 — 450)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	120 (110 — 140) *395 (370 — 450)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	200 (170 — 220) *660 (560 — 720)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	44 (27 — 61) *145 (89 — 200)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	35 (22 — 49) *115 (73 — 160)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	31 (19 — 43) *100 (63 — 140)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	105 (75 — 130) *345 (250 — 420)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (58 — 100) *260 (200 — 320)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	65 (46 — 81) *215 (160 — 260)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
GR1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*

XSB540

High performance – Universal – Ball nose – 4 Flutes – ICC



D

- Tolerances:
- DC= e8
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CSP	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
						mm	mm	mm	mm			SIRA
XSB540E10100D1BZ4A	10138334	1	D	✓	E10	10,0	9,7	5,5	12,3	4	8	■
XSB540E12120D1BZ4A	10138335	1	D	✓	E12	12,0	11,7	6,6	14,4	4	10	■
XSB540E16160D1BZ4A	10138336	1	D	✓	E16	16,0	15,5	8,8	18,6	4	12	■

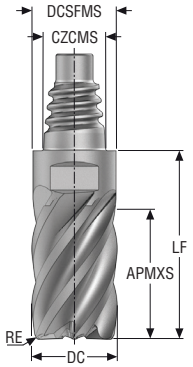
■ Stocked standard.

Cutting data – XSB540 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	190 (160 — 220) *620 (530 — 720)*
P12	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M1	E/M/A	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	145 (120 — 170) *475 (400 — 550)*
M2	E/M/A	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M3	E/M/A	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	95 (75 — 110) *310 (250 — 360)*
M4	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	75 (57 — 88) *245 (190 — 280)*
M5	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	60 (48 — 74) *195 (160 — 240)*
K1	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	205 (190 — 220) *670 (630 — 720)*
K2	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	180 (160 — 190) *590 (530 — 620)*
K3	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	150 (140 — 160) *490 (460 — 520)*
K4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	170 (150 — 190) *560 (500 — 620)*
K5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	105 (90 — 110) *345 (300 — 360)*
K6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	150 (140 — 160) *490 (460 — 520)*
K7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	130 (120 — 140) *425 (400 — 450)*
N1	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	640 (540 — 740) *2100 (1800 — 2400)*
N2	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	415 (350 — 480) *1350 (1200 — 1500)*
N3	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	275 (230 — 320) *900 (760 — 1000)*
N11	E/M/A	0,15 *0.15*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	430 (380 — 480) *1400 (1300 — 1500)*
S1	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (54 — 74) *215 (180 — 240)*
S2	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (59 — 75) *215 (200 — 240)*
S3	E	0,10 *0.10*	0,50 *0.50*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	32 (22 — 42) *105 (73 — 130)*
S11	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	110 (98 — 120) *360 (330 — 390)*
S12	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 96) *280 (250 — 310)*
S13	E	0,15 *0.15*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	65 (59 — 75) *215 (200 — 240)*
H5	M/A	0,030 *0.030*	0,44 *0.44*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
H8	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H21	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H31	M/A	0,030 *0.030*	0,44 *0.44*	0,034 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	100 (86 — 110) *330 (290 — 360)*
TS1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*
TP1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*
GR1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	640 (540 — 740) *2100 (1800 — 2400)*

XSE720

High performance – Superalloy – Square – 6 Flutes – Corner radius



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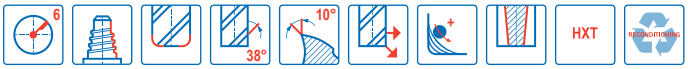


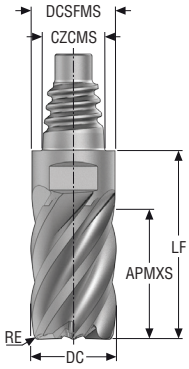
- Tolerances:
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			HXT
XSE720E10100D3R050Z6	10138187	3	D	E10	10,0	9,7	15,0	21,8	0,5	6	8	■
XSE720E10100D3R100Z6	10138188	3	D	E10	10,0	9,7	15,0	21,8	1,0	6	8	■
XSE720E12120D3R050Z6	10138189	3	D	E12	12,0	11,7	18,0	25,9	0,5	6	10	■
XSE720E12120D3R100Z6	10138190	3	D	E12	12,0	11,7	18,0	25,9	1,0	6	10	■
XSE720E12120D3R200Z6	10138191	3	D	E12	12,0	11,7	18,0	25,9	2,0	6	10	■
XSE720E12120D3R300Z6	10138192	3	D	E12	12,0	11,7	18,0	25,9	3,0	6	10	■
XSE720E16160D3R050Z6	10138193	3	D	E16	16,0	15,5	24,0	34,1	0,5	6	12	■
XSE720E16160D3R100Z6	10138194	3	D	E16	16,0	15,5	24,0	34,1	1,0	6	12	■
XSE720E16160D3R200Z6	10138195	3	D	E16	16,0	15,5	24,0	34,1	2,0	6	12	■
XSE720E16160D3R300Z6	10138196	3	D	E16	16,0	15,5	24,0	34,1	3,0	6	12	■
XSE720E20200D3R050Z6	10138197	3	D	E20	20,0	19,3	30,0	40,2	0,5	6	16	■
XSE720E20200D3R100Z6	10138198	3	D	E20	20,0	19,3	30,0	40,2	1,0	6	16	■
XSE720E20200D3R200Z6	10138199	3	D	E20	20,0	19,3	30,0	40,2	2,0	6	16	■
XSE720E20200D3R300Z6	10138200	3	D	E20	20,0	19,3	30,0	40,2	3,0	6	16	■
XSE720E25250D3R200Z6	10138201	3	D	E25	25,0	24,2	37,5	49,5	2,0	6	20	■
XSE720E25250D3R300Z6	10138202	3	D	E25	25,0	24,2	37,5	49,5	3,0	6	20	■
XSE720E25250D3R400Z6	10138203	3	D	E25	25,0	24,2	37,5	49,5	4,0	6	20	■

■ Stocked standard.

XSE720

High performance – Superalloy – Square – 6 Flutes – Corner radius or sharp – *Inch*



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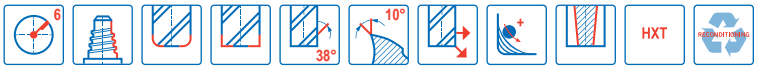


- Tolerances:
- DC= e7
- RE= ±.0008 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			HXT
XSE720E10.375D3SZ6	10138204	3	D	E10	0.375	0.364	0.563	0.827	–	6	8	■
XSE720E12.500D3SZ6	10138205	3	D	E12	0.500	0.484	0.750	1.055	–	6	10	■
XSE720E16.625D3SZ6	10138206	3	D	E16	0.625	0.610	0.938	1.343	–	6	12	■
XSE720E20.750D3SZ6	10138207	3	D	E20	0.750	0.728	1.125	1.524	–	6	16	■
XSE720E251.00D3SZ6	10138208	3	D	E25	1.000	0.965	1.500	1.980	–	6	20	■
XSE720E10.375D3R030Z6	10138209	3	D	E10	0.375	0.364	0.563	0.827	0.030	6	8	■
XSE720E12.500D3R030Z6	10138210	3	D	E12	0.500	0.484	0.750	1.055	0.030	6	10	■
XSE720E12.500D3R060Z6	10138211	3	D	E12	0.500	0.484	0.750	1.055	0.060	6	10	■
XSE720E12.500D3R120Z6	10138212	3	D	E12	0.500	0.484	0.750	1.055	0.120	6	10	■
XSE720E16.625D3R030Z6	10138213	3	D	E16	0.625	0.610	0.938	1.343	0.030	6	12	■
XSE720E16.625D3R060Z6	10138214	3	D	E16	0.625	0.610	0.938	1.343	0.060	6	12	■
XSE720E16.625D3R120Z6	10138215	3	D	E16	0.625	0.610	0.938	1.343	0.120	6	12	■
XSE720E20.750D3R030Z6	10138216	3	D	E20	0.750	0.728	1.125	1.524	0.030	6	16	■
XSE720E20.750D3R060Z6	10138217	3	D	E20	0.750	0.728	1.125	1.524	0.060	6	16	■
XSE720E20.750D3R120Z6	10138218	3	D	E20	0.750	0.728	1.125	1.524	0.120	6	16	■
XSE720E251.00D3R030Z6	10138219	3	D	E25	1.000	0.965	1.500	1.980	0.030	6	20	■
XSE720E251.00D3R060Z6	10138220	3	D	E25	1.000	0.965	1.500	1.980	0.060	6	20	■
XSE720E251.00D3R120Z6	10138221	3	D	E25	1.000	0.965	1.500	1.980	0.120	6	20	■

■ Stocked standard.

Seco

Cutting data – XSE720 Side milling

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	230 (180 — 280) *750 (600 — 910)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 230) *640 (500 — 750)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	170 (130 — 200) *560 (430 — 650)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	130 (100 — 160) *425 (330 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (120 — 190) *475 (400 — 620)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 180) *460 (370 — 590)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	130 (100 — 160) *425 (330 — 520)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	130 (110 — 170) *425 (370 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 130) *395 (330 — 420)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 100) *295 (260 — 320)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 88) *245 (210 — 280)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XSE720 advanced roughing

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	245 (190 — 300) *800 (630 — 980)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	240 (190 — 290) *790 (630 — 950)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	205 (160 — 250) *670 (530 — 820)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	185 (140 — 220) *610 (460 — 720)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 180) *460 (370 — 590)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (130 — 200) *510 (430 — 650)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (120 — 190) *490 (400 — 620)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	140 (110 — 180) *460 (370 — 590)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	140 (110 — 180) *460 (370 — 590)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 140) *410 (370 — 450)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 110) *310 (270 — 360)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 92) *260 (220 — 300)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – XSE720 Side milling inch

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	265 (200 — 320) *870 (660 — 1000)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	255 (200 — 320) *840 (660 — 1000)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (170 — 270) *740 (560 — 880)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	195 (150 — 240) *640 (500 — 780)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	160 (120 — 190) *520 (400 — 620)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	180 (140 — 220) *590 (460 — 720)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	170 (130 — 210) *560 (430 — 680)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	160 (120 — 190) *520 (400 — 620)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	160 (130 — 200) *520 (430 — 650)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 110) *395 (330 — 360)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 91) *295 (260 — 290)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 76) *245 (210 — 240)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

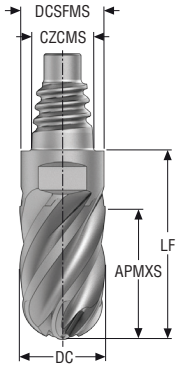
Cutting data – XSE720 advanced roughing inch

SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	285 (220 — 350) *940 (730 — 1100)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	275 (210 — 340) *900 (690 — 1100)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	240 (180 — 290) *790 (600 — 950)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	210 (160 — 260) *690 (530 — 850)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	175 (130 — 210) *570 (430 — 680)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 240) *640 (500 — 780)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	185 (140 — 220) *610 (460 — 720)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	170 (130 — 210) *560 (430 — 680)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 120) *410 (370 — 390)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 95) *310 (270 — 310)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 79) *260 (220 — 250)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

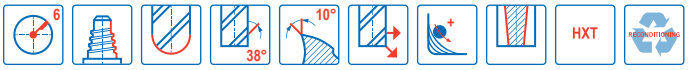
XSB720

High performance – Superalloy – Ball nose – 6 Flutes



D

- Tolerances:
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø12 mm

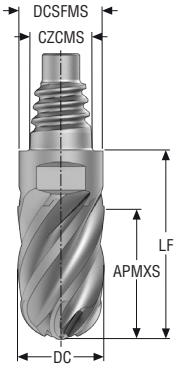


Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
					mm	mm	mm	mm			HXT
XSB720E10100D3BZ6	10138222	3	D	E10	10,0	9,7	15,0	21,8	6	8	■
XSB720E12120D3BZ6	10138223	3	D	E12	12,0	11,7	18,0	25,9	6	10	■
XSB720E16160D3BZ6	10138224	3	D	E16	16,0	15,5	24,0	34,1	6	12	■
XSB720E20200D3BZ6	10138225	3	D	E20	20,0	19,3	30,0	40,2	6	16	■

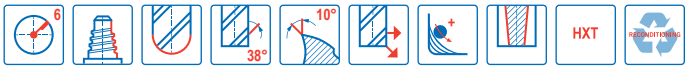
■ Stocked standard.

XSB720

High performance – Superalloy – Ball nose – 6 Flutes – *Inch*



D



- Tolerances:
- DC= e7
- RE= ±.0008 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*			HXT
XSB720E10.375D3BZ6	10138226	3	D	E10	0.375	0.364	0.563	0.827	6	8	■
XSB720E12.500D3BZ6	10138227	3	D	E12	0.500	0.484	0.750	1.055	6	10	■
XSB720E16.625D3BZ6	10138228	3	D	E16	0.625	0.610	0.938	1.343	6	12	■
XSB720E20.750D3BZ6	10138229	3	D	E20	0.750	0.728	1.125	1.524	6	16	■
XSB720E251.00D3BZ6	10138230	3	D	E25	1.000	0.965	1.500	1.980	6	20	■

■ Stocked standard.

Seco

Cutting data – XSB720 Side milling

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	185 (150 — 140) *610 (500 — 450)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	175 (140 — 130) *570 (460 — 420)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	155 (120 — 110) *510 (400 — 360)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	135 (110 — 100) *445 (370 — 320)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	130 (110 — 100) *425 (370 — 320)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (120 — 110) *475 (400 — 360)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 100) *460 (370 — 320)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	130 (99 — 98) *425 (330 — 320)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	140 (110 — 100) *460 (370 — 320)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	85 (68 — 67) *280 (230 — 210)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	140 (120 — 160) *460 (400 — 520)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	120 (110 — 140) *395 (370 — 450)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	90 (77 — 100) *295 (260 — 320)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	75 (65 — 89) *245 (220 — 290)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	35 (5 — 45) *115 (17 — 140)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (47 — 77) *195 (160 — 250)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XSB720 Side milling advanced roughing a_e/DC=0,07

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	195 (160 — 150) *640 (530 — 490)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	190 (150 — 140) *620 (500 — 450)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	165 (130 — 120) *540 (430 — 390)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	145 (120 — 110) *475 (400 — 360)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	140 (110 — 100) *460 (370 — 320)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (130 — 120) *520 (430 — 390)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	150 (120 — 110) *490 (400 — 360)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	140 (110 — 100) *460 (370 — 320)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (120 — 110) *490 (400 — 360)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	95 (73 — 72) *310 (240 — 230)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	185 (160 — 200) *610 (530 — 650)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	125 (110 — 140) *410 (370 — 450)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (81 — 110) *310 (270 — 360)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	80 (68 — 93) *260 (230 — 300)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	35 (5 — 45) *115 (17 — 140)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	65 (49 — 81) *215 (170 — 260)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Seco

Cutting data – XSB720 Side milling inch

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	95 (81 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	180 (140 — 220) *590 (460 — 720)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	160 (120 — 200) *520 (400 — 650)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	125 (93 — 150) *410 (310 — 490)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	105 (77 — 120) *345 (260 — 390)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

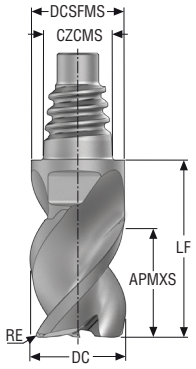
Cutting data – XSB720 Side milling advanced roughing a_e/DC=0,07 inch

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	235 (190 — 280) *770 (630 — 910)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (160 — 230) *640 (530 — 750)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	170 (130 — 200) *560 (430 — 650)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	105 (81 — 130) *345 (270 — 420)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

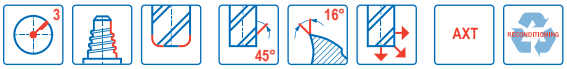
XSE450

High performance – Aluminium – Square – 3 Flutes – Corner radius



D

- Tolerances:
- DC= 0/-0,0508 mm
- RE= ±0,0254 mm
- Regrind possible if DC is ≥Ø12 mm

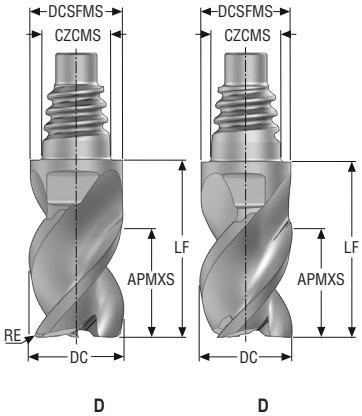


Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			AXT
XSE450E10100D2R050Z3	10138362	2	D	E10	10,0	9,7	12,0	18,7	0,5	3	8	■
XSE450E12120D2R050Z3	10138363	2	D	E12	12,0	11,7	14,4	22,1	0,5	3	10	■
XSE450E12120D2R100Z3	10138364	2	D	E12	12,0	11,7	14,4	22,1	1,0	3	10	■
XSE450E16160D2R050Z3	10138365	2	D	E16	16,0	15,5	19,2	29,2	0,5	3	12	■
XSE450E16160D2R100Z3	10138366	2	D	E16	16,0	15,5	19,2	29,2	1,0	3	12	■
XSE450E20200D2R050Z3	10138367	2	D	E20	20,0	19,3	24,0	34,3	0,5	3	16	■
XSE450E20200D2R100Z3	10138369	2	D	E20	20,0	19,3	24,0	34,3	1,0	3	16	■

■ Stocked standard.

XSE450

High performance – Aluminium – Square – 3 Flutes – Corner radius – *Inch*



- Tolerances:
- DC= 0/-.002 Inch
- RE= ±.001 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			AXT
XSE450E10.375D2SZ3	10138370	2	D	E10	0.375	0.364	0.450	0.720	–	3	8	■
XSE450E12.500D2SZ3	10138371	2	D	E12	0.500	0.484	0.600	0.906	–	3	10	■
XSE450E16.625D2SZ3	10138372	2	D	E16	0.625	0.610	0.750	1.150	–	3	12	■
XSE450E20.750D2SZ3	10138373	2	D	E20	0.750	0.728	0.900	1.295	–	3	16	■
XSE450E251.00D2SZ3	10138374	2	D	E25	1.000	0.965	1.200	1.673	–	3	20	■
XSE450E10.375D2R030Z3	10138375	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8	■
XSE450E12.500D2R030Z3	10138376	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10	■
XSE450E12.500D2R060Z3	10138377	2	D	E12	0.500	0.484	0.600	0.906	0.060	3	10	■
XSE450E16.625D2R030Z3	10138378	2	D	E16	0.625	0.610	0.750	1.150	0.030	3	12	■
XSE450E16.625D2R060Z3	10138379	2	D	E16	0.625	0.610	0.750	1.150	0.060	3	12	■
XSE450E16.625D2R120Z3	10138380	2	D	E16	0.625	0.610	0.750	1.150	0.120	3	12	■
XSE450E20.750D2R030Z3	10138381	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16	■
XSE450E20.750D2R060Z3	10138382	2	D	E20	0.750	0.728	0.900	1.295	0.060	3	16	■
XSE450E20.750D2R120Z3	10138383	2	D	E20	0.750	0.728	0.900	1.295	0.120	3	16	■
XSE450E251.00D2R030Z3	10138384	2	D	E25	1.000	0.965	1.200	1.673	0.030	3	20	■
XSE450E251.00D2R060Z3	10138385	2	D	E25	1.000	0.965	1.200	1.673	0.060	3	20	■
XSE450E251.00D2R120Z3	10138386	2	D	E25	1.000	0.965	1.200	1.673	0.120	3	20	■

■ Stocked standard.

Cutting data – XSE450 Side milling

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20		
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	405 (340 — 450) *1325 (1200 — 1400)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	275 (230 — 330) *900 (760 — 1000)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	185 (150 — 220) *610 (500 — 720)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	245 (200 — 290) *800 (660 — 950)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*

Cutting data – XSE450 Slot milling

SMG		a_p/DC	f_z					v_c
			10	12	16	20		
N1	E/M/A	0,90 *0.90*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	360 (310 — 410) *1175 (1100 — 1300)*
N2	E/M/A	0,90 *0.90*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	250 (200 — 300) *820 (660 — 980)*
N3	E/M/A	0,90 *0.90*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	165 (140 — 200) *540 (460 — 650)*
N11	E/M/A	0,90 *0.90*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	220 (180 — 260) *720 (600 — 850)*
TS1	A/D	0,90 *0.90*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,90 *0.90*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XSE450 Side milling inch

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	295 (230 — 360) *970 (760 — 1100)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	395 (300 — 490) *1300 (990 — 1600)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*

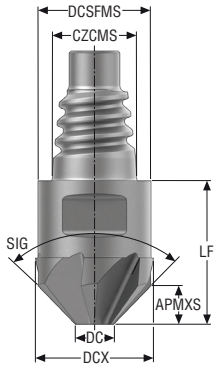
Cutting data – XSE450 Slot milling inch

SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
N1	E/M/A	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	500 (400 — 590) *1650 (1400 — 1900)*
N2	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	400 (300 — 490) *1300 (990 — 1600)*
N3	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	265 (200 — 330) *870 (660 — 1000)*
N11	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	355 (270 — 440) *1175 (890 — 1400)*
TS1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

XSC509

High performance – Universal – Chamfer – 6 Flutes



N

- Tolerances:
- SIG= ±1°

Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	SIG°	PCEDC	SW	Grade
					mm	mm	mm	mm	mm				SIRA
XSC509E10100N1SZ6	10219277	1	N	E10	10,1	1,95	9,7	4,0	12,3	90,0	6	8	■
XSC509E12120N1SZ6	10219278	1	N	E12	12,1	2,95	11,7	4,5	14,4	90,0	6	10	■
XSC509E16160N1SZ6	10219279	1	N	E16	16,1	3,95	15,5	6,0	18,6	90,0	6	12	■

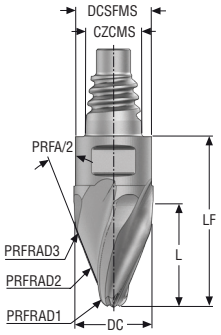
■ Stocked standard.

Cutting data – XSC509 Chamfering

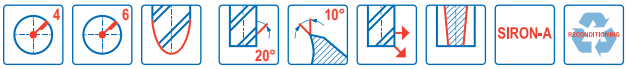
SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,09 *0.0035*	0,11 *0.0043*	275 (135 — 310) *900 (440 — 1010)*
P2	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,09 *0.0035*	0,11 *0.0043*	270 (130 — 300) *890 (425 — 975)*
P3	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,09 *0.0035*	0,11 *0.0043*	235 (110 — 260) *770 (370 — 850)*
P4	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,085 *0.0035*	0,1 *0.0039*	220 (105 — 250) *720 (350 — 810)*
P5	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,085 *0.0035*	0,1 *0.0039*	200 (95 — 220) *660 (310 — 715)*
P6	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,055 *0.0022*	0,08 *0.0031*	0,1 *0.0039*	200 (95 — 220) *660 (310 — 715)*
P7	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,055 *0.0022*	0,08 *0.0031*	0,1 *0.0039*	200 (95 — 220) *660 (310 — 715)*
P8	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,055 *0.0022*	0,08 *0.0031*	0,1 *0.0039*	200 (95 — 220) *660 (310 — 715)*
P11	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,055 *0.0022*	0,08 *0.0031*	0,1 *0.0039*	180 (80 — 200) *590 (270 — 650)*
P12	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,08 *0.0022*	0,07 *0.0028*	130 (60 — 140) *425 (200 — 460)*
M1	E/M/A	0,20 *0.20*	0,30 *0.30*	0,065 *0.0026*	0,09 *0.0035*	0,11 *0.0043*	220 (100 — 240) *720 (330 — 790)*
M2	E/M/A	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.00314*	0,1 *0.0039*	180 (80 — 200) *590 (270 — 650)*
M3	E/M/A	0,20 *0.20*	0,30 *0.30*	0,05 *0.0018*	0,07 *0.0026*	0,08 *0.0032*	145 (65 — 155) *475 (210 — 510)*
M4	E/M/A	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,06 *0.0022*	0,07 *0.0028*	110 (50 — 120) *360 (160 — 390)*
M5	E/M/A	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,06 *0.0022*	0,07 *0.0028*	90 (40 — 100) *295 (140 — 330)*
K1	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0039*	215 (100 — 235) *710 (340 — 770)*
K2	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0039*	190 (90 — 205) *620 (300 — 675)*
K3	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0039*	160 (75 — 175) *520 (250 — 570)*
K4	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0039*	150 (70 — 165) *490 (240 — 540)*
K5	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,05 *0.002*	0,075 *0.00295*	0,09 *0.00354*	80 (45 — 100) *260 (145 — 330)*
K6	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,06 *0.0024*	0,08 *0.00314*	0,1 *0.0039*	115 (65 — 145) *375 (210 —480)*
K7	E/M/A/D	0,20 *0.20*	0,30 *0.30*	0,05 *0.002*	0,075 *0.003*	0,09 *0.0036*	100 (60 — 130) *330 (190 — 425)*
N1	E/M/A	0,20 *0.20*	0,30 *0.30*	0,08 *0.003*	0,11 *0.0044*	0,14 *0.0055*	1250 (775— 1800) *4100 (2540 — 5900)*
N2	E/M/A	0,20 *0.20*	0,30 *0.30*	0,08 *0.003*	0,11 *0.0044*	0,14 *0.0055*	570 (310 — 720) *1870 (1020 — 2370)*
N3	E/M/A	0,20 *0.20*	0,30 *0.30*	0,08 *0.003*	0,11 *0.0044*	0,14 *0.0055*	380 (210 — 480) *1240 (680 — 1580)*
N11	E/M/A	0,20 *0.20*	0,30 *0.30*	0,08 *0.003*	0,11 *0.0044*	0,14 *0.0055*	610 (240 — 555) *2000 (780 — 1820)*
S1	E	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	30 (17 — 40) *100 (55 — 125)*
S2	E	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	24 (15 — 31) *80 (44 — 102)*
S3	E	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	21 (12 — 27) *70 (38 — 88)*
S11	E	0,20 *0.20*	0,30 *0.30*	0,05 *0.0018*	0,065 *0.0026*	0,08 *0.0032*	43 (25 — 55) *140 (80 — 180)*
S12	E	0,20 *0.20*	0,30 *0.30*	0,05 *0.0018*	0,065 *0.0026*	0,08 *0.0032*	33 (20 — 42) *108 (60 — 138)*
S13	E	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	26 (15 — 33) *85 (50 — 110)*
H5	M/A	0,20 *0.20*	0,30 *0.30*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	60 (30 — 70) *195 (105— 240)*
H8	M/A	0,20 *0.20*	0,30 *0.30*	0,03 *0.0012*	0,04 *0.0017*	0,06 *0.0022*	60 (30 — 70) *195 (105— 240)*
H21	M/A	0,20 *0.20*	0,30 *0.30*	0,03 *0.0012*	0,04 *0.0017*	0,06 *0.0022*	60 (30 — 70) *195 (105— 240)*
H31	M/A	0,20 *0.20*	0,30 *0.30*	0,03 *0.0012*	0,04 *0.0017*	0,06 *0.0022*	45 (25 — 55) *145 (80 — 185)*

XHT740

High speed – ISO– M and ISO– S - Taper Shape – 4-6 Flutes



- Tolerances:
- PRFRAD1= ±0,03 mm
- Form tolerance PRFRAD2= 0,02 mm
- Regrind possible if DC is ≥Ø12 mm and PRFRAD1 is ≥1,5 mm



Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	L	LF	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	SW	Grade
					mm	mm	mm	mm	mm	mm	mm				SIRA
XHT740E10100T2R1.5R250Z4	10138388	2	T	E10	10,0	9,7	5,4	18,7	1,5	250,0	2,0	65,0	4	8	■
XHT740E12120T2R3R250Z4	10138389	2	T	E12	12,0	11,7	10,5	22,1	3,0	250,0	6,0	32,5	4	10	■
XHT740E16160T2R4R500Z4	10138390	2	T	E16	16,0	15,5	14,6	29,2	4,0	500,0	8,0	27,5	4	12	■
XHT740E10100T3R2R250Z4	10138391	3	T	E10	10,0	9,7	12,7	21,8	2,0	250,0	5,0	20,0	4	8	■
XHT740E12120T3R3R250Z4	10138392	3	T	E12	12,0	11,7	13,7	25,9	3,0	250,0	6,0	20,0	4	10	■
XHT740E16160T3R4R1000Z4	10138394	3	T	E16	16,0	15,5	24,0	34,1	4,0	1000,0	5,0	20,0	4	12	■
XHT740E16160T3R4R500Z4	10138393	3	T	E16	16,0	15,5	17,6	34,1	4,0	500,0	8,0	20,0	4	12	■
XHT740E10100T3R2R250Z6	10138395	3	T	E10	10,0	9,7	12,7	21,8	2,0	250,0	5,0	20,0	6	8	■
XHT740E12120T3R3R250Z6	10138396	3	T	E12	12,0	11,7	13,7	25,9	3,0	250,0	6,0	20,0	6	10	■
XHT740E16160T3R4R500Z6	10138397	3	T	E16	16,0	15,5	17,6	34,1	4,0	500,0	8,0	20,0	6	12	■

■ Stocked standard.

Cutting data – XHT740 – Copy milling PCEDC 4

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

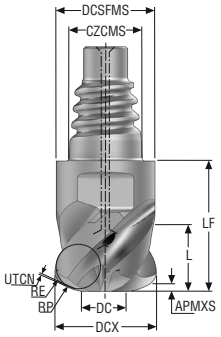
Cutting data – XHT740 – Copy milling PCEDC 6

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

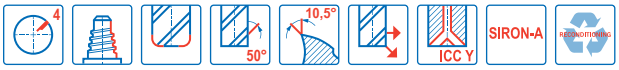
XHF580

High feed – Universal – 4 Flutes – Corner radius – ICC



D

- Tolerances:
- DCX= h9
- RE= ±0,03 mm
- Regrind possible if DCX is ≥Ø12 mm

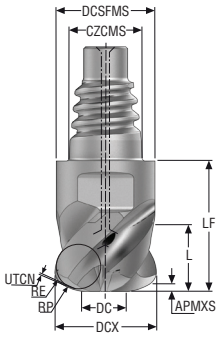


Designation	Item number	Length index	Tool shape	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Grades
						mm	mm	mm	mm	mm	mm	mm	mm	mm			SIRA
XHF580E10100D1HZ4A	10137971	1	D	✓	E10	10,0	3,4	9,7	0,7	6,0	12,4	1,5	1,99	0,27	4	8	■
XHF580E12120D1HZ4A	10137972	1	D	✓	E12	12,0	4,5	11,7	0,8	7,5	14,5	1,5	2,1	0,323	4	10	■
XHF580E16160D1HZ4A	10137973	1	D	✓	E16	16,0	6,2	15,5	1,0	10,0	18,7	2,0	2,747	0,426	4	12	■

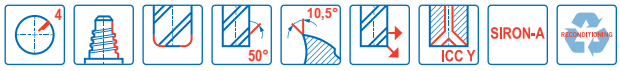
■ Stocked standard.

XHF580

High feed – Universal – 4 Flutes – Corner radius – ICC – *Inch*



D



- Tolerances:
- DCX= h9
- RE= ±.0012 Inch
- Regrind possible if DCX is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Grades
						Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XHF580E10.375D1HZ4A	10137974	1	D	✓	E10	0.375	0.134	0.364	0.024	0.236	0.488	0.060	0.076	0.008	4	8	■
XHF580E12.500D1HZ4A	10137975	1	D	✓	E12	0.500	0.197	0.484	0.033	0.315	0.571	0.060	0.086	0.014	4	10	■
XHF580E16.625D1HZ4A	10137976	1	D	✓	E16	0.614	0.236	0.610	0.039	0.394	0.736	0.080	0.110	0.016	4	12	■

■ Stocked standard.

Universal
Steel and cast iron
Stainless steel and S-materials
Non ferrous
Hard
Plastic and cfrp
Graphite
X-Heads
Minimaster Plus
Minimaster

Cutting data – XHF580 Side milling

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (330 — 400) *1150 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	340 (320 — 390) *1125 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (280 — 340) *970 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	190 (180 — 230) *620 (600 — 750)*
P7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	180 (170 — 220) *590 (560 — 720)*
P8	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	170 (160 — 200) *560 (530 — 650)*
P11	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	145 (150 — 170) *475 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (83 — 100) *280 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	170 (170 — 200) *560 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	140 (140 — 160) *460 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (97 — 130) *345 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	75 (73 — 99) *245 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	65 (61 — 83) *215 (210 — 270)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	345 (330 — 400) *1125 (1100 — 1300)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	300 (280 — 340) *980 (920 — 1100)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	250 (240 — 290) *820 (790 — 950)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	240 (230 — 280) *790 (760 — 910)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	145 (140 — 160) *475 (460 — 520)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	210 (200 — 240) *690 (660 — 780)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	185 (180 — 210) *610 (600 — 680)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	45 (36 — 71) *150 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	36 (29 — 57) *120 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	31 (25 — 49) *100 (83 — 160)*
S11	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	160 (160 — 190) *520 (530 — 620)*
S12	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	125 (120 — 150) *410 (400 — 490)*
S13	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	95 (91 — 110) *310 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	80 (74 — 100) *260 (250 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XHF580 Slot milling

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	320 (300 — 360) *1050 (990 — 1100)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (250 — 300) *870 (830 — 980)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	235 (220 — 270) *770 (730 — 880)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	235 (220 — 270) *770 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	175 (160 — 210) *570 (530 — 680)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	165 (150 — 200) *540 (500 — 650)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	155 (150 — 180) *510 (500 — 590)*
P11	E/M/A/D	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (130 — 160) *425 (430 — 520)*
P12	E/M/A/D	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (75 — 94) *260 (250 — 300)*
M1	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	155 (150 — 180) *510 (500 — 590)*
M2	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	125 (120 — 150) *410 (400 — 490)*
M3	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 110) *310 (290 — 360)*
M4	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (66 — 89) *230 (220 — 290)*
M5	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	60 (55 — 74) *195 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (300 — 360) *1025 (990 — 1100)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (260 — 310) *890 (860 — 1000)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	220 (210 — 250) *720 (690 — 820)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	130 (130 — 150) *425 (430 — 490)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	190 (180 — 220) *620 (600 — 720)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	165 (160 — 190) *540 (530 — 620)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	39 (32 — 62) *130 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (26 — 50) *100 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	27 (22 — 43) *90 (73 — 140)*
S11	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	150 (150 — 180) *490 (500 — 590)*
S12	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	115 (110 — 140) *375 (370 — 450)*
S13	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	90 (85 — 100) *295 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (67 — 91) *230 (220 — 290)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Universal
Steel and cast iron
Stainless steel and S-materials
Non ferrous
Hard
Plastic and cfrp
Graphite
X-Heads
Minimaster Plus
Minimaster

Cutting data – XHF580 Side milling inch

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	485 (440 — 530) *1600 (1500 — 1700)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	405 (370 — 450) *1325 (1300 — 1400)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P5	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P6	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
P7	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	280 (250 — 300) *920 (830 — 980)*
P8	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P11	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (140 — 170) *520 (460 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	185 (170 — 200) *610 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 99) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 82) *230 (210 — 260)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	415 (370 — 450) *1350 (1300 — 1400)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (320 — 380) *1150 (1100 — 1200)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	335 (300 — 370) *1100 (990 — 1200)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	200 (180 — 220) *660 (600 — 720)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	255 (230 — 280) *840 (760 — 910)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	170 (150 — 190) *560 (500 — 620)*
S12	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	130 (120 — 140) *425 (400 — 450)*
S13	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	100 (89 — 110) *330 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (74 — 100) *295 (250 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

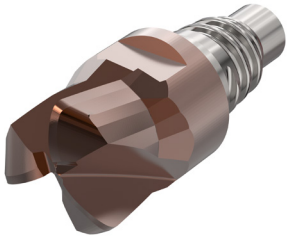
Cutting data – XHF580 Slot milling inch

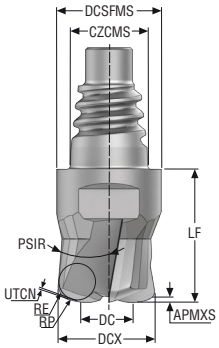
SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	440 (400 — 480) *1450 (1400 — 1500)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 470) *1400 (1300 — 1500)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	370 (330 — 400) *1225 (1100 — 1300)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 360) *1075 (960 — 1100)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	275 (250 — 300) *900 (830 — 980)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (240 — 280) *850 (790 — 910)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P11	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	85 (75 — 94) *280 (250 — 300)*
M1	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	170 (150 — 180) *560 (500 — 590)*
M2	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	135 (120 — 150) *445 (400 — 490)*
M3	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 110) *345 (290 — 360)*
M4	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (66 — 89) *260 (220 — 290)*
M5	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (55 — 74) *215 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 480) *1400 (1300 — 1500)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	375 (340 — 410) *1225 (1200 — 1300)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	305 (270 — 330) *1000 (890 — 1000)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	180 (170 — 200) *590 (560 — 650)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (240 — 290) *870 (790 — 950)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (210 — 250) *750 (690 — 820)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	47 (32 — 62) *155 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (26 — 50) *125 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	32 (22 — 43) *105 (73 — 140)*
S11	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	160 (150 — 180) *520 (500 — 590)*
S12	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	125 (110 — 140) *410 (370 — 450)*
S13	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (84 — 100) *310 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (67 — 91) *260 (220 — 290)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

XHF780

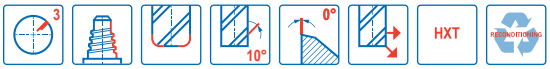
High feed – ISO– M and ISO– S – 3 Flutes – Corner radius





D

- Tolerances:
- DCX= -0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible if DCX is ≥Ø12 mm

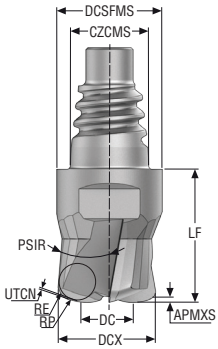


Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	RP	UTCN	PSIR°	PCEDC	SW	Grades
					mm	mm	mm	mm	mm	mm	mm	mm				HXT
XHF780E10100D1HZ3	10137957	1	D	E10	10,0	5,0	9,7	0,45	12,3	0,8	1,175	0,232	-5,0	3	8	■
XHF780E12120D1HZ3	10137958	1	D	E12	12,0	6,0	11,7	0,5	14,4	1,0	1,416	0,262	-5,0	3	10	■
XHF780E16160D1HZ3	10137959	1	D	E16	16,0	8,0	15,5	0,6	18,6	1,5	1,989	0,32	-5,0	3	12	■

■ Stocked standard.

XHF780

High feed – ISO– M and ISO– S – 3 Flutes – Corner radius – *Inch*



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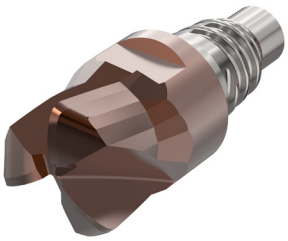
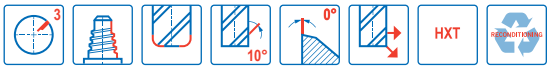




- Tolerances:
- DCX= -.0008/-0.0016 Inch
- RE= ±.002 Inch
- Regrind possible if DCX is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	RP	UTCN	PSIR°	PCEDC	SW	Grades
					Inch	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*	*Inch*				HXT
XHF780E10.375D1HZ3	10137960	1	D	E10	0.375	0.188	0.364	0.018	0.484	0.028	0.043	0.009	-5,0	3	8	■
XHF780E12.500D1HZ3	10137961	1	D	E12	0.461	0.250	0.484	0.020	0.567	0.045	0.061	0.010	-5,0	3	10	■
XHF780E16.625D1HZ3	10137962	1	D	E16	0.625	0.313	0.610	0.024	0.732	0.061	0.080	0.012	-5,0	3	12	■

■ Stocked standard.

Cutting data – XHF780 Side milling

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	355 (330 — 410) *1175 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	345 (320 — 390) *1125 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (280 — 340) *970 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	195 (180 — 230) *640 (600 — 750)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	185 (170 — 220) *610 (560 — 720)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	175 (160 — 210) *570 (530 — 680)*
P11	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	180 (170 — 210) *590 (560 — 680)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (83 — 100) *280 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	175 (170 — 210) *570 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	140 (140 — 160) *460 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (97 — 130) *345 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	75 (73 — 100) *245 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	65 (61 — 83) *215 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	45 (36 — 71) *150 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	36 (29 — 57) *120 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	31 (25 — 49) *100 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	160 (160 — 190) *520 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	120 (120 — 150) *395 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	95 (90 — 110) *310 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	135 (130 — 170) *445 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	80 (75 — 100) *260 (250 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XHF780 Slot milling

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (290 — 350) *1025 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	300 (290 — 350) *980 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (250 — 300) *850 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	170 (160 — 200) *560 (530 — 650)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	160 (150 — 190) *520 (500 — 620)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	150 (140 — 180) *490 (460 — 590)*
P11	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	155 (150 — 180) *510 (500 — 590)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (73 — 92) *245 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	150 (150 — 180) *490 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	120 (120 — 140) *395 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (85 — 110) *295 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (64 — 87) *215 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (53 — 72) *180 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (31 — 60) *125 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	30 (25 — 48) *100 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	26 (21 — 41) *85 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	145 (140 — 170) *475 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	110 (110 — 130) *360 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	85 (82 — 100) *280 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	115 (110 — 140) *375 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (65 — 88) *230 (220 — 280)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

Cutting data – XHF780 Side milling inch

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	370 (330 — 410) *1225 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	310 (280 — 340) *1025 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	305 (280 — 330) *1000 (920 — 1000)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	290 (260 — 320) *950 (860 — 1000)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P11	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (150 — 170) *520 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 83) *230 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	175 (160 — 190) *570 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	135 (120 — 150) *445 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	105 (90 — 110) *345 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (130 — 170) *490 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (75 — 100) *295 (250 — 320)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

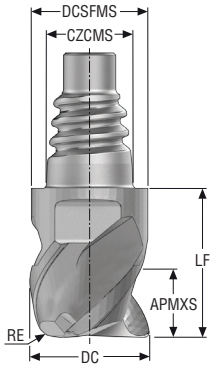
Cutting data – XHF780 Slot milling inch

SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 350) *1075 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (250 — 300) *890 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (240 — 290) *890 (790 — 950)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	255 (230 — 280) *840 (760 — 910)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P11	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	140 (130 — 150) *460 (430 — 490)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (73 — 92) *260 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (53 — 72) *215 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	45 (31 — 60) *150 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	36 (25 — 48) *120 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (21 — 41) *100 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	155 (140 — 170) *510 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	120 (110 — 130) *395 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (82 — 100) *310 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (110 — 140) *425 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (65 — 88) *245 (220 — 280)*

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

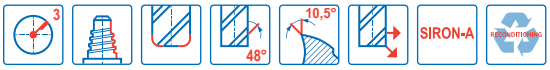
XVE540

General purpose – Universal – Square – 3 Flutes – Corner radius



D

- Tolerances:
- DC= h9
- RE= ±0,015 mm
- Regrind possible if DC is ≥Ø12 mm

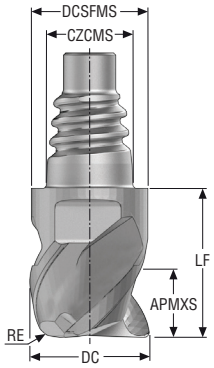


Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z3	10137981	1	D	E10	10,0	9,7	5,5	12,4	0,5	3	8	■
XVE540E12120D1R050Z3	10137982	1	D	E12	12,0	11,7	6,5	14,5	0,5	3	10	■
XVE540E16160D1R050Z3	10137983	1	D	E16	16,0	15,5	8,5	18,7	0,5	3	12	■
XVE540E20200D1R050Z3	10137984	1	D	E20	20,0	19,3	11,0	21,3	0,5	3	16	■

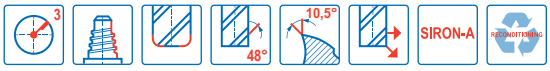
■ Stocked standard.

XVE540

General purpose – Universal – Square – 3 Flutes – Corner radius



D



- Tolerances:
- DC= h9
- RE= .015 Inch= ±.0006 Inch
- RE= .031 Inch= ±.0012 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XVE540E10.375D1R015Z3	10137985	1	D	E10	0.375	0.364	0.209	0.488	0.015	3	8	■
XVE540E12.500D1R015Z3	10137986	1	D	E12	0.500	0.484	0.276	0.575	0.015	3	10	■
XVE540E16.625D1R015Z3	10137987	1	D	E16	0.625	0.610	0.335	0.736	0.015	3	12	■
XVE540E20.750D1R031Z3	10137988	1	D	E20	0.750	0.728	0.413	0.839	0.031	3	16	■

■ Stocked standard.

Seco

Cutting data – XVE540 – Side milling PCEDC 3

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (140 — 220) *570 (460 — 720)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	170 (130 — 210) *560 (430 — 680)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	150 (120 — 180) *490 (400 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (100 — 160) *445 (330 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	125 (96 — 150) *410 (320 — 490)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	145 (110 — 170) *475 (370 — 550)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	135 (110 — 160) *445 (370 — 520)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (96 — 150) *410 (320 — 490)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	80 (70 — 93) *260 (230 — 300)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (45 — 59) *165 (150 — 190)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	95 (81 — 100) *310 (270 — 320)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (67 — 88) *245 (220 — 280)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	50 (39 — 60) *165 (130 — 190)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	38 (30 — 46) *125 (99 — 150)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	32 (25 — 39) *105 (83 — 120)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (140 — 170) *510 (460 — 550)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	115 (99 — 130) *375 (330 — 420)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	110 (95 — 120) *360 (320 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	200 (170 — 220) *660 (560 — 720)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	175 (150 — 190) *570 (500 — 620)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	550 (510 — 710) *1800 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	355 (330 — 450) *1175 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	235 (220 — 300) *770 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.50*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0050*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	30 (24 — 37) *100 (79 — 120)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	25 (19 — 32) *80 (63 — 100)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	22 (17 — 27) *70 (56 — 88)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (44 — 79) *195 (150 — 250)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

Cutting data – XVE540 – Slot milling PCEDC 3

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (64 — 84) *245 (210 — 270)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	44 (38 — 49) *145 (130 — 160)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (75 — 99) *280 (250 — 320)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	45 (35 — 55) *150 (120 — 180)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 150) *460 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (89 — 110) *345 (300 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (85 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	540 (510 — 700) *1775 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	345 (330 — 450) *1125 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	230 (220 — 300) *750 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 350) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	27 (22 — 34) *90 (73 — 110)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	23 (18 — 29) *75 (60 — 95)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (51 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	55 (39 — 69) *180 (130 — 220)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

Seco

Cutting data – XVE540 – Side milling PCEDC 3 inch

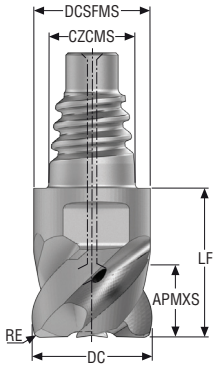
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 200) *590 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (100 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (94 — 140) *375 (310 — 450)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (89 — 130) *360 (300 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (70 — 110) *310 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (45 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (81 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 76) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	50 (36 — 63) *165 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 140) *395 (370 — 450)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	105 (87 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 80) *215 (180 — 260)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (69 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	300 (250 — 340) *1025 (860 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (32 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (26 — 37) *100 (86 — 120)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	28 (23 — 33) *90 (76 — 100)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (87 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

Cutting data – XVE540 – Slot milling PCEDC 3 inch

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 190) *540 (460 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (64 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (38 — 62) *165 (130 — 200)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (75 — 120) *330 (250 — 390)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 67) *165 (130 — 210)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	44 (32 — 56) *145 (110 — 180)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (92 — 120) *360 (310 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (78 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 71) *195 (160 — 230)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (71 — 100) *295 (240 — 320)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 91) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 43) *120 (96 — 140)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (24 — 34) *95 (79 — 110)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 30) *80 (66 — 98)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 77) *195 (160 — 250)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

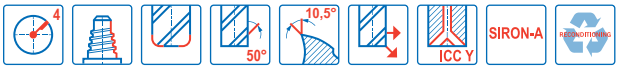
XVE540

General purpose – Universal – Square – 4 Flutes – Corner radius – ICC



D

- Tolerances:
- DC= h9
- RE= ±0,015 mm
- Regrind possible if DC is ≥Ø12 mm

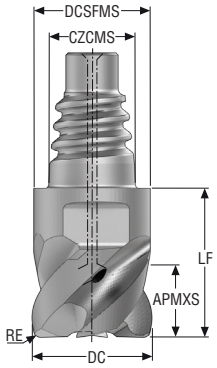


Designation	Item number	Length index	Tool shape	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
						mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z4A	10137989	1	D	✓	E10	10,0	9,7	6,0	12,4	0,5	4	8	■
XVE540E12120D1R050Z4A	10137990	1	D	✓	E12	12,0	11,7	7,5	14,5	0,5	4	10	■
XVE540E16160D1R050Z4A	10137991	1	D	✓	E16	16,0	15,5	10,0	18,7	0,5	4	12	■
XVE540E20200D1R050Z4A	10137992	1	D	✓	E20	20,0	19,3	12,0	21,3	0,5	4	16	■

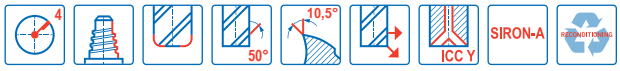
■ Stocked standard.

XVE540

General purpose – Universal – Square – 4 Flutes – Corner radius – ICC – *Inch*



D



- Tolerances:
- DC= h9
- RE= .015 Inch= ±.0006 Inch
- RE= .031 Inch= ±.0012 Inch
- Regrind possible if DC is ≥Ø.500 Inch

Designation	Item number	Length index	Tool shape	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
						Inch	*Inch*	*Inch*	*Inch*	*Inch*			SIRA
XVE540E10.375D1R015Z4A	10137993	1	D	✓	E10	0.375	0.364	0.236	0.488	0.015	4	8	■
XVE540E12.500D1R031Z4A	10137994	1	D	✓	E12	0.500	0.484	0.315	0.571	0.031	4	12	■
XVE540E16.625D1R031Z4A	10137995	1	D	✓	E16	0.625	0.610	0.394	0.736	0.031	4	16	■
XVE540E20.750D1R031Z4A	10137996	1	D	✓	E20	0.750	0.728	0.453	0.839	0.031	4	18	■

■ Stocked standard.

Cutting data – XVE540 – Side milling PCEDC 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (140 — 210) *570 (460 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	170 (130 — 210) *560 (430 — 680)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	150 (120 — 180) *490 (400 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	130 (99 — 160) *425 (330 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	125 (95 — 150) *410 (320 — 490)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	140 (110 — 170) *460 (370 — 550)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	135 (110 — 160) *445 (370 — 520)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (95 — 150) *410 (320 — 490)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	80 (70 — 92) *260 (230 — 300)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (44 — 58) *165 (150 — 190)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	95 (80 — 100) *310 (270 — 320)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (66 — 87) *245 (220 — 280)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	49 (39 — 60) *160 (130 — 190)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	38 (30 — 46) *125 (99 — 150)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	32 (25 — 38) *105 (83 — 120)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (140 — 170) *510 (460 — 550)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	115 (99 — 130) *375 (330 — 420)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	110 (94 — 120) *360 (310 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	200 (160 — 220) *660 (530 — 720)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	175 (150 — 190) *570 (500 — 620)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	540 (510 — 700) *1775 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	350 (330 — 450) *1150 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	235 (220 — 300) *770 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.55*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0050*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	30 (24 — 37) *100 (79 — 120)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	25 (19 — 31) *80 (63 — 100)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	22 (17 — 27) *70 (56 — 88)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (44 — 78) *195 (150 — 250)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Cutting data – XVE540 – Slot milling PCEDC 4

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 200) *520 (430 — 650)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	155 (120 — 190) *510 (400 — 620)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	135 (110 — 160) *445 (370 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (96 — 150) *410 (320 — 490)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (91 — 150) *395 (300 — 490)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (63 — 83) *245 (210 — 270)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	43 (37 — 49) *140 (130 — 160)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (74 — 98) *280 (250 — 320)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	33 (26 — 40) *110 (86 — 130)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 150) *460 (400 — 490)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (88 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	95 (84 — 110) *310 (280 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 130) *410 (330 — 420)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	530 (500 — 690) *1750 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	345 (320 — 440) *1125 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	230 (220 — 290) *750 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	55 (39 — 69) *180 (130 — 220)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

Seco

Cutting data – XVE540 – Side milling PCEDC 4 inch

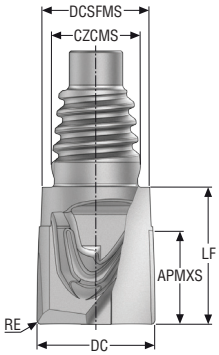
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 210) *590 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (150 — 200) *570 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (99 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (93 — 130) *375 (310 — 420)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (88 — 130) *360 (290 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (70 — 110) *295 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (44 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (80 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 75) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	49 (36 — 63) *160 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (120 — 150) *445 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	100 (86 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 79) *215 (180 — 250)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (68 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	295 (250 — 340) *1000 (860 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (31 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (25 — 37) *100 (83 — 120)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	27 (22 — 32) *90 (73 — 100)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (86 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Cutting data – XVE540 – Slot milling PCEDC 4 inch

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 180) *540 (460 — 590)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (89 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (84 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (63 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	49 (37 — 61) *160 (130 — 200)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (74 — 120) *330 (250 — 390)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 66) *165 (130 — 210)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	43 (31 — 55) *140 (110 — 180)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (91 — 120) *345 (300 — 390)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (77 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 70) *195 (160 — 220)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (70 — 100) *280 (230 — 320)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 90) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	380 (320 — 440) *1250 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 42) *120 (96 — 130)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (23 — 34) *95 (76 — 110)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 29) *80 (66 — 95)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 76) *195 (160 — 240)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

XVE510

General purpose – Universal – Square – 2 Flutes – Corner radius



D

- Tolerances:
- DC= h10
- RE= ±0,015 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm			SIRA
XVE510E10100D1R050Z2	10138003	1	D	E10	10,0	9,7	8,0	11,8	0,5	2	6	■
XVE510E12120D1R050Z2	10138004	1	D	E12	12,0	11,7	10,0	14,0	0,5	2	8	■

■ Stocked standard.

Cutting data – XVE510 Side milling

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	210 (170 — 250) *690 (560 — 820)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	205 (170 — 240) *670 (560 — 780)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (150 — 210) *570 (500 — 680)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (140 — 200) *570 (460 — 650)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	165 (140 — 190) *540 (460 — 620)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	115 (82 — 140) *375 (270 — 450)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,080 *0.0032*	70 (50 — 89) *230 (170 — 290)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (97 — 170) *445 (320 — 550)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	110 (78 — 130) *360 (260 — 420)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (55 — 85) *230 (190 — 270)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	50 (41 — 64) *165 (140 — 200)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	44 (35 — 53) *145 (120 — 170)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	130 (110 — 150) *425 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	230 (190 — 270) *750 (630 — 880)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	100 (83 — 110) *330 (280 — 360)*
N1	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	470 (410 — 530) *1550 (1400 — 1700)*
N2	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	305 (270 — 340) *1000 (890 — 1100)*
N3	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	200 (180 — 230) *660 (600 — 750)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	370 (300 — 440) *1225 (990 — 1400)*
S1	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	60 (39 — 85) *195 (130 — 270)*
S2	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	55 (32 — 77) *180 (110 — 250)*
S3	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	39 (24 — 54) *130 (79 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	95 (78 — 100) *310 (260 — 320)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (61 — 84) *230 (210 — 270)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	540 (470 — 620) *1775 (1600 — 2000)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	540 (470 — 620) *1775 (1600 — 2000)*
GR1	A/D	0,20 *0.20*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	570 (510 — 630) *1875 (1700 — 2000)*

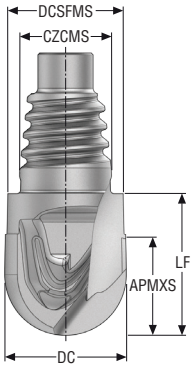
Seco

Cutting data – XVE510 Slot milling

SMG		a_p/DC	f_z		v_c
			10	12	
P1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	135 (110 — 160) *445 (370 — 520)*
P2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	130 (110 — 150) *425 (370 — 490)*
P3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	115 (91 — 130) *375 (300 — 420)*
P4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 110) *330 (270 — 360)*
P5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	75 (53 — 94) *245 (180 — 300)*
P12	E/M/A/D	0,40 *0.40*	0,040 *0.0016*	0,048 *0.0019*	46 (33 — 58) *150 (110 — 190)*
M1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (62 — 110) *280 (210 — 360)*
M2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	70 (50 — 89) *230 (170 — 290)*
M3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,38 *0.38*	0,050 *0.0020*	0,060 *0.0024*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,38 *0.38*	0,050 *0.0020*	0,060 *0.0024*	28 (23 — 34) *90 (76 — 110)*
K1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (70 — 97) *280 (230 — 310)*
K5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 120) *330 (270 — 390)*
K6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	65 (54 — 74) *215 (180 — 240)*
N1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
N2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	225 (200 — 250) *740 (660 — 820)*
N3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (130 — 170) *490 (430 — 550)*
N11	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	250 (200 — 290) *820 (660 — 950)*
S1	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	40 (25 — 54) *130 (83 — 170)*
S2	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	35 (20 — 49) *115 (66 — 160)*
S3	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	80 (65 — 90) *260 (220 — 290)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	60 (50 — 69) *195 (170 — 220)*
S13	E	0,42 *0.42*	0,050 *0.0020*	0,060 *0.0024*	47 (39 — 54) *155 (130 — 170)*
TS1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
TP1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
GR1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	450 (400 — 490) *1475 (1400 — 1600)*

XVB510

General purpose – Universal – Ball nose – 2 Flutes



D

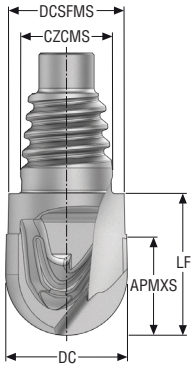
- Tolerances:
- DC= h9
- RE= ±0,01 mm

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
					mm	mm	mm	mm			SIRA
XVB510E10100D1BZ2	10138005	1	D	E10	10,0	9,7	8,0	11,8	2	6	■
XVB510E12120D1BZ2	10138006	1	D	E12	12,0	11,7	10,0	14,0	2	8	■
XVB510E16160D1BZ2	10138007	1	D	E16	16,0	15,5	13,0	18,1	2	10	■

■ Stocked standard.

XVB510

General purpose – Universal – Ball nose – 2 Flutes – *Inch*



D

- Tolerances:
- DC= h9
- RE= ±.0004 Inch

Designation	Item number	Length index	Tool shape	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Grade
					Inch	*Inch*	*Inch*	*Inch*			SIRA
XVB510E10.375D1BZ2	10138008	1	D	E10	0.375	0.364	0.315	0.465	2	6	■
XVB510E12.500D1BZ2	10138009	1	D	E12	0.500	0.484	0.413	0.551	2	8	■
XVB510E16.625D1BZ2	10138010	1	D	E16	0.624	0.610	0.512	0.713	2	10	■

■ Stocked standard.

Cutting data – XVB510 Copy milling roughing

SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 180) *490 (430 — 590)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	145 (120 — 170) *475 (400 — 550)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	65 (50 — 78) *215 (170 — 250)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	39 (30 — 47) *130 (99 — 150)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 91) *245 (200 — 290)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	60 (48 — 74) *195 (160 — 240)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	60 (48 — 74) *195 (160 — 240)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	46 (36 — 55) *150 (120 — 180)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	38 (30 — 46) *125 (99 — 150)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 150) *425 (370 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	125 (110 — 150) *410 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	80 (63 — 94) *260 (210 — 300)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	115 (93 — 130) *375 (310 — 420)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (81 — 120) *330 (270 — 390)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	285 (250 — 320) *940 (830 — 1000)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	190 (170 — 210) *620 (560 — 680)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	335 (270 — 400) *1100 (890 — 1300)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	55 (33 — 76) *180 (110 — 240)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	44 (27 — 61) *145 (89 — 200)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	38 (23 — 52) *125 (76 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (88 — 120) *345 (290 — 390)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	80 (68 — 94) *260 (230 — 300)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	65 (53 — 73) *215 (180 — 230)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	630 (570 — 700) *2075 (1900 — 2200)*

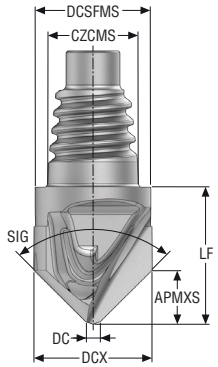
Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

Cutting data – XVB510 Copy milling roughing inch

SMG		a_e/DC	a_p/DC	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	365 (320 — 420) *1200 (1100 — 1300)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	355 (310 — 400) *1175 (1100 — 1300)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	305 (270 — 350) *1000 (890 — 1100)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	270 (230 — 310) *890 (760 — 1000)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	195 (160 — 240) *640 (530 — 780)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 220) *610 (500 — 720)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	95 (78 — 110) *310 (260 — 360)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (160 — 210) *610 (530 — 680)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	120 (95 — 140) *395 (320 — 450)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	90 (71 — 110) *295 (240 — 360)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 92) *245 (200 — 300)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	360 (310 — 410) *1175 (1100 — 1300)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	310 (270 — 350) *1025 (890 — 1100)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	265 (230 — 300) *870 (760 — 980)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	250 (220 — 280) *820 (730 — 910)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (79 — 120) *330 (260 — 390)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (120 — 180) *490 (400 — 590)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	510 (390 — 630) *1675 (1300 — 2000)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	330 (250 — 400) *1075 (830 — 1300)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	405 (270 — 530) *1325 (890 — 1700)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	110 (66 — 150) *360 (220 — 490)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	90 (53 — 120) *295 (180 — 390)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	75 (46 — 100) *245 (160 — 320)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (130 — 220) *570 (430 — 720)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (95 — 170) *445 (320 — 550)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (74 — 130) *345 (250 — 420)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	850 (710 — 980) *2800 (2400 — 3200)*

XVC506/509/512

General purpose – Universal – Chamfer – 2 Flutes



N

- Tolerances:
- SIG= ±1°

Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	SIG°	PCEDC	SW	Grade
					mm	mm	mm	mm	mm				SIRA
XVC506E10100N1SZ2	10138012	1	N	E10	10,0	1,5	9,7	7,23	11,8	60,0	2	6	■
XVC506E12120N1SZ2	10138013	1	N	E12	12,0	1,5	11,7	7,73	14,0	60,0	2	8	■
XVC509E10100N1SZ2	10138014	1	N	E10	10,0	1,5	9,7	4,23	11,8	90,0	2	6	■
XVC509E12120N1SZ2	10138015	1	N	E12	12,0	1,5	11,7	5,23	14,0	90,0	2	8	■
XVC509E16160N1SZ2	10138016	1	N	E16	16,0	1,5	15,5	7,23	18,1	90,0	2	10	■
XVC512E12120N1SZ2	10138017	1	N	E12	12,0	1,5	11,7	3,03	14,0	120,0	2	8	■

■ Stocked standard.

Seco

Cutting data – XVC506 Chamfering

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	105 (86 — 120) *345 (290 — 390)*
P12	E/M/A/D	0,10 *0.10*	1,6 *1.6*	0,15 *0.0060*	0,16 *0.0065*	65 (52 — 76) *215 (180 — 240)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,26 *0.010*	0,28 *0.011*	125 (99 — 140) *410 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	1,5 *1.5*	0,19 *0.0075*	0,20 *0.0080*	47 (33 — 60) *155 (110 — 190)*
M5	E/M/A	0,10 *0.10*	1,5 *1.5*	0,19 *0.0075*	0,20 *0.0080*	39 (27 — 50) *130 (89 — 160)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	150 (130 — 160) *490 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	30 (10 — 49) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	95 (72 — 120) *310 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	1,7 *1.7*	0,19 *0.0075*	0,20 *0.0080*	55 (43 — 72) *180 (150 — 230)*
H5	M/A	0,050 *0.050*	2,0 *2.0*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,050 *0.050*	1,8 *1.8*	0,080 *0.0032*	0,085 *0.0034*	120 (99 — 130) *395 (330 — 420)*
H21	M/A	0,050 *0.050*	1,8 *1.8*	0,080 *0.0032*	0,085 *0.0034*	120 (99 — 130) *395 (330 — 420)*
H31	M/A	0,050 *0.050*	1,8 *1.8*	0,070 *0.0028*	0,075 *0.0030*	90 (75 — 100) *295 (250 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*
GR1	A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	600 (500 — 690) *1975 (1700 — 2200)*

Cutting data – XVC509 Chamfering

SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	150 (130 — 160) *490 (430 — 520)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	105 (85 — 120) *345 (280 — 390)*
P12	E/M/A/D	0,10 *0.10*	1,6 *1.6*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	60 (50 — 74) *195 (170 — 240)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	120 (98 — 140) *395 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	1,5 *1.5*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	46 (33 — 60) *150 (110 — 190)*
M5	E/M/A	0,10 *0.10*	1,5 *1.5*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	39 (27 — 50) *130 (89 — 160)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	145 (130 — 160) *475 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	125 (110 — 130) *410 (370 — 420)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	30 (10 — 50) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	1,7 *1.7*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	55 (42 — 72) *180 (140 — 230)*
H5	M/A	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,10 *0.10*	1,8 *1.8*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 (99 — 130) *395 (330 — 420)*
H21	M/A	0,10 *0.10*	1,8 *1.8*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 (99 — 130) *395 (330 — 420)*
H31	M/A	0,10 *0.10*	1,8 *1.8*	0,075 *0.0030*	0,080 *0.0032*	0,085 *0.0034*	90 (75 — 100) *295 (250 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	600 (500 — 700) *1975 (1700 — 2200)*

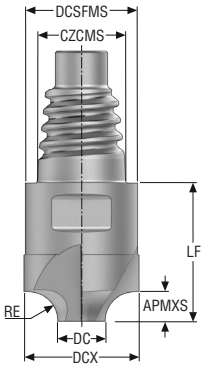
Universal
Steel and cast iron
Stainless steel and S-materials
Non ferrous
Hard
Plastic and cfrp
Graphite
X-Heads
Minimaster Plus
Minimaster

Cutting data – XVC512 Chamfering

SMG		a_e/DC	a_p/DC	f_z	v_c
				12	
P1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	165 (150 — 180) *540 (500 — 590)*
P2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 170) *520 (460 — 550)*
P3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	135 (120 — 150) *445 (400 — 490)*
P7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	125 (120 — 140) *410 (400 — 450)*
P8	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P11	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	85 (68 — 100) *280 (230 — 320)*
P12	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,22 *0.0085*	50 (41 — 61) *165 (140 — 200)*
M1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	100 (80 — 110) *330 (270 — 360)*
M2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (65 — 96) *260 (220 — 310)*
M3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	50 (37 — 68) *165 (130 — 220)*
M4	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	39 (28 — 51) *130 (92 — 160)*
M5	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	33 (23 — 42) *110 (76 — 130)*
K1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	140 (130 — 150) *460 (430 — 490)*
K3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	115 (110 — 130) *375 (370 — 420)*
K4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	110 (98 — 120) *360 (330 — 390)*
K5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	65 (58 — 75) *215 (200 — 240)*
K6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	85 (74 — 96) *280 (250 — 310)*
N1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	480 (410 — 560) *1575 (1400 — 1800)*
N2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	310 (260 — 360) *1025 (860 — 1100)*
N3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	205 (180 — 240) *670 (600 — 780)*
N11	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	320 (290 — 360) *1050 (960 — 1100)*
S1	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	35 (12 — 58) *115 (40 — 190)*
S2	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	29 (9,6 — 47) *95 (32 — 150)*
S3	E	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	25 (8,3 — 41) *80 (28 — 130)*
S11	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (58 — 98) *260 (200 — 320)*
S12	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	60 (45 — 76) *195 (150 — 240)*
S13	E	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	47 (35 — 59) *155 (120 — 190)*
H5	M/A	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	100 (83 — 110) *330 (280 — 360)*
H8	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H21	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H31	M/A	0,10 *0.10*	1,3 *1.3*	0,11 *0.0044*	75 (64 — 88) *245 (210 — 280)*
TS1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*
TP1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*
GR1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	480 (410 — 560) *1575 (1400 — 1800)*

XVK310

General purpose – Universal – Concave – 4 Flutes



- Tolerances:
- RE= ≤5= ±0,05 mm
- RE= >5= ±0,1 mm

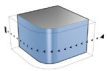
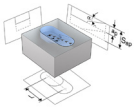
Designation	Item number	Length index	Tool shape	CZCMS	DCX	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Grade
					mm	mm	mm	mm	mm	mm			SIRA
XVK310E12120D1K300Z4	10137998	1	D	E12	12,0	5,0	11,7	3,0	14,5	3,0	4	10	■
XVK310E12120D1K400Z4	10137999	1	D	E12	12,0	4,0	11,7	4,0	14,5	4,0	4	10	■
XVK310E16160D1K500Z4	10138000	1	D	E16	16,0	6,0	15,5	5,0	18,7	5,0	4	12	■
XVK310E20200D1K600Z4	10138001	1	D	E20	20,0	8,0	19,3	6,0	21,3	6,0	4	16	■

■ Stocked standard.

Cutting data – XVK310 Side milling roughing

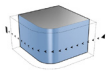
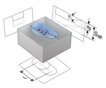
SMG		a_p/D_c	f_z			v_c
			12	16	20	
P1	E/M/A/D	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A/D	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	105 (70 — 115) *345 (220 — 375)*
N1	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S1	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S2	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S3	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S11	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	265 (180 — 285) *870 (590 — 940)*
S12	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S13	E	0,24 *0,24*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	155 (105 — 165) *510 (345 — 540)*
TS1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ 30° *						
JS412																
LV2	100	100	100	100	100	140	3	40	120	80	100	50	10	130	50	100
										≤ 10° *						
JS413																
LV2	100	100	100	100	100	150	3	40	120	70	50	50	10	130	X	X
LV3	X	X	25	60	240	120	3	40	230	70	50	50	10	130	X	X
										≤ 30° *						
JS452																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	50	60	75	60	50	120	3	40	100	70	70	50	10	130	20	10
										≤ 10° *						
JS453																
LV2	100	100	100	100	100	140	3	35	120	70	50	50	10	130	20	10
LV3	X	X	25	60	240	120	3	40	230	70	70	50	10	130	20	10
										≤ 30° *						
JSE512																
LV2	100	100	100	100	100	110	3	65	125	40	40	100	5	130	40	40
										≤ 5° *						
JSE513																
LV2	100	100	100	100	100	110	3	85	150	100	100	100	5	130	50	40
LV3	30	100	30	50	200	110	3	85	250	X	X	X	X	X	X	X
LV4	X	X	X	X	X	60	3	80	350	X	X	X	X	X	X	X
										≤ 5° *						
JSE514																
LV1	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV2	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV3	X	X	25	50	200	110	3	60	250	X	X	X	X	X	X	X
LV4	X	X	X	X	X	60	3	80	350	X	X	X	X	X	X	X
										≤ 45° *						
JS553																
LV1	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV2	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV3	40	60	40	105	200	110	3	55	250	50	15	35	3	130	35	50
										≤ 5° *						
JS554																
LV1	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV2	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	53	250	50	50	60	3	130	X	X
JS564																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X
JS565																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X

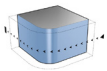
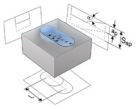
*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ 45° *						
J28																
LV2	100	100	100	100	100	140	3	100	135	40	25	100	10	130	25	60
										≤ X° *						
J36																
LV2	X	X	100	100	100	120	3	85	150	X	X	X	X	X	X	X
										≤ 20° *						
J93F																
LV2	100	100	100	100	100	133	3	40	100	100	100	100	3	130	25	30
										≤ 1°						
JH120																
LV2	100	100	100	100	100	120	3	120	80	17	100	100	2	130	X	X
										≤ X° *						
JH130																
LV2	X	X	100	100	100	120	3	120	80	X	X	X	X	X	X	X
										≤ X° *						
JH142																
LV2	X	X	100	100	100	110	3	80	70	X	X	30	2	130	X	X
LV3	X	X	100	100	100	110	3	80	70	X	X	20	1	130	X	X
LV6	X	X	100	100	100	110	3	80	70	X	X	10	1	130	X	X
										≤ 45° *						
JH830																
LV2	100	100	100	100	100	110	3	110	80	9	135	135	3	130	X	X
										≤ X° *						
JH910																
LV2	100	100	100	100	100	125	4	100	80	15	140	140	3	130	X	X
LV3	80	80	100	80	80	125	4	80	65	10	110	110	3	130	X	X
										≤ X° *						
JH930																
LV2	X	X	100	100	100	125	2	30	100	X	X	X	X	X	X	X

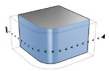
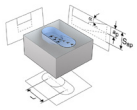
*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ 5° *						
JH40																
LV2	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
LV3	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
										≤ 45° *						
JH410																
LV2	100	100	100	100	100	125	2	25	100	100	67	67	40	130	67	80
LV2 (ML)	75	60	80	60	100	125	2	25	100	60	40	40	40	130	40	50
LV2 (TL)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV2 (RS)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV3 (RS)	95	95	80	100	100	100	2	100	100	50	50	50	40	130	75	40
										≤ 45° *						
JH421																
LV2	100	100	100	100	100	100	4	35	100	100	100	100	25	130	45	80
										≤ 30° *						
JH440																
LV2	100	100	100	100	100	125	3	40	100	100	100	100	5	130	X	X
										≤ 5° *						
JHP750																
LV1	115	120	115	115	100	100	2	145	100	100	120	120	3	130	10	70
LV2	100	100	100	100	100	100	2	145	100	100	100	100	3	130	10	60
										≤ 5° *						
JHP951																
LV2	100	100	100	100	100	158	2	50	113	20	100	125	3	130	6	20
										≤ 10° *						
JHP993																
LV2	100	100	100	100	100	X	X	X	X	30	100	100	3	130	4	40
LV3	80	80	80	80	80	X	X	X	X	20	80	80	3	130	3	30
										≤ X° *						
JS520																
LV2	X	X	100	100	100	133	2	65	100	X	X	X	X	X	X	X
LV3	X	X	X	X	X	133	2	65	175	X	X	X	X	X	X	X
										≤ X° *						
JS522																
LV4	X	X	100	100	100	129	2	140	100	X	X	X	X	X	X	X
JS720																
LV2	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
LV3	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
JS754																
LV1	100	100	100	100	100	110	3	55	150	100	100	100	3	130		
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	55	250	50	50	60	3	130		
JS755																
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	100	110	3	55	250	50	50	60	3	130		

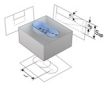
*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version side milling cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ X°						
JME542-JME562-JME564																
LV1	100	100	100	100	100	125	2	150	5	X	X	X	X	X	X	X
LV2	63	100	100	100	65	125	2	150	3	X	X	X	X	X	X	X
LV3	25	100	100	100	25	125	2	150	1	X	X	X	X	X	X	X
LV4 (TL)	18	100	100	100	20	125	2	150	1	X	X	X	X	X	X	X
LV4 (XL)	12	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV5	10	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV6	4	100	100	100	5	125	2	150	1	X	X	X	X	X	X	X
LV7	2	100	100	100	2	125	2	150	1	X	X	X	X	X	X	X
										≤ X°						
JME142-JME144																
LV1	100	100	100	100	100	100	2	150	5	X	X	X	X	X	X	X
LV2	85	85	100	100	63	100	2	150	3	X	X	X	X	X	X	X
LV3	75	75	100	100	25	100	2	150	1	X	X	X	X	X	X	X
LV4	60	60	100	100	20	100	2	150	1	X	X	X	X	X	X	X
LV5	50	50	100	100	10	100	2	150	1	X	X	X	X	X	X	X
LV6	40	40	100	100	5	100	2	150	1	X	X	X	X	X	X	X
										≤ X° *						
JM403-JM404-JM406																
LV1	100	100	100	100	100	X	X	X	X	X	X	X	X	X	X	X
LV2	100	75	100	75	100	X	X	X	X	X	X	X	X	X	X	X
LV3 (L)	100	75	100	75	90	X	X	X	X	X	X	X	X	X	X	X
LV3 (TL)	90	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (XL)	75	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (SL)	75	75	100	75	45	X	X	X	X	X	X	X	X	X	X	X
LV5	50	50	100	50	30	X	X	X	X	X	X	X	X	X	X	X
JME642																
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
										≤2						
JC898																
LV3	X	X	100	100	100	X	X	X	X	X	50	80	3	130-160	X	X
										≤5°						
JC899																
LV3	X	X	100	100	100	100	3	50	100	X	X	X	X	X	X	X

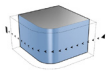
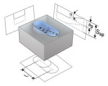
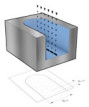
*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!						
	Slotting		Side rough			Side finish				Ramping		Helical			Drilling	
Straight																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	f_z	a_p (% of DC)
										≤ 1°						
JHP170																
LV2	100	100	100	100	100	130	3	175	80	100	100	100	2	130	X	X
										≤ 30°						
JHP490																
LV2	100	100	100	100	100	X	X	X	X	50	50	35	5	130	30	50
LV2 (E-Shape)	100	75	100	100	100	X	X	X	X	50	50	35	5	130	30	50
LV3	100	75	80	100	100	X	X	X	X	50	50	35	5	130	30	50
LV4	150	75	80	100	100	X	X	X	X	50	50	35	5	130	30	50
										≤ 5°						
JHP760																
LV2	100	100	100	100	100	140	2	125	15	30	100	100	3	130	10	50
LV3	50	50	100	50	50	140	2	125	15	15	50	50	3	130	5	25
										≤ 15°						
JHP770																
LV2	100	100	100	100	100	170	3	125	100	100	40	40	3	130	X	X
										≤ 5°						
JHP780																
LV1	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
LV2	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
JD620																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	20	100	60	100	60	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD630																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD640																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X

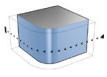
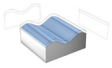
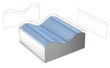
*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!								
Straight	Slotting		Side rough			Side finish				Ramping		Helical			Plunging			
																		
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)	v_c	a_e (% of DC)	f_z	a_e-sd (% of DC)
JHF181																		
LV1	100	100	100	100	100	X	X	X	X	X	X	100	3,4	130	X	X	X	X
LV2	80	85	100	85	80	X	X	X	X	X	X	85	3,0	130	X	X	X	X
LV3	60	70	100	70	60	X	X	X	X	X	X	70	2,5	130	X	X	X	X
										≤ 1,5° *								
JHF980																		
LV1	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV2	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV3	80	85	80	85	80	X	X	X	X	80	85	85	3	130	70	30	33	200
LV4	50	70	50	70	60	X	X	X	X	60	70	70	3	130	70	30	33	200

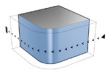
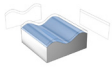
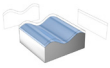
*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!									
BALL	Slotting		Side rough			Side finish				Copy milling roughing			Copy milling finishing				Helical		
																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)
JSB512																			
LV2	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	100	5	130
JS532																			
LV1	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV2	X	X	70	100	70	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV3	X	X	X	X	X	125	3	125	10	X	X	X	X	X	X	X	X	X	X
JS533																			
LV1	X	X	100	100	100	125	3	125	15	X	X	X	X	X	X	X	75	5	130
LV2	X	X	75	75	75	125	3	125	15	X	X	X	X	X	X	X	75	5	130
JS534																			
LV1	X	X	100	100	100	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV2	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV3	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
JHB970																			
LV1	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV2	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV3	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
JHB720																			
LV2	X	X	100	100	100	125	2	90	75	X	X	X	X	X	X	X	40	3	130
JH112																			
LV1	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV2	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV3	X	X	100	100	100	110	1,6	55	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	130	1,4	55	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	130	1,4	50	100	X	X	X	X	X	X	X	X	X	X
LV6	X	X	100	100	100	130	1	35	100	X	X	X	X	X	X	X	X	X	X
JH150																			
LV2	X	X	100	100	100	165	1	90	35	X	X	X	X	X	X	X	30	2	130

*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!									
BALL	Slotting		Side rough			Side finish				Copy milling roughing			Copy milling finishing				Helical		
																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% of DC)	f_z	a_p	f_z	a_p/360° (% of DC)	hole Ø (≥ % of DC)
JH160																			
Standard (2)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
JH450																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	45	5	130
JH460																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	X	X	X
JMB542-JMB562-JMB563																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	125	2	150	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	100	100	63	125	2	150	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	100	100	25	125	2	150	1	X	X	X
LV4 (TL)	20	100	X	X	X	X	X	X	X	100	100	19	125	2	150	1	X	X	X
LV4 (XL)	12	100	X	X	X	X	X	X	X	100	100	12	125	2	150	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	100	100	10	125	2	150	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	100	100	4	125	2	150	1	X	X	X
LV7	2	100	X	X	X	X	X	X	X	100	100	2	125	2	150	1	X	X	X
JMB112																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	118	2	120	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	64	85	85	118	2	120	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	56	75	75	118	2	120	1	X	X	X
LV4	20	100	X	X	X	X	X	X	X	45	60	60	118	2	120	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	38	50	50	118	2	120	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	30	40	40	118	2	120	1	X	X	X
JM413-JM416																			
LV1	X	X	100	100	100	100	5	40	35	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	60	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	80	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	60	75	100	5	40	10	X	X	X	X	X	X	X	X	X	X
JMB642																			
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
										≤2									
JD660																			
LV1	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X

*Max ramping angle
All values are percentages of original (100%) cutting data.

Nomenclature and formulae

RPM

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_c} \quad \text{(rev/min)}$$

Cutting speed

$$v_c = \frac{n \cdot \pi \cdot D_c}{1000} \quad \text{(m/min)}$$

Feed speed

$$v_f = n \cdot z_n \cdot f_z \quad \text{(mm/min)}$$

Feed per revolution

$$f = z_n \cdot f_z \quad \text{(mm/rev)}$$

Metal removal rate

$$Q = \frac{a_e \cdot a_p \cdot v_f}{1000} \quad \text{(cm}^3\text{/min)}$$

Cutting speed and RPM for copying

$$v_c = \frac{n \cdot \pi \cdot D_w}{1000} \quad \text{(m/min)}$$

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_w} \quad \text{(RPM)}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad \text{(mm)}$$

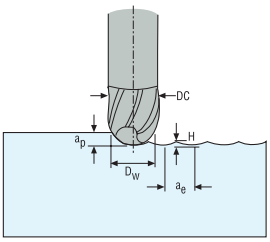
Calculation of a_p vs. overhang length:
If the overhang length (XS) is longer than 4 x DC and Cylindrical shanks are used it is important to adopt another depth of cut (a_p) value than that indicated in the table.
Use the following formula to calculate the new a_p value

$$a_p new = a_p \times (4 \times DC/XS)^2$$

Profile heigth

$$H = \frac{D_c}{2} - \frac{\sqrt{D_c^2 - a_e^2}}{2}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad \text{(mm)}$$



Profile heigth H (um)

DC	Pitch a_e (µm)						
	0,06	0,08	0,11	0,15	0,20	0,3	0,45
1	0,90	1,60	3,00	5,70	10,0	23,0	53,0
2	0,45	0,80	1,50	2,80	5,0	11,0	26,0
4	0,23	0,40	0,76	1,40	2,5	5,60	13,0
6	0,15	0,27	0,50	0,94	1,7	3,80	8,40
8	0,11	0,20	0,38	0,70	1,3	2,80	6,30
10	0,09	0,16	0,30	0,56	1,0	2,30	5,10
12	0,08	0,13	0,25	0,47	0,83	1,90	4,20

a_p = Depth of cut mm/axial depth of cut (mm)
a_e = Width of cut mm/radial depth of cut (mm)
DC = Cutter diameter
f = Feed per revolution (mm/rev)
f_z = Feed per tooth (mm/tooth)
z_n = No. of teeth
n = RPM (rev/min)
Q = Material removal rate (cm³/min)
v_c = Cutting speed (m/min)
v_f = Feed speed (mm/min)
D_w = Working diameter

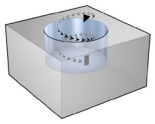
Operation recommendations

Ramping method

The table below shows the feed rate percentage to use at certain ramping angles

Recommended diameter of hole for helical interpolation ramping

Diameter of end mill DC	Diameter of hole
1-2,5	1,4 x DC
3-6	1,3 x DC
8-12	1,2 x DC
16-32	1,15 x DC

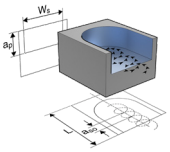


Trochoidal method

The figure below shows a method often called the trochoidal method for milling slots

Recommendation of width of slot

Diameter of end mill DC	Slot width
1-2,5	1,8 x DC
3-6	1,6 x DC
8-12	1,4 x DC
16-32	1,2 x DC



MINIMASTER™

Minimaster™ is a unique, versatile end milling system that can combine different solutions for optimum accessibility and maximum stability and security.

The flexible two-piece design combines shanks and inserts to save time, money and create a versatile tool that enables users to find a solution for almost every application – whether they need to minimize the overhang, attain maximum stability, or more.

- Square Shoulder range: 6-20 mm (.25 - .75 inch)
- Ballnose range: 6-20 mm (.25 - .75 inch)
- Center Drilling/Chamfering range: 6-19,05mm (.25 - .750 inch)
- High Feed range: 8-12 mm (.375 - .625 inch)
- Plunging range: 6-16 mm (.25 - .625 inch)
- Concave Radius range: 12 mm (.472 inch)

Code keys

Shanks

Insert taper size		Shank diameter	Shank length		Shank type 0 = Cylindrical 3 = Cyl/Weldon	Angle of tapered part (10 = 1°)	Length of tapered part	High density anti vibration shank (without sleeve)	Modified version
MM10	-	16	160	.	0	- 10	35	DS	M

3-flute Minimaster inserts

Insert taper size		Diameter (100 = 10,0)	Cutting edge length		Corner radius (B90 = ball nose)	Helix angle 30°		Edge geometry, E = easy operations M = medium operations D = difficult operations 03 = relative edge strength
MM10	-	100	12	-	R10	A30	-	M03

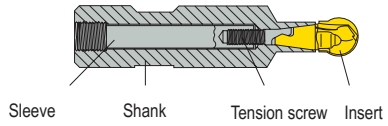
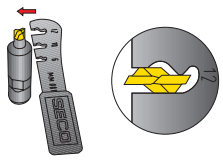
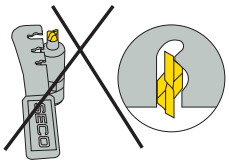
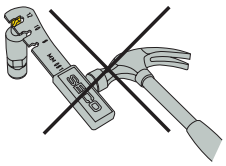
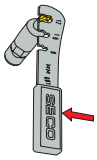
2-flute Minimaster inserts

Insert taper size		Diameter (100 = 10,0)	Cutting edge length		Corner radius A = positive rake angle B = ball nose C = centre drill CR = concave radius 4525 = chamfer 45 x 2,5 mm Rxx-PL = Plunging		Edge geometry, E = for easy conditions M = for medium conditions D = for difficult conditions. 04 = relative edge strength
MM10	-	100	07	-	R04	-	MD04

Note that parts of the code can vary for different types of insert or shanks

Internal through coolant

Mounting instructions for 2-flute Minimaster

Torque wrench	
	The sleeve must be securely tightened in the shank before the tension screw and insert are fitted. If the wrench cannot be used for changing the insert (If the insert has broken off or jammed in the shank) , the sleeve can be released, which will also release the insert. Use Allen key (turn it anti-clockwise) to back off the sleeve until the insert is free. Re-tighten the sleeve in the shank before fitting the tension screw and the new insert. For 3-flute Minimaster another key (MM0416) must be used (Key grip on hexagonal part of the insert.)
	Make sure that the wrench is used correctly
	If the wrench is used on the wrong side, it will cause damage
	Do not use excessve force
	Normal hand-power is quite sufficient

Selection guide

1. Select taper size
The design of the workpiece and the machining operations determines suitable taper size. Select the largest possible taper size for best strength and stability.

2. Select insert
a. Use the tables beginning on page 676 to classify the workpiece material into a Seco material group.
b. Look up the pages for the selected taper size and choose a suitable insert in the insert selection table.

3. Select shank
a. Look up the pages for the selected taper size and choose a suitable shank in the tool data table.
b. Always choose the shortest shank possible to achieve the best possible stability.

4. Select cutting data
a. Cutting speed recommendations are found in the cutting data tables for each selected taper size. Cutting data recommendations are based on stable conditions and might therefore need to be adjusted depending on the stability in the application (tooling, machine & workpiece fixturing). General rule for max ap in slotting is DC*0.3= Max APMXS. (See figure 1)
b. Feed and cutting speed recommendations are found in the cutting data conversion table.
c. Maximum RPM that for safety reasons should never be exceeded, are shown on page N/A.
d. If the cutter is not fully engaged the feed per tooth and the cutting speed should be increased compared to the recommendations for a fully engaged cutter. The reason for that is to keep the average chip thickness and the working temperature in the cutting zone.
e. Divide the radial depth of cut with the cutter diameter to get the actual cutter engagement percentage(a_e/DC%), for ball nose cutters use the effective working diameter D_w instead of DC (See figure 2 & 6)
f. Use the percentage to get a correct feed per tooth and cutting speed recommendation for the actual cutter engagement.

5. General
- When milling in corners and bottoms of cavities the feed rate should be reduced due to the increase of the average chip thickness. Use the feed per tooth recommendations for a fully engaged cutter.
- When steep down copying with an angle bigger than 40° or steep up copying with an angle bigger than 30° in combination with small depths of cut, use the diameter (DC) as working diameter instead of Dw.
- When calculating feed per revolution and feed speed, always use the ZEFP-value. That is the effective number of teeth to use for cutting data calculations. The ZEFP-value can be found in the insert selection table.

Note! There will be a deterioration in the surface finish on the workpiece when the feed rate is increased. (See figure 3 & 5)

Minimaster figures

Figure 1	Figure 2

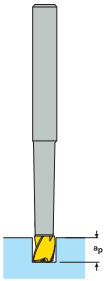
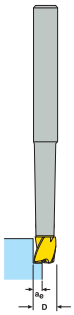

	

Figure 3	**Figure 4**

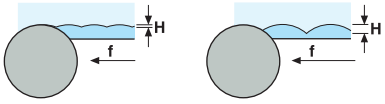
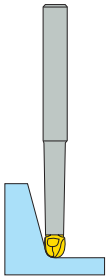
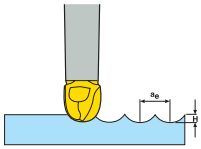
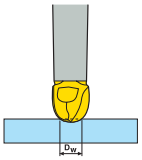
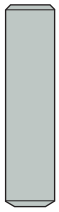
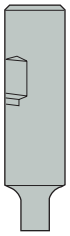
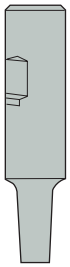
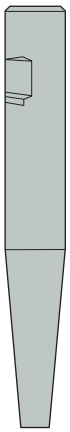
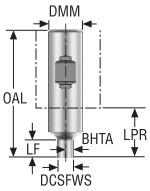

	

Figure 5	**Figure 6**
	

Shank design

Design 1, Keyway shank	Design 2, Cylindrical/Weldon back end and 90º front
	
Design 3, Cylindrical/Weldon back end tapered front 87º/89º	**Design 4, Cylindrical/Weldon back end tapered front 80º/85º/87º**
	
Design 5, Cylindrical back end double tapered front end 89º/85º	

MM06 Shank – Metric



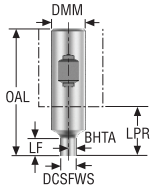
Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM06-12070.3-0005	75080695	Weldon	5,75	12,0	70,0	5,0	25,0	0,0	2	✓	80000	0,1	1
MM06-16075.3-3009	75080696	Weldon	5,75	16,0	75,0	9,0	27,0	3,0	3	✓	80000	0,1	1
MM06-16110.3-5058	75080697	Weldon	5,75	16,0	110,0	58,6	62,0	5,0	4	✓	80000	0,1	4
MM06-10040.0-0007	00094747	Cylindrical	5,75	10,0	40,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM06-12065.0-0000	75080694	Cylindrical	5,7	12,0	65,0	0,0	15,0	60,0	1	✓	80000	0,1	1
MM06-16140.0-1020M	00027102	Cylindrical	5,75	16,0	140,0	20,0	92,0	1,0	3	✓	80000	0,2	5
MM06-16140.0-1035M	00027103	Cylindrical	5,75	16,0	140,0	35,0	92,0	1,0	3	✓	80000	0,2	6
MM06-16140.0-1050M	00094748	Cylindrical	5,75	16,0	140,0	50,0	92,0	1,0	3	✓	80000	0,2	6
MM06-10050.0-0007DS	02580666	Cylindrical	5,75	10,0	50,0	7,0	7,0	0,0	2	✓	80000	0,1	3
MM06-10075.0-3041DS	02580701	Cylindrical	5,75	10,0	75,0	40,5	35,0	3,0	4	✓	80000	0,1	3
MM06-10100.0-1035DS	02580713	Cylindrical	5,75	10,0	100,0	35,0	60,0	1,0	3	✓	80000	0,1	3
MM06-12120.0-1050DS	02580714	Cylindrical	5,75	12,0	120,0	50,0	75,0	1,0	3	✓	80000	0,2	3
MM06-16090.0-0012DS	02580670	Cylindrical	5,75	16,0	90,0	12,0	42,0	0,0	2	✓	80000	0,3	3
MM06-16095.0-0024DS	02580673	Cylindrical	5,75	16,0	95,0	24,0	47,0	0,0	2	✓	80000	0,3	3
MM06-16140.0-1050DS	02580717	Cylindrical	5,75	16,0	140,0	50,0	92,0	1,0	3	✓	80000	0,3	3
MM06-16140.0-1035DS	02580716	Cylindrical	5,75	16,0	140,0	35,0	92,0	1,0	3	✓	80000	0,4	3
MM06-20250.0-1035DS	02580718	Cylindrical	5,75	20,0	250,0	35,0	190,0	1,0	5	✓	80000	0,9	3

Spare Parts, included in delivery

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
1	MM-035046	MM06-03518	H05-4
4	MM-035091	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4
3	–	MM06-03518	–

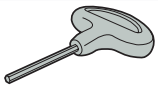
MM06 Shank – *Inch*



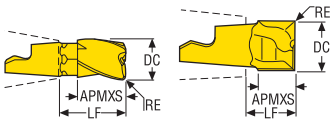
Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			inch	inch	inch	inch	inch					lbs	
MM06-0.50-2.8-3-0002	00096108	Weldon	0.224	0.500	2.756	0.197	0.984	0,0	2	✓	80000	0.220	1
MM06-0.62-3.0-3-3003	00096116	Weldon	0.224	0.625	2.953	0.354	1.063	3,0	1	✓	80000	0.220	1
MM06-0.62-4.3-3-5022	00096117	Weldon	0.224	0.625	4.331	2.291	2.441	5,0	2	✓	80000	0.440	4
MM06-0.38-1.6-0-0002	00096107	Cylindrical	0.224	0.375	1.575	0.276	0.276	0,0	2	✓	80000	0.220	2
MM06-0.50-2.6-0-0000	00096106	Cylindrical	0.224	0.500	2.559	0	0.787	60,0	1	✓	80000	0.220	1
MM06-0.62-5.5-0-1007	00096111	Cylindrical	0.224	0.625	5.512	0.787	3.622	1,0	3	✓	80000	0.440	5
MM06-0.62-5.5-0-1013	00096112	Cylindrical	0.224	0.625	5.512	1.378	3.622	1,0	3	✓	80000	0.440	6
MM06-0.62-5.5-0-1019	00096114	Cylindrical	0.224	0.625	5.512	1.969	3.622	1,0	3	✓	80000	0.440	6
MM06-0.62-3.5-0-0004DS	02593394	Cylindrical	0.224	0.625	3.543	0.472	1.654	0,0	2	✓	80000	0.660	3
MM06-0.62-3.7-0-0009DS	02593395	Cylindrical	0.224	0.625	3.740	0.945	1.850	0,0	2	✓	80000	0.660	3
MM06-0.62-5.5-0-1013DS	02593396	Cylindrical	0.224	0.625	5.512	1.378	3.622	1,0	3	✓	80000	0.880	3
MM06-0.62-5.5-0-1019DS	02593397	Cylindrical	0.224	0.625	5.512	1.969	3.622	1,0	3	✓	80000	0.660	3
MM06-0.75-10.0-0-1013DS	02593399	Cylindrical	0.224	0.750	9.843	1.378	7.874	1,0	5	✓	80000	1.980	3

Spare Parts, included in delivery

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
1	MM-035046	MM06-03518	H05-4
4	MM-035091	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4
3	–	MM06-03518	–

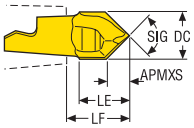
Slot milling/square shoulder milling



• For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM06-05804T-R02-D02	5,8 *0.228*	4,1 *0.161*	0,2 *0.008*	5,1 *0.201*	15,0	7,2	11,0	0	2	MM0612		■			
MM06-05807-R02A30-M02	5,8 *0.228*	7,5 *0.295*	0,2 *0.008*	9,9 *0.390*	15,0	7,2	11,0	30	3	MM0416	✓				■
MM06-06004-M02	6,0 *0.236*	4,1 *0.161*	0,0 –	5,1 *0.201*	15,0	7,4	11,8	0	2	MM0612		■			
MM06-06004-R04-MD02	6,0 *0.236*	4,1 *0.161*	0,4 *0.016*	5,1 *0.201*	15,0	7,4	11,0	0	2	MM0612		■		■	
MM06-06004-R10-MD02	6,0 *0.236*	4,1 *0.161*	1,0 *0.039*	5,1 *0.201*	15,0	7,4	9,8	0	2	MM0612				■	
MM06-06007-A30-E02	6,0 *0.236*	7,5 *0.295*	0,0 –	9,9 *0.390*	15,0	7,4	11,8	30	3	MM0416	✓			■	
MM06-06007-R05A30-M02	6,0 *0.236*	7,5 *0.295*	0,5 *0.020*	9,9 *0.390*	15,0	7,4	10,8	30	3	MM0416	✓				■
MM06-06007-R10A30-D02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-E02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-M02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓				■
MM06-06007-R20A30-M02	6,0 *0.236*	7,5 *0.295*	2,0 *0.079*	9,9 *0.390*	15,0	7,4	7,8	30	3	MM0416	✓				■
MM06-06407-A30-E02	6,35 *0.250*	7,5 *0.295*	0,0 –	9,9 *0.390*	15,0	7,8	12,5	30	3	MM0416	✓			■	
MM06-06407-R04A30-M02	6,35 *0.250*	7,5 *0.295*	0,4 *0.016*	9,9 *0.390*	15,0	7,8	11,7	30	3	MM0416	✓				■
MM06-06407-R08A30-M02	6,35 *0.250*	7,5 *0.295*	0,8 *0.031*	9,9 *0.390*	15,0	7,8	10,9	30	3	MM0416	✓				■

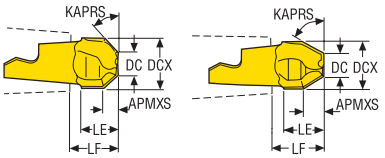
Centre drilling



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	LE	LF	SIG°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-06003-C120-M02	6,0 *0.236*	1,6 *0.063*	6,27 *0.247*	7,19 *0.283*	120,0	2	MM0612	■			
MM06-06003-C90-M02	6,0 *0.236*	2,86 *0.113*	6,0 *0.236*	7,12 *0.280*	90,0	2	MM0612	■			

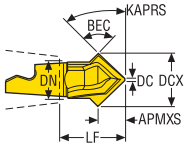
Chamfering



- For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-06004-4515-E02	6,0 *0.236*	1,8 *0.071*	2,1 *0.083*	4,0 *0.157*	5,1 *0.201*	45,0	2	MM0612	■			
MM06-06004-6015-E02	6,0 *0.236*	3,14 *0.124*	2,4 *0.094*	4,6 *0.181*	5,75 *0.226*	60,0	2	MM0612	■			

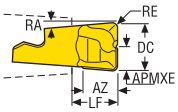
Double chamfering



• For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	LF	DN	BEC°	KAPRS°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM06-08008-D4510P-M02	8,0 *0.315*	0,6 *0.024*	3,7 *0.146*	8,5 *0.335*	6,0 *0.236*	90,0	45,0	2	MM0612		■		

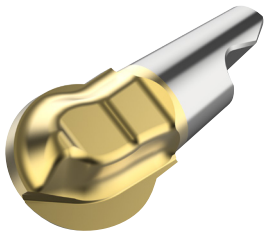
Plunge milling

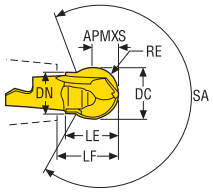


• For Torque keys and torque values, see page 673

Designation	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-06004-R10-PL-MD02	6,0 *0.236*	3,0 *0.118*	1,0 *0.039*	4,3 *0.169*	5,08 *0.200*	5,0	2	MM0612			■	

Precision inserts for semi-finishing in all materials

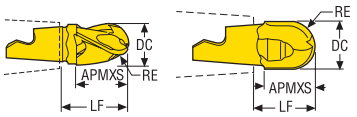




- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LE	LF	DN	SA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-08008-B120PF-M01	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	8,73 *0.344*	6,0 *0.236*	263,0	2	MM0612		■		
MM06-08008-B120P-M03	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	8,73 *0.344*	6,0 *0.236*	263,0	2	MM0612			■	

Copy milling



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM06-06006-B90-MD02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*	0,0	2	MM0612		■		■	
MM06-06006-B90PF-M01	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*	0,0	2	MM0612			■		
MM06-06006-B90P-M02	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*	0,0	2	MM0612				■	
MM06-06006-B90S-E02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*	0,0	2	MM0612				■	
MM06-06007-B90A30-E02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓			■	
MM06-06007-B90A30-M02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓				■
MM06-06406-B90P-M02	6,35 *0.250*	5,4 *0.213*	3,175 *0.125*	7,22 *0.284*	0,0	2	MM0612				■	
MM06-06406-B90S-E02	6,35 *0.250*	6,3 *0.248*	3,175 *0.125*	7,24 *0.285*	0,0	2	MM0612				■	

MM06 - Slot and Side milling – Insert selection – Metric / *Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P6	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P7	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P8	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P12	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,020 *0.00080*	0,020 *0.00080*	0,022 *0.00085*	0,030 *0.0012*
M1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
M3	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
M4	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
M5	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
K1	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,038 *0.0015*	0,050 *0.0020*
K2	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N2	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N3	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N11	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
S1	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 *0.0011*	0,026 *0.0010*	0,025 *0.0010*	0,032 *0.0013*
S2	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 *0.0011*	0,026 *0.0010*	0,025 *0.0010*	0,032 *0.0013*
S3	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,026 *0.0010*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0012*
S11	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
S12	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
S13	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H5	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 *0.0010*	0,024 *0.00095*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*
H11	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 *0.0010*	0,024 *0.00095*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*
H21	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

MM06 - Slot and Side milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	280 *920*	350 *1150*	395 *1300*	435 *1425*	270 *890*	335 *1100*	375 *1225*	415 *1350*	220 *720*	270 *890*	300 *980*	330 *1075*
P2	275 *900*	340 *1125*	380 *1250*	420 *1375*	260 *850*	325 *1075*	365 *1200*	400 *1300*	210 *690*	260 *850*	295 *970*	320 *1050*
P3	240 *790*	295 *970*	330 *1075*	365 *1200*	225 *740*	285 *940*	315 *1025*	350 *1150*	185 *610*	230 *750*	255 *840*	280 *920*
P4	210 *690*	260 *850*	295 *970*	320 *1050*	200 *660*	250 *820*	280 *920*	305 *1000*	160 *520*	200 *660*	225 *740*	245 *800*
P5	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	295 *970*	155 *510*	190 *620*	215 *710*	235 *770*
P6	225 *740*	285 *940*	315 *1025*	345 *1125*	215 *710*	270 *890*	300 *980*	330 *1075*	175 *570*	215 *710*	240 *790*	265 *870*
P7	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	285 *940*	310 *1025*	165 *540*	205 *670*	230 *750*	250 *820*
P8	200 *660*	250 *820*	280 *920*	305 *1000*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P11	210 *690*	260 *850*	290 *950*	320 *1050*	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	200 *660*	220 *720*	245 *800*
P12	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	100 *330*	125 *410*	135 *445*	150 *490*
M1	— —	— —	— —	— —	210 *690*	265 *870*	295 *970*	320 *1050*	170 *560*	210 *690*	235 *770*	260 *850*
M2	— —	— —	— —	— —	175 *570*	215 *710*	240 *790*	265 *870*	140 *460*	170 *560*	195 *640*	210 *690*
M3	— —	— —	— —	— —	135 *445*	165 *540*	190 *620*	205 *670*	110 *360*	135 *445*	150 *490*	165 *540*
M4	— —	— —	— —	— —	105 *345*	130 *425*	145 *475*	155 *510*	85 *280*	105 *345*	115 *375*	125 *410*
M5	— —	— —	— —	— —	85 *280*	105 *345*	120 *395*	130 *425*	70 *230*	85 *280*	95 *310*	105 *345*
K1	215 *710*	270 *890*	305 *1000*	335 *1100*	205 *670*	260 *850*	290 *950*	315 *1025*	165 *540*	210 *690*	230 *750*	255 *840*
K2	190 *620*	235 *770*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	150 *490*	180 *590*	205 *670*	225 *740*
K3	160 *520*	200 *660*	225 *740*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	125 *410*	155 *510*	175 *570*	190 *620*
K4	155 *510*	190 *620*	215 *710*	235 *770*	145 *475*	180 *590*	205 *670*	225 *740*	120 *395*	145 *475*	165 *540*	180 *590*
K5	95 *310*	115 *375*	130 *425*	145 *475*	90 *295*	110 *360*	125 *410*	135 *445*	70 *230*	90 *295*	100 *330*	110 *360*
K6	135 *445*	170 *560*	190 *620*	210 *690*	130 *425*	160 *520*	180 *590*	200 *660*	105 *345*	130 *425*	145 *475*	160 *520*
K7	120 *395*	150 *490*	165 *540*	180 *590*	115 *375*	140 *460*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
N1	1650 *5425*	2050 *6725*	2325 *7625*	2525 *8275*	1575 *5175*	1975 *6475*	2200 *7225*	2400 *7875*	1275 *4175*	1575 *5175*	1775 *5825*	1950 *6400*
N2	670 *2200*	830 *2725*	930 *3050*	1025 *3375*	640 *2100*	790 *2600*	890 *2925*	970 *3175*	510 *1675*	640 *2100*	710 *2325*	790 *2600*
N3	445 *1450*	560 *1825*	620 *2025*	680 *2225*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	340 *1125*	425 *1400*	475 *1550*	530 *1750*
N11	510 *1675*	630 *2075*	710 *2325*	780 *2550*	485 *1600*	600 *1975*	680 *2225*	740 *2425*	390 *1275*	485 *1600*	540 *1775*	600 *1975*
S1	50 *165*	65 *215*	70 *230*	75 *245*	49 *160*	60 *195*	65 *215*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
S2	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	32 *105*	39 *130*	44 *145*	48 *155*
S3	36 *120*	44 *145*	49 *160*	55 *180*	34 *110*	42 *140*	47 *155*	50 *165*	27 *90*	34 *110*	38 *125*	41 *135*
S11	— —	— —	— —	— —	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	70 *230*	75 *245*	85 *280*
S12	— —	— —	— —	— —	48 *155*	60 *195*	65 *215*	70 *245*	38 *125*	48 *155*	55 *180*	60 *195*
S13	— —	— —	— —	— —	27 *90*	34 *110*	38 *125*	41 *135*	22 *70*	27 *90*	30 *100*	33 *110*
H5	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	33 *110*	41 *135*	45 *150*	50 *165*
H8	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*
H11	55 *180*	65 *215*	75 *245*	85 *280*	50 *165*	65 *215*	70 *230*	80 *260*	42 *140*	50 *165*	60 *195*	65 *215*
H12	80 *260*	95 *310*	110 *360*	120 *395*	75 *245*	90 *295*	105 *345*	115 *375*	60 *195*	75 *245*	85 *280*	90 *295*
H21	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*

MM06 Z3-Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P8	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P12	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
M1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
M3	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,028 *0.0011*	0,026 *0.0010*	0,028 *0.0011*	0,036 *0.0014*
M4	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
M5	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
S1	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
S2	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
S3	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,024 *0.00095*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0012*
S11	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,036 *0.0014*
S12	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,036 *0.0014*
S13	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM06 Z3-Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P8	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P12	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
M2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M3	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
M4	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
M5	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,090 *0.0036*
K6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,090 *0.0036*
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S2	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S3	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
S12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
S13	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM06 Z3-Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	295 *970*	350 *1150*	370 *1225*	405 *1325*	400 *1300*	280 *920*	330 *1075*	355 *1175*	385 *1275*	380 *1250*
P2	285 *940*	340 *1125*	360 *1175*	395 *1300*	390 *1275*	275 *900*	325 *1075*	345 *1125*	375 *1225*	370 *1225*
P3	250 *820*	295 *970*	315 *1025*	340 *1125*	340 *1125*	235 *770*	280 *920*	300 *980*	320 *1050*	325 *1075*
P4	220 *720*	260 *850*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*
P5	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*
P6	235 *770*	275 *900*	295 *970*	320 *1050*	320 *1050*	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*
P7	225 *740*	260 *850*	280 *920*	305 *1000*	300 *980*	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*
P8	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P11	215 *710*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*
P12	135 *445*	160 *520*	165 *560*	180 *590*	180 *590*	125 *410*	150 *490*	160 *520*	170 *560*	170 *560*
M1	230 *750*	275 *900*	290 *950*	315 *1025*	315 *1025*	220 *720*	260 *850*	280 *920*	300 *980*	300 *980*
M2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*
M3	150 *490*	180 *590*	185 *610*	200 *660*	200 *660*	140 *460*	170 *560*	175 *590*	190 *620*	190 *620*
M4	105 *345*	145 *475*	140 *490*	150 *490*	150 *490*	100 *330*	135 *445*	135 *460*	145 *475*	145 *475*
M5	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*	85 *280*	115 *375*	110 *395*	120 *395*	120 *395*
K1	230 *750*	270 *890*	285 *940*	310 *1025*	310 *1025*	215 *710*	255 *840*	275 *900*	295 *970*	295 *970*
K2	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
K3	170 *560*	200 *660*	210 *690*	230 *750*	230 *750*	160 *520*	190 *620*	200 *660*	220 *720*	220 *720*
K4	160 *520*	190 *620*	205 *670*	220 *720*	220 *720*	155 *510*	180 *590*	195 *640*	210 *690*	210 *690*
K5	95 *310*	115 *375*	120 *395*	130 *425*	130 *425*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
K6	140 *460*	165 *540*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K7	125 *410*	145 *475*	155 *510*	170 *560*	170 *560*	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*
N1	1750 *5750*	2075 *6800*	2200 *7225*	2375 *7800*	2375 *7800*	1675 *5500*	1975 *6475*	2100 *6900*	2275 *7475*	2250 *7375*
N2	710 *2325*	830 *2725*	890 *2925*	960 *3150*	950 *3125*	670 *2200*	790 *2600*	850 *2800*	920 *3025*	910 *2975*
N3	470 *1550*	560 *1825*	590 *1925*	640 *2100*	640 *2100*	450 *1475*	530 *1750*	570 *1875*	610 *2000*	610 *2000*
N11	540 *1775*	630 *2075*	680 *2225*	730 *2400*	730 *2400*	510 *1675*	600 *1975*	650 *2125*	700 *2300*	690 *2275*
S1	49 *160*	65 *215*	65 *230*	70 *230*	70 *230*	46 *150*	65 *215*	65 *215*	70 *230*	65 *215*
S2	39 *130*	55 *180*	55 *180*	55 *180*	55 *180*	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*
S3	34 *110*	47 *155*	46 *155*	50 *165*	49 *160*	32 *105*	44 *145*	44 *150*	47 *155*	47 *155*
S11	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*
S12	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*
S13	27 *90*	38 *125*	37 *130*	40 *130*	40 *130*	26 *85*	36 *120*	35 *120*	38 *125*	38 *125*
H5	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*	42 *140*	50 *165*	55 *180*	55 *180*	55 *180*
H8	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H11	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	55 *180*	65 *215*	65 *230*	70 *230*	75 *245*
H12	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
H21	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*

Seco

MM06 Z2-Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 *0.0012*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
P6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P8	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P12	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
M1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M3	MM06-06006-B90S-E02 F30M	2,0 *0.080*	0,024 *0.00095*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
M4	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
M5	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
K1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
K2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,026 *0.0010*	0,026 *0.0010*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,026 *0.0010*	0,026 *0.0010*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N11	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
S1	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
S2	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
S3	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,020 *0.00080*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0012*
S11	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
S12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
S13	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
H5	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*
H11	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*
H21	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM06 Z2-Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P8	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P12	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
M1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
M2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
M3	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
M4	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
M5	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
K1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
K2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
K6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
N1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
S1	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S2	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S3	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,013 *0.00050*	0,014 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
S11	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
S12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
S13	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
H5	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H8	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H11	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H21	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

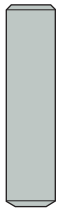
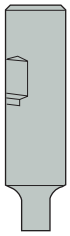
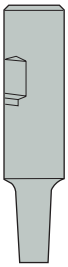
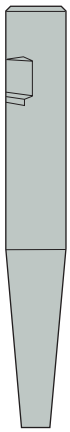
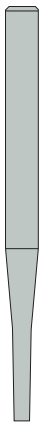
Seco

Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

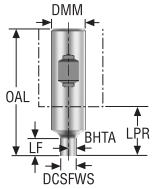
MM06 Z2-Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	325 *1075*	415 *1350*	430 *1400*	470 *1550*	465 *1525*	275 *900*	345 *1125*	375 *1225*	405 *1325*	405 *1325*	225 *740*	280 *920*	305 *1000*	330 *1075*	325 *1075*
P2	320 *1050*	400 *1300*	420 *1375*	455 *1500*	455 *1500*	265 *870*	335 *1100*	365 *1200*	395 *1300*	395 *1300*	215 *710*	270 *890*	295 *970*	320 *1050*	320 *1050*
P3	275 *900*	345 *1125*	360 *1175*	395 *1300*	395 *1300*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*
P4	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	205 *670*	255 *840*	280 *920*	305 *1000*	300 *980*	165 *540*	205 *670*	225 *740*	245 *800*	245 *800*
P5	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	290 *950*	290 *950*	160 *520*	200 *660*	215 *710*	235 *770*	235 *770*
P6	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	220 *720*	275 *900*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P7	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	210 *690*	260 *850*	285 *940*	305 *1000*	305 *1000*	170 *560*	210 *690*	230 *750*	250 *820*	245 *800*
P8	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	285 *940*	290 *950*	160 *520*	200 *660*	215 *710*	230 *750*	235 *770*
P11	240 *790*	300 *980*	315 *1025*	340 *1125*	340 *1125*	200 *660*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
P12	145 *475*	185 *610*	190 *620*	205 *670*	205 *670*	130 *425*	160 *520*	170 *560*	180 *590*	180 *590*	105 *345*	130 *425*	135 *445*	145 *475*	145 *475*
M1	255 *840*	325 *1075*	340 *1125*	365 *1200*	365 *1200*	215 *710*	270 *890*	295 *970*	320 *1050*	315 *1025*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*
M2	210 *690*	265 *870*	275 *900*	300 *980*	300 *980*	175 *570*	220 *720*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
M3	165 *540*	210 *690*	210 *710*	230 *750*	230 *750*	140 *460*	180 *590*	185 *620*	205 *670*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	165 *540*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	140 *490*	155 *510*	155 *510*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*
M5	105 *345*	135 *445*	130 *475*	145 *475*	145 *475*	95 *310*	120 *395*	120 *410*	130 *425*	130 *425*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
K1	250 *820*	320 *1050*	335 *1100*	360 *1175*	360 *1175*	210 *690*	265 *870*	290 *950*	315 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*
K2	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	185 *610*	230 *750*	255 *840*	275 *900*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
K3	185 *610*	235 *770*	245 *800*	265 *870*	265 *870*	160 *520*	195 *640*	215 *710*	230 *750*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*
K4	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	150 *490*	185 *610*	205 *670*	220 *720*	220 *720*	120 *395*	150 *490*	165 *540*	180 *590*	180 *590*
K5	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*	90 *295*	115 *375*	125 *410*	135 *445*	135 *445*	75 *245*	90 *295*	100 *330*	110 *360*	105 *345*
K6	155 *510*	195 *640*	205 *670*	225 *740*	225 *740*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	105 *345*	135 *445*	145 *475*	160 *520*	155 *510*
K7	135 *445*	170 *560*	180 *590*	195 *640*	195 *640*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	140 *460*
N1	1975 *6475*	2475 *8125*	2600 *8525*	2800 *9175*	2800 *9175*	1625 *5325*	2050 *6725*	2225 *7300*	2400 *7875*	2375 *7800*	1325 *4350*	1650 *5425*	1800 *5900*	1950 *6400*	1925 *6325*
N2	790 *2600*	1000 *3275*	1050 *3450*	1125 *3700*	1125 *3700*	660 *2175*	820 *2700*	900 *2950*	970 *3175*	960 *3150*	530 *1750*	670 *2200*	730 *2400*	790 *2600*	780 *2550*
N3	530 *1750*	670 *2200*	700 *2300*	760 *2500*	750 *2450*	440 *1450*	550 *1800*	600 *1975*	650 *2125*	640 *2100*	355 *1175*	445 *1450*	485 *1600*	520 *1700*	520 *1700*
N11	600 *1975*	760 *2500*	800 *2625*	860 *2825*	860 *2825*	500 *1650*	630 *2075*	680 *2225*	740 *2425*	730 *2400*	405 *1325*	510 *1675*	550 *1800*	600 *1975*	590 *1925*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	43 *150*	47 *155*	47 *155*
S3	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*	36 *120*	46 *150*	46 *160*	50 *165*	50 *165*	29 *95*	37 *120*	38 *130*	40 *130*	40 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	75 *245*	95 *310*	95 *310*	105 *345*	100 *330*	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*
S12	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	41 *135*	55 *180*	55 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	29 *95*	37 *120*	37 *130*	40 *130*	40 *130*	24 *80*	30 *100*	30 *105*	33 *110*	33 *110*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	45 *150*	49 *160*	49 *160*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	80 *260*	85 *280*	90 *295*	90 *295*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*

Shank design

Design 1, Keyway shank	Design 2, Cylindrical/Weldon back end and 90º front
	
Design 3, Cylindrical/Weldon back end tapered front 87º/89º	**Design 4, Cylindrical/Weldon back end tapered front 80º/85º/87º**
	
Design 5, Cylindrical back end double tapered front end 89º/85º	
	

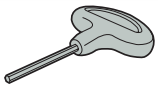
MM08 Shank – Metric



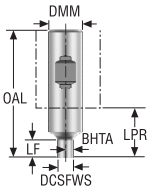
Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM08-16070.3-0007	75034241	Weldon	7,6	16,0	70,0	7,6	22,0	0,0	2	✓	80000	0,1	1
MM08-16075.3-3012	75034242	Weldon	7,6	16,0	75,0	12,0	27,0	3,0	3	✓	80000	0,1	1
MM08-16120.3-5048M	00042863	Weldon	7,6	16,0	120,0	48,0	72,0	5,0	4	✓	80000	0,2	5
MM08-10040.0-0007	00083980	Cylindrical	7,6	10,0	40,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM08-12065.0-0000	75034240	Cylindrical	7,6	12,0	65,0	0,0	20,0	60,0	1	✓	80000	0,1	1
MM08-16150.0-1030M	00094751	Cylindrical	7,6	16,0	150,0	30,0	102,0	1,0	3	✓	80000	0,2	5
MM08-16150.0-1050M	00094752	Cylindrical	7,6	16,0	150,0	50,0	102,0	1,0	3	✓	80000	0,2	4
MM08-16150.0-1070M	00094754	Cylindrical	7,6	16,0	150,0	70,0	102,0	1,0	3	✓	80000	0,2	4
MM08-10050.0-0007DS	02580665	Cylindrical	7,6	10,0	50,0	7,0	10,0	0,0	2	✓	80000	0,1	3
MM08-10080.0-3023DS	02580702	Cylindrical	7,6	10,0	80,0	22,9	40,0	3,0	4	✓	80000	0,1	3
MM08-12100.0-1035DS	02580719	Cylindrical	7,6	12,0	100,0	35,0	55,0	1,0	3	✓	80000	0,2	3
MM08-12120.0-1050DS	02580720	Cylindrical	7,6	12,0	120,0	50,0	75,0	1,0	3	✓	80000	0,2	3
MM08-16085.0-0016DS	02580675	Cylindrical	7,6	16,0	85,0	16,0	37,0	0,0	2	✓	80000	0,3	3
MM08-16100.0-0032DS	02580687	Cylindrical	7,6	16,0	100,0	32,0	52,0	0,0	2	✓	80000	0,3	3
MM08-16150.0-1050DS	02580722	Cylindrical	7,6	16,0	150,0	50,0	102,0	1,0	3	✓	80000	0,4	3
MM08-16150.0-1070DS	02580727	Cylindrical	7,6	16,0	150,0	70,0	102,0	1,0	3	✓	80000	0,3	3

Spare Parts, included in delivery

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
1	MM-05044	MM08-0524	H05-4
5	MM-05044	MM08-0543	H05-4
2	MM-05019	MM08-0524	H05-4
4	MM-05044	MM08-0582	H05-4
3	–	MM08-0524	–

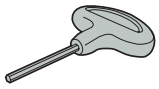
MM08 Shank – *Inch*



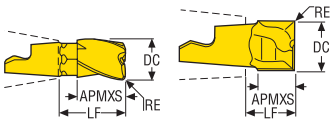
Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			inch	inch	inch	inch	inch					lbs	
MM08-0.62-2.8-3-0003	75054600	Weldon	0.299	0.625	2.756	0.299	0.866	0,0	2	✓	80000	0.220	1
MM08-0.62-3.0-3-3004	75054601	Weldon	0.299	0.625	2.953	0.472	1.063	3,0	3	✓	80000	0.220	1
MM08-0.62-4.7-3-5018	75054602	Weldon	0.299	0.625	4.724	1.850	2.835	5,0	4	✓	80000	0.440	2
MM08-0.38-1.6-0-0002	00096119	Cylindrical	0.299	0.375	1.575	0.276	0.276	0,0	2	✓	80000	0.220	3
MM08-0.50-2.6-0-0000	75054599	Cylindrical	0.299	0.500	2.559	0	0.787	60,0	1	✓	80000	0.220	1
MM08-0.62-5.9-0-1011	75054604	Cylindrical	0.299	0.625	5.906	1.181	4.016	1,0	3	✓	80000	0.440	2
MM08-0.62-3.3-0-0006DS	02593402	Cylindrical	0.299	0.625	3.346	0.630	1.457	0,0	2	✓	80000	0.660	4
MM08-0.62-4.0-0-0012DS	02593403	Cylindrical	0.299	0.625	3.937	1.260	2.047	0,0	2	✓	80000	0.660	4
MM08-0.62-5.9-0-1019DS	02593407	Cylindrical	0.299	0.625	5.906	1.969	4.016	1,0	3	✓	80000	0.880	4
MM08-0.62-5.9-0-1027DS	02593410	Cylindrical	0.299	0.625	5.906	2.756	4.016	1,0	3	✓	80000	0.660	4
MM08-0.75-10.0-0-1019DS	02593413	Cylindrical	0.299	0.750	9.843	1.969	7.874	1,0	5	✓	80000	1.980	4

Spare Parts, included in delivery

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
1	MM-05044	MM08-0524	H05-4
2	MM-05044	MM08-0543	H05-4
3	MM-05019	MM08-0524	H05-4
4	–	MM08-0524	–

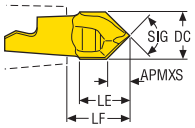
Slot milling/square shoulder milling



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM08-07805T-R02-D03	7,8 *0.307*	5,4 *0.213*	0,2 *0.008*	6,8 *0.268*	15,0	9,6	15,0	0	2	MM0612		■			
MM08-07809-R02A30-M03	7,8 *0.307*	10,0 *0.394*	0,2 *0.008*	13,0 *0.512*	15,0	9,6	15,0	30	3	MM0416	✓				■
MM08-08005-M03	8,0 *0.315*	5,5 *0.217*	0,0 *–*	6,8 *0.268*	15,0	9,8	15,8	0	2	MM0612		■			
MM08-08005-R04A8-E03	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	8	2	MM0612		■		■	
MM08-08005-R04-MD03	8,0 *0.315*	5,5 *0.217*	0,4 *0.016*	6,8 *0.268*	15,0	9,8	15,0	0	2	MM0612		■		■	
MM08-08005-R04P-M02	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	0	2	MM0612				■	
MM08-08005-R10-MD03	8,0 *0.315*	5,4 *0.213*	1,0 *0.039*	6,8 *0.268*	15,0	9,8	13,8	0	2	MM0612				■	
MM08-08009-A30-E03	8,0 *0.315*	10,0 *0.394*	0,0 *–*	13,0 *0.512*	15,0	9,8	15,0	30	3	MM0416	✓			■	
MM08-08009-R05A30-M03	8,0 *0.315*	10,0 *0.394*	0,5 *0.020*	13,0 *0.512*	15,0	9,8	14,8	30	3	MM0416	✓				■
MM08-08009-R10A30-D03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-E03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-M03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓				■
MM08-08009-R20A30-M03	8,0 *0.315*	10,0 *0.394*	2,0 *0.079*	13,0 *0.512*	15,0	9,8	11,8	30	3	MM0416	✓				■
MM08-08009-R30A30-M03	8,0 *0.315*	10,0 *0.394*	3,0 *0.118*	13,0 *0.512*	15,0	9,8	9,8	30	3	MM0416	✓				■

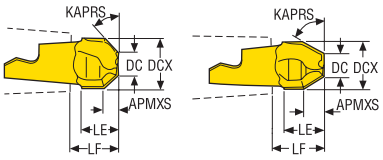
Centre drilling



• For Torque keys and torque values, see page 673

Designation	DC	APMXS	LE	LF	SIG°	ZEFP	Wrench	Grades Coated T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							
MM08-08004-C90-M03	8,0 *0.315*	3,79 *0.149*	8,0 *0.315*	9,5 *0.374*	90,0	2	MM0612	■			
MM08-08006-C120-M03	8,0 *0.315*	2,15 *0.085*	8,32 *0.328*	9,46 *0.372*	120,0	2	MM0612	■			

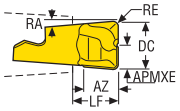
Chamfering



• For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Wrench	Grades Coated T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							
MM08-08005-4520-E03	8,0 *0.315*	3,87 *0.152*	2,1 *0.083*	5,5 *0.217*	6,7 *0.264*	45,0	2	MM0612	■			
MM08-08006-6030-E03	8,0 *0.315*	4,19 *0.165*	3,3 *0.130*	6,45 *0.254*	7,66 *0.302*	60,0	2	MM0612	■			

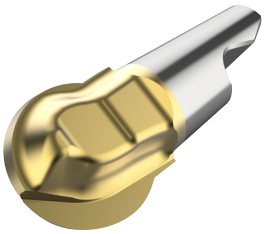
Plunge milling

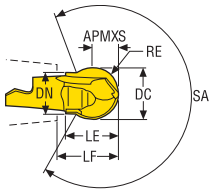


- For Torque keys and torque values, see page 673

Designation	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM08-08005-R10-PL-MD03	8,0 *0.315*	4,0 *0.157*	1,0 *0.039*	5,7 *0.224*	6,78 *0.267*	5,0	2	MM0612			■	

Precision inserts for semi-finishing in all materials

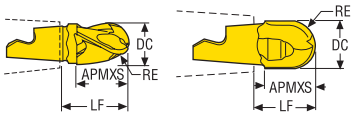




- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LE	LF	DN	SA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM08-10010-B120PF-M02	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	10,97 *0.432*	8,0 *0.315*	254,0	2	MM0612		■		
MM08-10010-B120P-M04	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	10,97 *0.432*	8,0 *0.315*	254,0	2	MM0612			■	

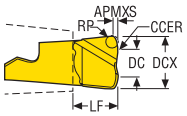
Copy milling

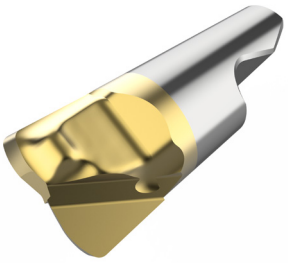


• For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM08-08008-B90-MD03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*	0,0	2	MM0612		■		■	
MM08-08008-B90PF-M01	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*	0,0	2	MM0612			■		
MM08-08008-B90P-M03	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*	0,0	2	MM0612				■	
MM08-08008-B90S-E03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*	0,0	2	MM0612				■	
MM08-08009-B90A30-E03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416	✓			■	
MM08-08009-B90A30-M03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416	✓				■

High feed





• For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM08-08.40-HF-MD06	8,0 *0.315*	4,0 *0.157*	0,37 *0.015*	0,88 *0.035*	4,0 *0.157*	6,84 *0.269*	5,0	9,8	14,6	2	MM0612				■	

Seco

MM08 - Slot and Side milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
P3	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P5	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P7	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P8	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P12	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
M2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
M5	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
K1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
S12	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
S13	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
H5	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H8	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H12	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM08 - Slot and Side milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	370 *1225*	410 *1350*	255 *840*	315 *1025*	350 *1150*	385 *1275*	205 *670*	250 *820*	280 *920*	310 *1025*
P2	255 *840*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	195 *640*	245 *800*	275 *900*	300 *980*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	170 *560*	210 *690*	240 *790*	260 *850*
P4	195 *640*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	290 *950*	150 *490*	185 *610*	210 *690*	230 *750*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	145 *475*	180 *590*	200 *660*	220 *720*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	280 *920*	310 *1025*	160 *520*	200 *660*	225 *740*	250 *820*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	145 *475*	180 *590*	200 *660*	220 *720*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	150 *490*	185 *610*	210 *690*	230 *750*
P12	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	95 *310*	115 *375*	130 *425*	145 *475*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	195 *640*	220 *720*	240 *790*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	130 *425*	160 *520*	180 *590*	200 *660*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	105 *345*	130 *425*	145 *475*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	80 *260*	100 *330*	110 *360*	120 *395*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	85 *280*	90 *295*	100 *330*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	155 *510*	195 *640*	215 *710*	235 *770*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	135 *445*	170 *560*	190 *620*	210 *690*
K3	155 *510*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	115 *375*	145 *475*	160 *520*	180 *590*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	110 *360*	140 *460*	155 *510*	170 *560*
K5	90 *295*	110 *360*	120 *395*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	85 *280*	95 *310*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	150 *490*
K7	115 *375*	140 *460*	155 *510*	170 *560*	110 *360*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1550 *5075*	1950 *6400*	2150 *7050*	2350 *7700*	1475 *4850*	1850 *6075*	2025 *6650*	2250 *7375*	1175 *3850*	1475 *4850*	1625 *5325*	1800 *5900*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	750 *2450*	820 *2700*	910 *2975*	475 *1550*	590 *1925*	660 *2175*	720 *2350*
N3	420 *1375*	520 *1700*	580 *1900*	630 *2075*	400 *1300*	495 *1625*	550 *1800*	610 *2000*	315 *1025*	395 *1300*	440 *1450*	485 *1600*
N11	480 *1575*	600 *1975*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	630 *2075*	690 *2275*	360 *1175*	455 *1500*	500 *1650*	550 *1800*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
S2	39 *130*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	30 *100*	37 *120*	41 *135*	45 *150*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	26 *85*	32 *105*	36 *120*	39 *130*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	75 *245*	80 *260*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	21 *70*	26 *85*	29 *95*	31 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	31 *100*	39 *130*	43 *140*	47 *155*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	60 *195*	70 *230*	80 *260*	90 *295*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*

Seco

MM08 Z3 – Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P3	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P8	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P12	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
M1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
M2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,040 *0.0016*	0,040 *0.0016*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
M5	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
S1	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
S12	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
S13	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM08 Z3 – Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
P3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
P4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,15 *0.0060*
P5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P8	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
P11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P12	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
M2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
K6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
S1	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,038 *0.0015*	0,042 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM08 Z3 – Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	265 *870*	315 *1025*	335 *1100*	360 *1175*	360 *1175*
P2	270 *890*	325 *1075*	345 *1125*	370 *1225*	365 *1200*	260 *850*	310 *1025*	325 *1075*	350 *1150*	350 *1150*
P3	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*	225 *740*	270 *890*	280 *920*	305 *1000*	300 *980*
P4	210 *690*	250 *820*	265 *870*	280 *920*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P6	225 *740*	265 *870*	280 *920*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P7	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*	200 *660*	240 *790*	255 *840*	275 *900*	270 *890*
P8	200 *660*	235 *770*	250 *820*	270 *890*	265 *870*	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*
P11	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	260 *850*	275 *900*	300 *980*	295 *970*	210 *690*	250 *820*	265 *870*	285 *940*	280 *920*
M2	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*	170 *560*	205 *670*	215 *710*	235 *770*	230 *750*
M3	145 *475*	170 *560*	175 *570*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	180 *590*	180 *590*
M4	100 *330*	135 *445*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	80 *260*	110 *360*	105 *375*	115 *375*	115 *375*
K1	215 *710*	255 *840*	270 *890*	295 *970*	290 *950*	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*
K2	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*
K4	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	185 *610*	200 *660*	195 *640*
K5	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	180 *590*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	110 *360*	135 *445*	140 *460*	155 *510*	155 *510*
N1	1625 *5325*	1950 *6400*	2075 *6800*	2225 *7300*	2200 *7225*	1550 *5075*	1850 *6075*	1975 *6475*	2125 *6975*	2100 *6900*
N2	660 *2175*	790 *2600*	830 *2725*	900 *2950*	890 *2925*	630 *2075*	750 *2450*	790 *2600*	850 *2800*	840 *2750*
N3	440 *1450*	520 *1700*	560 *1825*	600 *1975*	590 *1925*	420 *1375*	500 *1650*	530 *1750*	570 *1875*	560 *1825*
N11	500 *1650*	600 *1975*	640 *2100*	680 *2225*	670 *2200*	480 *1575*	570 *1875*	610 *2000*	650 *2125*	640 *2100*
S1	46 *150*	65 *215*	65 *215*	70 *230*	70 *230*	44 *145*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	31 *100*	43 *140*	42 *150*	45 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	35 *125*	38 *125*	38 *125*	25 *80*	34 *110*	34 *120*	36 *120*	37 *120*
H5	43 *140*	50 *165*	55 *180*	60 *195*	55 *180*	41 *135*	49 *160*	50 *165*	55 *180*	55 *180*
H8	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*
H12	75 *245*	95 *310*	100 *330*	105 *345*	105 *345*	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*
H21	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*

MM08 Z2 – Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
P3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,046 *0.0018*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P8	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,046 *0.0018*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
M1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
M2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08008-B90S-E03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
M5	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
K1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 *0.0016*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 *0.0016*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,032 *0.0013*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*
S12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*
S13	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
H5	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
H8	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
H12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM08 Z2 – Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P8	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P12	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
M1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
M2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
M3	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
M4	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
M5	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
K1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
K2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
K6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
N1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
S1	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S2	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S3	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,014 *0.00060*	0,020 *0.00080*	0,030 *0.0012*
S11	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
S12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
S13	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
H5	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H8	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H11	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H21	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM08 Z2 – Copy milling – Cutting data v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	320 1050	405 1325	430 1400	465 1525	465 1525	265 870	330 1075	360 1175	385 1275	385 1275	215 710	265 870	290 950	315 1025	310 1025
P2	315 1025	395 1300	420 1375	450 1475	450 1475	260 850	320 1050	345 1125	375 1225	370 1225	210 690	260 850	280 920	305 1000	300 980
P3	270 890	340 1125	360 1175	390 1275	390 1275	225 740	280 920	300 980	325 1075	325 1075	180 590	225 740	245 800	265 870	260 850
P4	240 790	300 980	320 1050	345 1125	345 1125	200 660	245 800	265 870	285 940	285 940	160 520	200 660	215 710	230 750	230 750
P5	225 740	285 940	305 1000	330 1075	330 1075	190 620	235 770	255 840	275 900	275 900	155 510	190 620	205 670	220 720	220 720
P6	255 840	320 1050	340 1125	370 1225	370 1225	210 690	265 870	285 940	310 1025	305 1000	170 560	215 710	230 750	250 820	250 820
P7	240 790	300 980	320 1050	350 1150	350 1150	200 660	250 820	270 890	295 970	290 950	160 520	200 660	220 720	235 770	235 770
P8	225 740	285 940	305 1000	330 1075	330 1075	190 620	235 770	250 820	275 900	270 890	150 490	190 620	205 670	220 720	220 720
P11	235 770	295 970	315 1025	340 1125	340 1125	195 640	240 790	260 850	285 940	280 920	160 520	195 640	210 690	230 750	230 750
P12	145 475	185 610	185 620	200 660	200 660	125 410	155 510	165 540	175 570	175 570	100 330	125 410	130 445	145 475	140 460
M1	250 820	315 1025	335 1100	365 1200	365 1200	210 690	260 850	280 920	305 1000	300 980	170 560	210 690	225 740	245 800	240 790
M2	205 670	255 840	275 900	295 970	295 970	170 560	210 690	230 750	245 800	245 800	140 460	170 560	185 610	200 660	200 660
M3	165 540	205 670	210 710	225 740	225 740	135 445	175 570	180 590	195 640	195 640	110 360	140 460	145 475	155 510	155 510
M4	125 410	160 520	160 560	170 560	170 560	110 360	140 460	135 475	150 490	150 490	85 280	110 360	110 375	120 395	120 395
M5	105 345	135 445	130 460	140 460	140 460	90 295	115 375	115 395	125 410	125 410	75 245	95 310	90 330	100 330	100 330
K1	250 820	310 1025	330 1075	360 1175	355 1175	205 670	255 840	275 900	300 980	295 970	165 540	205 670	220 720	240 790	240 790
K2	215 710	270 890	290 950	310 1025	310 1025	180 590	225 740	240 790	260 850	260 850	145 475	180 590	195 640	210 690	210 690
K3	180 590	230 750	245 800	265 870	265 870	150 490	190 620	205 670	220 720	220 720	125 410	155 510	165 540	180 590	180 590
K4	175 570	220 720	235 770	250 820	250 820	145 475	180 590	195 640	210 690	210 690	115 375	145 475	160 520	170 560	170 560
K5	105 345	130 425	140 460	150 490	150 490	90 295	110 360	120 395	125 410	125 410	70 230	90 295	95 310	105 345	105 345
K6	155 510	190 620	205 670	220 720	220 720	130 425	160 520	170 560	185 610	185 610	105 345	130 425	140 460	150 490	150 490
K7	135 445	165 540	180 590	195 640	195 640	110 360	140 460	150 490	165 540	165 540	90 295	110 360	120 395	130 425	130 425
N1	1925 6325	2425 7950	2575 8450	2800 9175	2775 9100	1550 5075	1925 6325	2075 6800	2250 7375	2225 7300	1250 4100	1550 5075	1675 5500	1825 6000	1800 5900
N2	780 2550	980 3225	1050 3450	1125 3700	1125 3700	630 2075	780 2550	840 2750	910 2975	900 2950	510 1675	630 2075	680 2225	740 2425	730 2400
N3	520 1700	650 2125	700 2300	750 2450	750 2450	420 1375	520 1700	560 1825	610 2000	600 1975	340 1125	420 1375	455 1500	490 1600	485 1600
N11	590 1925	740 2425	800 2625	860 2825	860 2825	480 1575	590 1925	640 2100	700 2300	690 2275	390 1275	480 1575	520 1700	560 1825	560 1825
S1	60 195	75 245	75 260	80 260	80 260	50 165	65 215	65 230	70 230	70 230	41 135	50 165	50 180	55 180	55 180
S2	47 155	60 195	60 215	65 215	65 215	40 130	50 165	50 180	55 180	55 180	33 110	42 140	42 145	45 150	45 150
S3	40 130	50 165	50 180	55 180	55 180	35 115	45 150	45 155	48 155	48 155	28 90	36 120	36 125	39 130	39 130
S11	85 280	105 345	105 360	115 375	115 375	70 230	90 295	90 310	100 330	100 330	55 180	75 245	75 245	80 260	80 260
S12	60 195	75 245	75 245	80 260	80 260	48 155	60 195	65 215	70 230	70 230	39 130	50 165	50 180	55 180	55 180
S13	33 110	42 140	42 150	45 150	45 150	28 90	36 120	36 125	39 130	39 130	23 75	29 95	29 100	31 100	32 105
H5	48 155	60 195	60 215	65 215	65 215	41 135	50 165	55 180	60 195	60 195	33 110	42 140	44 145	47 155	47 155
H8	49 160	60 195	60 215	65 215	65 215	42 140	55 180	55 180	60 195	60 195	34 110	44 145	45 150	48 155	48 155
H11	60 195	80 260	80 260	85 280	85 280	55 180	65 215	70 230	75 245	75 245	43 140	55 180	55 180	60 195	60 195
H12	85 280	110 360	110 375	120 395	120 395	75 245	100 330	100 345	105 345	105 345	60 195	80 260	80 280	85 280	85 280
H21	49 160	60 195	60 215	65 215	65 215	42 140	55 180	55 180	60 195	60 195	34 110	44 145	45 150	48 155	48 155

Seco

MM08 High-Feed – Insert selection – mm/*Inch*

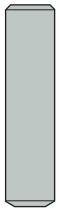
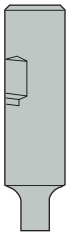
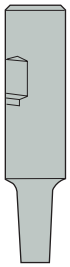
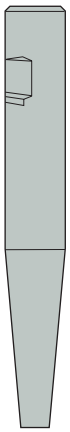
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
P2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
P3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
P4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,48 *0.019*
P5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
P6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P8	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
P11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P12	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
M1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
M2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
M3	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
M4	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
M5	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
K1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
K2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 *0.010*	0,26 *0.010*	0,34 *0.013*	0,42 *0.017*
K6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 *0.010*	0,26 *0.010*	0,34 *0.013*	0,42 *0.017*
N1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
S1	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
S2	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
S3	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*	0,30 *0.012*
S11	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
S12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
S13	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
H5	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
H8	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*
H11	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
H12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*
H21	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

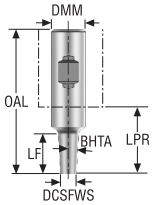
MM08 High-Feed – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M			
	100%	70%	30%	20%
P1	250 *820*	305 *1000*	350 *1150*	375 *1225*
P2	245 *800*	300 *980*	345 *1125*	365 *1200*
P3	215 *710*	260 *850*	300 *980*	315 *1025*
P4	190 *620*	230 *750*	265 *870*	275 *900*
P5	180 *590*	220 *720*	255 *840*	265 *870*
P6	205 *670*	250 *820*	285 *940*	300 *980*
P7	190 *620*	235 *770*	270 *890*	285 *940*
P8	180 *590*	220 *720*	250 *820*	265 *870*
P11	185 *610*	230 *750*	260 *850*	275 *900*
P12	120 *395*	145 *475*	165 *540*	175 *570*
M1	195 *640*	240 *790*	275 *900*	295 *970*
M2	165 *540*	195 *640*	230 *750*	240 *790*
M3	130 *425*	155 *510*	180 *590*	190 *620*
M4	100 *330*	120 *395*	140 *460*	145 *475*
M5	85 *280*	100 *330*	115 *375*	120 *395*
K1	195 *640*	235 *770*	270 *890*	290 *950*
K2	170 *560*	210 *690*	240 *790*	255 *840*
K3	145 *475*	175 *570*	205 *670*	215 *710*
K4	140 *460*	170 *560*	195 *640*	205 *670*
K5	85 *280*	105 *345*	120 *395*	125 *410*
K6	125 *410*	150 *490*	170 *560*	180 *590*
K7	110 *360*	130 *425*	150 *490*	160 *520*
N1	1475 *4850*	1800 *5900*	2050 *6725*	2125 *6975*
N2	590 *1925*	720 *2350*	820 *2700*	860 *2825*
N3	395 *1300*	480 *1575*	550 *1800*	570 *1875*
N11	450 *1475*	550 *1800*	630 *2075*	650 *2125*
S1	48 *155*	55 *180*	65 *215*	70 *230*
S2	39 *130*	46 *150*	50 *165*	55 *180*
S3	33 *110*	40 *130*	46 *150*	48 *155*
S11	65 *215*	80 *260*	90 *295*	95 *310*
S12	46 *150*	55 *180*	65 *215*	65 *215*
S13	27 *90*	32 *105*	36 *120*	38 *125*
H5	40 *130*	47 *155*	55 *180*	60 *195*
H8	41 *135*	50 *165*	55 *180*	60 *195*
H11	50 *165*	60 *195*	70 *230*	75 *245*
H12	75 *245*	90 *295*	100 *330*	105 *345*
H21	41 *135*	50 *165*	55 *180*	60 *195*

Shank design

Design 1, Keyway shank	Design 2, Cylindrical/Weldon back end and 90º front
	
Design 3, Cylindrical/Weldon back end tapered front 87º/89º	**Design 4, Cylindrical/Weldon back end tapered front 80º/85º/87º**
	
Design 5, Cylindrical back end double tapered front end 89º/85º	

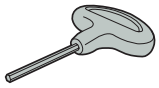
MM10 Shank – Metric



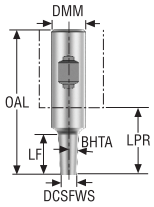
Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM10-20075.3-0010	75012787	Weldon	9,5	20,0	75,0	10,0	25,0	0,0	2	✓	80000	0,2	4
MM10-20085.3-3023	75012788	Weldon	9,5	20,0	85,0	23,0	35,0	3,0	3	✓	80000	0,2	4
MM10-20140.3-5060	75012789	Weldon	9,5	20,0	140,0	60,0	90,0	5,0	4	✓	80000	0,3	5
MM10-10045.0-0007	00083979	Cylindrical	9,6	10,0	45,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM10-16065.0-0000	75004925	Cylindrical	9,5	16,0	65,0	0,0	17,0	60,0	1	✓	80000	0,1	1
MM10-16160.0-1035M	00094757	Cylindrical	9,5	16,0	160,0	35,0	112,0	1,0	3	✓	80000	0,2	6
MM10-16160.0-1055M	00094758	Cylindrical	9,5	16,0	160,0	55,0	112,0	1,0	3	✓	80000	0,2	7
MM10-16160.0-1075M	00094760	Cylindrical	9,5	16,0	160,0	75,0	112,0	1,0	3	✓	80000	0,2	7
MM10-32250.0-10063	75069366	Cylindrical	9,5	32,0	250,0	63,8	190,0	10,0	4	✓	80000	1,3	5
MM10-12060.0-0007DS	02580667	Cylindrical	9,6	12,0	60,0	7,0	15,0	0,0	2	✓	76300	0,1	3
MM10-12085.0-3024DS	02580704	Cylindrical	9,5	12,0	85,0	23,8	40,0	3,0	4	✓	76300	0,2	3
MM10-12100.0-1035DS	02580733	Cylindrical	9,5	12,0	100,0	35,0	55,0	1,0	3	✓	76300	0,2	3
MM10-14120.0-1050DS	02580736	Cylindrical	9,5	14,0	120,0	50,0	75,0	1,0	3	✓	76300	0,3	3
MM10-16085.0-0020DS	02580688	Cylindrical	9,5	16,0	85,0	20,0	37,0	0,0	2	✓	76300	0,3	3
MM10-16105.0-0040DS	02580689	Cylindrical	9,5	16,0	105,0	40,0	57,0	0,0	2	✓	76300	0,3	3
MM10-16160.0-1055DS	02580748	Cylindrical	9,5	16,0	160,0	55,0	112,0	1,0	3	✓	76300	0,4	3
MM10-16160.0-1075DS	02580749	Cylindrical	9,5	16,0	160,0	75,0	112,0	1,0	3	✓	76300	0,4	3
MM10-20250.0-1055DS	02580750	Cylindrical	9,5	20,0	250,0	55,0	200,0	1,0	5	✓	76300	1,0	3

Spare Parts, included in delivery

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
4	MM-06048	MM10-0627	–
5	MM-06116	MM10-0627	–
2	MM-06020	MM10-0627	H05-4
1	MM-06032	MM10-0627	–
6	MM-06048	MM10-0651	–
7	MM-06032	MM10-0688	–
3	–	MM10-061027	–

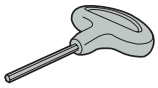
MM10 Shank – *Inch*



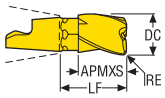
Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			inch	inch	inch	inch	inch					lbs	
MM10-0.75-3.0-3-0004	75015052	Weldon	0.360	0.750	2.953	0.394	0.984	0,0	2	✓	80000	0.440	3
MM10-0.75-3.3-3-3009	75015053	Weldon	0.374	0.750	3.346	0.906	1.378	3,0	3	✓	80000	0.440	3
MM10-0.75-5.5-3-5021	75015054	Weldon	0.374	0.750	5.512	2.150	3.543	5,0	4	✓	80000	0.660	5
MM10-0.38-1.8-0-0002	00096126	Cylindrical	0.360	0.375	1.772	0.276	0.276	0,0	2	✓	80000	0.220	2
MM10-0.62-2.6-0-0000	75005069	Cylindrical	0.374	0.625	2.559	0	0.669	60,0	1	✓	80000	0.220	1
MM10-0.62-6.3-0-1021	75054608	Cylindrical	0.360	0.625	6.299	2.165	4.409	1,0	3	✓	80000	0.440	7
MM10-1.25-10.0-0-10024	00096132	Cylindrical	0.374	1.250	9.843	2.484	7.480	10,0	4	✓	80000	2.870	5
MM10-0.75-10.0-0-1021DS	02593420	Cylindrical	0.360	0.750	9.843	2.165	7.874	1,0	5	✓	76300	1.980	4
MM10-0.75-4.1-0-0015DS	02593422	Cylindrical	0.360	0.750	4.134	1.575	2.165	0,0	2	✓	76300	0.660	4

Spare Parts, included in delivery

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
3	MM-06048	MM10-0627	–
5	MM-06116	MM10-0627	–
2	MM-06020	MM10-0627	H05-4
1	MM-06032	MM10-0627	–
7	MM-06032	MM10-0688	–
4	–	MM10-061027	–

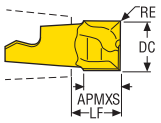
Slot milling/square shoulder milling



• For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM10-09512-A30-E03	9,525 *0.375*	11,8 *0.465*	0,0 *–*	15,72 *0.619*	15,0	11,6	18,8	30	3	MM0416	✓			■	
MM10-09512-R03A30-M03	9,525 *0.375*	11,8 *0.465*	0,3 *0.012*	15,72 *0.619*	15,0	11,6	18,2	30	3	MM0416	✓				■
MM10-09512-R04A30-M03	9,525 *0.375*	11,8 *0.465*	0,4 *0.016*	15,72 *0.619*	15,0	11,6	18,0	30	3	MM0416	✓				■
MM10-09512-R08A30-M03	9,525 *0.375*	11,8 *0.465*	0,8 *0.031*	15,72 *0.619*	15,0	11,6	17,2	30	3	MM0416	✓				■
MM10-09512-R16A30-M03	9,525 *0.375*	11,8 *0.465*	1,6 *0.063*	15,72 *0.619*	15,0	11,6	15,6	30	3	MM0416	✓				■
MM10-10012-A30-E03	10,0 *0.394*	11,8 *0.465*	0,0 *–*	15,72 *0.619*	15,0	12,2	19,8	30	3	MM0416	✓			■	
MM10-10012-R05A30-M03	10,0 *0.394*	11,8 *0.465*	0,5 *0.020*	15,72 *0.619*	15,0	12,2	18,8	30	3	MM0416	✓				■
MM10-10012-R10A30-D03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-E03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-M03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓				■
MM10-10012-R20A30-M03	10,0 *0.394*	11,8 *0.465*	2,0 *0.079*	15,72 *0.619*	15,0	12,2	15,8	30	3	MM0416	✓				■
MM10-10012-R30A30-M03	10,0 *0.394*	11,8 *0.465*	3,0 *0.118*	15,72 *0.619*	15,0	12,2	13,8	30	3	MM0416	✓				■

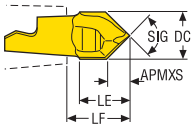
Slot milling/square shoulder milling



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM10-09510-M03	9,525 *0.375*	6,8 *0.268*	0,0 –	8,5 *0.335*	15,0	11,6	18,8	0	2	MM0612	■			
MM10-09510-R04-MD04	9,525 *0.375*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	11,6	18,0	0	2	MM0612	■			
MM10-09510-R08A8-E03	9,525 *0.375*	6,6 *0.260*	0,8 *0.031*	8,37 *0.330*	15,0	11,6	17,2	8	2	MM0612			■	
MM10-09807T-R03-D04	9,8 *0.386*	6,8 *0.268*	0,3 *0.012*	8,49 *0.334*	15,0	11,9	18,8	0	2	MM0612	■			
MM10-10007-M03	10,0 *0.394*	6,9 *0.272*	0,0 –	8,5 *0.335*	15,0	12,2	19,8	0	2	MM0612	■			
MM10-10007-R04A8-E03	10,0 *0.394*	6,6 *0.260*	0,4 *0.016*	8,44 *0.332*	15,0	12,2	19,0	8	2	MM0612	■		■	
MM10-10007-R04-MD04	10,0 *0.394*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	12,2	19,0	0	2	MM0612	■		■	
MM10-10007-R04P-M03	10,0 *0.394*	6,7 *0.264*	0,4 *0.016*	8,38 *0.330*	15,0	12,2	19,0	0	2	MM0612			■	
MM10-10007-R10-MD04	10,0 *0.394*	6,8 *0.268*	1,0 *0.039*	8,48 *0.334*	15,0	12,2	17,8	0	2	MM0612	■		■	
MM10-10007-R20-MD04	10,0 *0.394*	6,8 *0.268*	2,0 *0.079*	8,46 *0.333*	15,0	12,2	15,8	0	2	MM0612			■	
MM10-10007-R30-MD04	10,0 *0.394*	6,8 *0.268*	3,0 *0.118*	8,44 *0.332*	15,0	12,2	13,8	0	2	MM0612			■	

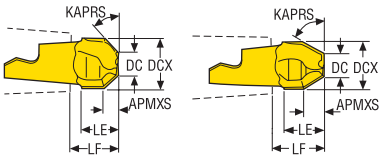
Centre drilling



• For Torque keys and torque values, see page 673

Designation	DC	APMXS	LE	LF	SIG°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM10-10005-C90-M03	10,0 *0.394*	4,69 *0.185*	10,0 *0.394*	11,8 *0.465*	90,0	2	MM0612	■			
MM10-10007-C120-M03	10,0 *0.394*	2,7 *0.106*	10,4 *0.409*	11,8 *0.465*	120,0	2	MM0612	■			

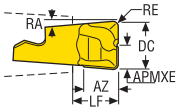
Chamfering



• For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM10-10007-4525-E03	10,0 *0.394*	4,82 *0.190*	2,6 *0.102*	6,94 *0.273*	8,48 *0.334*	45,0	2	MM0612	■			
MM10-10008-6040-E03	10,0 *0.394*	5,24 *0.206*	4,0 *0.157*	8,05 *0.317*	9,6 *0.378*	60,0	2	MM0612	■			

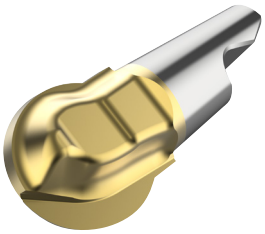
Plunge milling

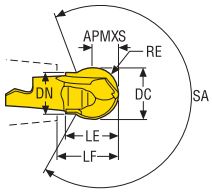


- For Torque keys and torque values, see page 673

Designation	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM10-10007-R10-PL-MD04	10,0 *0.394*	5,0 *0.197*	1,0 *0.039*	7,1 *0.280*	8,48 *0.334*	5,0	2	MM0612			■	

Precision inserts for semi-finishing in all materials

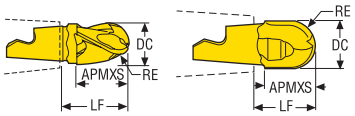




- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LE	LF	DN	SA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM10-12012-B120P-M05	12,0 *0.472*	6,0 *0.236*	6,0 *0.236*	12,0 *0.472*	13,2 *0.520*	10,0 *0.394*	247,0	2	MM0612			■	
MM10-12712-B120PF-M03	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	13,56 *0.534*	10,0 *0.394*	256,0	2	MM0612		■		
MM10-12712-B120P-M05	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	13,56 *0.534*	10,0 *0.394*	256,0	2	MM0612			■	

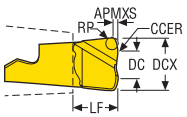
Copy milling

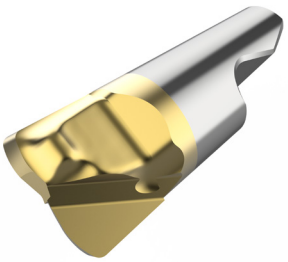


• For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm Inch	mm Inch	mm Inch	mm Inch					T60M	F15M	F30M	F40M
MM10-09510-B90P-M04	9,525 0.375	8,7 0.343	4,763 0.188	11,74 0.462	0,0	2	MM0612		■		■	
MM10-10010-B90-MD04	10,0 0.394	10,2 0.402	5,0 0.197	11,77 0.463	0,0	2	MM0612		■		■	
MM10-10010-B90PF-M02	10,0 0.394	8,73 0.344	5,0 0.197	11,74 0.462	0,0	2	MM0612			■		
MM10-10010-B90P-M04	10,0 0.394	8,73 0.344	5,0 0.197	11,74 0.462	0,0	2	MM0612				■	
MM10-10010-B90S-E04	10,0 0.394	10,2 0.402	5,0 0.197	11,77 0.463	0,0	2	MM0612				■	
MM10-10012-B90A30-D03	10,0 0.394	11,8 0.465	5,0 0.197	15,72 0.619	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-E03	10,0 0.394	11,8 0.465	5,0 0.197	15,72 0.619	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-M03	10,0 0.394	11,8 0.465	5,0 0.197	15,72 0.619	30,0	3	MM0416	✓				■

High feed





• For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Wrench		Grades Coated			
	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch	mm Inch							T60M	F15M	F30M	F40M
MM10-10.50-HF-MD08	10,0 0.394	5,0 0.197	0,44 0.017	1,13 0.044	5,0 0.197	8,5 0.335	5,0	12,2	18,2	2	MM0612			■	■	

Seco

MM10 - Slot and Side milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P3	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P5	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*
P6	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P7	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P8	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P12	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
M2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*
M3	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,032 *0.0013*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
M4	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
M5	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
K1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 *0.0016*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*
K6	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 *0.0016*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*
N1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
S2	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
S3	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
S12	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
S13	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
H5	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
H8	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H11	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
H12	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H21	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM10 - Slot and Side milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	365 *1200*	405 *1325*	250 *820*	315 *1025*	345 *1125*	385 *1275*	190 *620*	240 *790*	270 *890*	295 *970*
P2	260 *850*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	185 *610*	235 *770*	260 *850*	290 *950*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	165 *540*	205 *670*	230 *750*	250 *820*
P4	200 *660*	245 *800*	275 *900*	305 *1000*	190 *620*	235 *770*	260 *850*	290 *950*	145 *475*	180 *590*	200 *660*	225 *740*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	140 *460*	175 *570*	195 *640*	215 *710*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	220 *720*	240 *790*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	145 *475*	185 *610*	205 *670*	225 *740*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	140 *460*	175 *570*	190 *620*	210 *690*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
P12	125 *410*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	150 *490*	190 *620*	210 *690*	235 *770*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	125 *410*	155 *510*	175 *570*	190 *620*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	100 *330*	125 *410*	140 *460*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	75 *245*	95 *310*	105 *345*	115 *375*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	80 *260*	90 *295*	95 *310*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	150 *490*	185 *610*	205 *670*	230 *750*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	235 *770*	260 *850*	130 *425*	165 *540*	185 *610*	200 *660*
K3	150 *490*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	110 *360*	140 *460*	155 *510*	170 *560*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	150 *490*	165 *540*
K5	90 *295*	110 *360*	125 *410*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	80 *260*	90 *295*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	115 *375*	130 *425*	145 *475*
K7	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	115 *375*	125 *410*
N1	1550 *5075*	1925 *6325*	2150 *7050*	2350 *7700*	1475 *4850*	1825 *6000*	2025 *6650*	2250 *7375*	1125 *3700*	1400 *4600*	1550 *5075*	1725 *5650*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	740 *2425*	820 *2700*	910 *2975*	450 *1475*	570 *1875*	630 *2075*	690 *2275*
N3	415 *1350*	520 *1700*	580 *1900*	630 *2075*	395 *1300*	495 *1625*	550 *1800*	610 *2000*	300 *980*	380 *1250*	420 *1375*	460 *1500*
N11	475 *1550*	590 *1925*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	620 *2025*	690 *2275*	345 *1125*	430 *1400*	480 *1575*	530 *1750*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S2	38 *125*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	25 *80*	32 *105*	35 *115*	38 *125*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	70 *230*	75 *245*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	35 *115*	43 *140*	49 *160*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	20 *65*	25 *80*	28 *90*	30 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	38 *125*	42 *140*	46 *150*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	31 *100*	39 *130*	44 *145*	48 *155*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	38 *125*	48 *155*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	55 *180*	70 *230*	80 *260*	85 *280*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	31 *100*	39 *130*	44 *145*	48 *155*

Seco

MM10 Z3 – Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
P3	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P4	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P5	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P6	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P7	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P8	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P11	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P12	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
M1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
M2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
M3	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
M4	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
M5	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K5	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
K6	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K7	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
S1	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 *0.0017*	0,042 *0.0017*	0,042 *0.0017*	0,055 *0.0022*
S12	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 *0.0017*	0,042 *0.0017*	0,042 *0.0017*	0,055 *0.0022*
S13	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
H5	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H8	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H12	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM10 Z3 – Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
P3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,15 *0.0060*
P5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P8	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P12	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
M1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
M2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
K6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
S1	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,038 *0.0015*	0,042 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H8	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H11	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H21	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM10 Z3 – Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	270 *890*	310 *1025*	335 *1100*	365 *1200*	360 *1175*
P2	275 *900*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	260 *850*	305 *1000*	325 *1075*	355 *1175*	355 *1175*
P3	240 *790*	280 *920*	295 *970*	320 *1050*	320 *1050*	230 *750*	265 *870*	280 *920*	305 *1000*	305 *1000*
P4	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	260 *850*
P6	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	250 *820*	270 *890*	290 *950*	290 *950*
P7	215 *710*	250 *820*	265 *870*	290 *950*	285 *940*	205 *670*	235 *770*	255 *840*	275 *900*	275 *900*
P8	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	260 *850*
P11	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	160 *520*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	255 *840*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	260 *850*	285 *940*	285 *940*
M2	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*	175 *570*	200 *660*	215 *710*	235 *770*	230 *750*
M3	145 *475*	175 *570*	175 *590*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	185 *610*	180 *590*
M4	95 *310*	140 *460*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	75 *245*	110 *360*	105 *375*	115 *375*	115 *375*
K1	220 *720*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	255 *840*	280 *920*	280 *920*
K2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	230 *750*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*
K4	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*	145 *475*	170 *560*	185 *610*	200 *660*	195 *640*
K5	95 *310*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	115 *375*	130 *425*	140 *460*	155 *510*	155 *510*
N1	1650 *5425*	1925 *6325*	2050 *6725*	2225 *7300*	2200 *7225*	1575 *5175*	1825 *6000*	1950 *6400*	2125 *6975*	2100 *6900*
N2	670 *2200*	780 *2550*	830 *2725*	900 *2950*	890 *2925*	640 *2100*	740 *2425*	790 *2600*	860 *2825*	850 *2800*
N3	445 *1450*	520 *1700*	550 *1800*	600 *1975*	590 *1925*	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*
N11	510 *1675*	590 *1925*	630 *2075*	690 *2275*	680 *2225*	485 *1600*	560 *1825*	600 *1975*	650 *2125*	650 *2125*
S1	45 *150*	65 *215*	65 *215*	70 *230*	70 *230*	43 *140*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	30 *100*	43 *140*	42 *150*	46 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	45 *150*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	36 *125*	38 *125*	38 *125*	24 *80*	34 *110*	34 *120*	37 *120*	37 *120*
H5	43 *140*	55 *180*	55 *180*	60 *195*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*
H8	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
H12	75 *245*	100 *330*	100 *330*	105 *345*	105 *345*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*
H21	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*

MM10 Z2 – Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
P3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P4	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P8	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P11	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P12	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
M1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
M2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M3	MM10-10010-B90S-E04 F30M	3,5 *0.14*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
M4	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
M5	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
K1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
K2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K4	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
K6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
N1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N11	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
S1	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
S2	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
S3	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*	0,055 *0.0024*
S11	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
S12	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
S13	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
H5	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
H8	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H11	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
H12	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H21	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM10 Z2 – Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
P3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P8	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P12	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
M2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M3	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
M4	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
M5	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
K1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
K2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
K6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
N1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S2	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S3	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
S12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
S13	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
H5	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM10 Z2 – Copy milling – Cutting data v_c = (m/min)/(*sf/min*)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	305 *1000*	390 *1275*	405 *1325*	440 *1450*	440 *1450*	250 *820*	320 *1050*	340 *1125*	370 *1225*	365 *1200*	205 *670*	260 *850*	275 *900*	300 *980*	295 *970*
P2	295 *970*	380 *1250*	395 *1300*	425 *1400*	425 *1400*	240 *790*	305 *1000*	330 *1075*	355 *1175*	355 *1175*	195 *640*	250 *820*	270 *890*	285 *940*	285 *940*
P3	260 *850*	330 *1075*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*
P4	225 *740*	290 *950*	300 *980*	325 *1075*	325 *1075*	185 *610*	235 *770*	255 *840*	270 *890*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P5	215 *710*	275 *900*	290 *950*	315 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	265 *870*	260 *850*	145 *475*	185 *610*	195 *640*	215 *710*	210 *690*
P6	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	235 *770*
P7	230 *750*	295 *970*	305 *1000*	330 *1075*	330 *1075*	190 *620*	240 *790*	260 *850*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P11	225 *740*	285 *940*	295 *970*	325 *1075*	320 *1050*	185 *610*	235 *770*	250 *820*	270 *890*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	215 *710*
P12	140 *460*	175 *570*	180 *610*	195 *640*	195 *640*	120 *395*	150 *490*	155 *510*	170 *560*	170 *560*	95 *310*	120 *395*	125 *410*	135 *445*	135 *445*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	195 *640*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
M2	195 *640*	250 *820*	260 *850*	280 *920*	280 *920*	160 *520*	205 *670*	215 *710*	235 *770*	235 *770*	130 *425*	165 *540*	175 *570*	190 *620*	190 *620*
M3	155 *510*	200 *660*	200 *670*	220 *720*	220 *720*	130 *425*	165 *540*	175 *570*	185 *610*	185 *610*	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*
M4	120 *395*	155 *510*	155 *560*	165 *540*	165 *540*	105 *345*	135 *445*	130 *460*	145 *475*	140 *460*	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	335 *1100*	335 *1100*	190 *620*	245 *800*	260 *850*	280 *920*	280 *920*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
K2	205 *670*	265 *870*	275 *900*	295 *970*	295 *970*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*
K3	175 *570*	225 *740*	230 *750*	250 *820*	250 *820*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	150 *490*	155 *510*	170 *560*	170 *560*
K4	165 *540*	215 *710*	220 *720*	240 *790*	240 *790*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	160 *520*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	85 *280*	105 *345*	110 *360*	120 *395*	120 *395*	70 *230*	85 *280*	90 *295*	100 *330*	100 *330*
K6	145 *475*	185 *610*	195 *640*	210 *690*	210 *690*	120 *395*	155 *510*	165 *540*	180 *590*	175 *570*	95 *310*	125 *410*	130 *425*	145 *475*	145 *475*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	105 *345*	135 *445*	145 *475*	155 *510*	155 *510*	85 *280*	110 *360*	115 *375*	125 *410*	125 *410*
N1	1800 *5900*	2300 *7550*	2425 *7950*	2600 *8525*	2600 *8525*	1450 *4750*	1825 *6000*	1975 *6475*	2150 *7050*	2100 *6900*	1175 *3850*	1475 *4850*	1600 *5250*	1725 *5650*	1700 *5575*
N2	730 *2400*	930 *3050*	970 *3175*	1050 *3450*	1050 *3450*	590 *1925*	740 *2425*	800 *2625*	870 *2850*	850 *2800*	475 *1550*	600 *1975*	650 *2125*	700 *2300*	680 *2225*
N3	485 *1600*	620 *2025*	650 *2125*	700 *2300*	700 *2300*	390 *1275*	495 *1625*	530 *1750*	580 *1900*	560 *1825*	315 *1025*	400 *1300*	435 *1425*	465 *1525*	455 *1500*
N11	550 *1800*	710 *2325*	740 *2425*	800 *2625*	800 *2625*	450 *1475*	570 *1875*	610 *2000*	660 *2175*	640 *2100*	360 *1175*	460 *1500*	495 *1625*	530 *1750*	520 *1700*
S1	55 *180*	70 *230*	70 *260*	80 *260*	75 *245*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S2	46 *150*	60 *195*	60 *215*	65 *215*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	32 *105*	40 *130*	40 *140*	43 *140*	43 *140*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	34 *110*	43 *140*	43 *150*	47 *155*	46 *150*	27 *90*	35 *115*	35 *120*	38 *125*	38 *125*
S11	80 *260*	100 *330*	100 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *295*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	49 *165*	55 *180*	55 *180*
S13	32 *105*	41 *135*	40 *145*	44 *145*	43 *140*	27 *90*	35 *115*	35 *120*	37 *120*	37 *120*	22 *70*	28 *90*	28 *100*	30 *100*	30 *100*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	32 *105*	41 *135*	42 *140*	45 *150*	45 *150*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	40 *130*	50 *165*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	60 *195*	75 *245*	80 *260*	85 *280*	85 *280*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*

Seco

MM10 High-Feed – Insert selection – mm/*Inch*

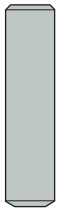
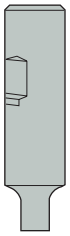
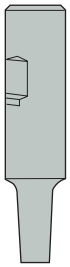
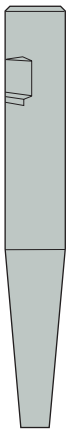
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,48 *0.019*	0,48 *0.019*	0,65 *0.026*	0,80 *0.032*
P2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P8	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P12	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
M1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
M2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
M3	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
M4	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
M5	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
K1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
K6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
N1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
S1	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
S2	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
S3	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
S11	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S12	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S13	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
H5	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
H8	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
H11	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
H12	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
H21	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

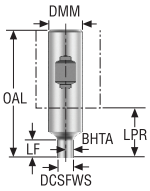
MM10 High-Feed – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	230	280	325	340
	—	—	—	—	*750*	*920*	*1075*	*1125*
P2	—	—	—	—	225	270	315	330
	—	—	—	—	*740*	*890*	*1025*	*1075*
P3	—	—	—	—	195	240	275	290
	—	—	—	—	*640*	*790*	*900*	*950*
P4	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P5	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P6	—	—	—	—	185	225	260	270
	—	—	—	—	*610*	*740*	*850*	*890*
P7	—	—	—	—	175	215	245	255
	—	—	—	—	*570*	*710*	*800*	*840*
P8	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P11	—	—	—	—	170	210	240	250
	—	—	—	—	*560*	*690*	*790*	*820*
P12	—	—	—	—	110	135	150	160
	—	—	—	—	*360*	*445*	*490*	*520*
M1	—	—	—	—	180	220	255	265
	—	—	—	—	*590*	*720*	*840*	*870*
M2	—	—	—	—	150	180	210	220
	—	—	—	—	*490*	*590*	*690*	*720*
M3	—	—	—	—	120	145	165	175
	—	—	—	—	*395*	*475*	*540*	*570*
M4	—	—	—	—	95	110	130	135
	—	—	—	—	*310*	*360*	*425*	*445*
M5	—	—	—	—	80	95	110	115
	—	—	—	—	*260*	*310*	*360*	*375*
K1	190	230	270	280	175	215	250	260
	620	*750*	*890*	*920*	*570*	*710*	*820*	*850*
K2	170	205	235	245	160	190	220	230
	560	*670*	*770*	*800*	*520*	*620*	*720*	*750*
K3	145	175	200	210	135	160	185	195
	475	*570*	*660*	*690*	*445*	*520*	*610*	*640*
K4	135	165	190	200	125	155	175	185
	445	*540*	*620*	*660*	*410*	*510*	*570*	*610*
K5	85	100	115	125	75	95	105	115
	280	*330*	*375*	*410*	*245*	*310*	*345*	*375*
K6	120	145	170	175	110	135	155	165
	395	*475*	*560*	*570*	*360*	*445*	*510*	*540*
K7	105	130	150	155	100	120	140	145
	345	*425*	*490*	*510*	*330*	*395*	*460*	*475*
N1	—	—	—	—	1325	1600	1850	1925
	—	—	—	—	*4350*	*5250*	*6075*	*6325*
N2	—	—	—	—	530	650	750	780
	—	—	—	—	*1750*	*2125*	*2450*	*2550*
N3	—	—	—	—	355	430	500	520
	—	—	—	—	*1175*	*1400*	*1650*	*1700*
N11	—	—	—	—	405	495	570	590
	—	—	—	—	*1325*	*1625*	*1875*	*1925*
S1	—	—	—	—	45	50	60	65
	—	—	—	—	*150*	*165*	*195*	*215*
S2	—	—	—	—	36	42	49	50
	—	—	—	—	*120*	*140*	*160*	*165*
S3	—	—	—	—	31	37	42	45
	—	—	—	—	*100*	*120*	*140*	*150*
S11	—	—	—	—	60	75	85	90
	—	—	—	—	*195*	*245*	*280*	*295*
S12	—	—	—	—	43	50	60	60
	—	—	—	—	*140*	*165*	*195*	*195*
S13	—	—	—	—	25	29	34	36
	—	—	—	—	*80*	*95*	*110*	*120*
H5	40	48	55	60	37	44	50	55
	130	*155*	*180*	*195*	*120*	*145*	*165*	*180*
H8	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*
H11	50	60	70	75	47	55	65	70
	165	*195*	*230*	*245*	*155*	*180*	*215*	*230*
H12	75	90	105	110	70	85	95	100
	245	*295*	*345*	*360*	*230*	*280*	*310*	*330*
H21	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*

Shank design

Design 1, Keyway shank	Design 2, Cylindrical/Weldon back end and 90º front
	
Design 3, Cylindrical/Weldon back end tapered front 87º/89º	**Design 4, Cylindrical/Weldon back end tapered front 80º/85º/87º**
	
Design 5, Cylindrical back end double tapered front end 89º/85º	

MM12 Shank – Metric



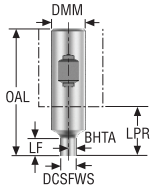
Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM12-20080.3-0012	75012864	Weldon	11,4	20,0	80,0	12,0	30,0	0,0	2	✓	80000	0,2	4
MM12-20095.3-3027	75012865	Weldon	11,4	20,0	95,0	27,0	45,0	3,0	3	✓	80000	0,2	4
MM12-20150.3-5049	75012866	Weldon	11,4	20,0	150,0	49,1	100,0	5,0	4	✓	80000	0,3	5
MM12-12055.0-0008	00083978	Cylindrical	11,5	12,0	55,0	8,5	10,0	0,0	2	✓	80000	0,1	2
MM12-16065.0-0000	75004926	Cylindrical	11,4	16,0	65,0	0,0	17,0	60,0	1	✓	80000	0,1	1
MM12-16170.0-1040	75034505	Cylindrical	11,4	16,0	170,0	40,0	122,0	1,0	3	✓	80000	0,2	5
MM12-16170.0-1060	75034506	Cylindrical	11,4	16,0	170,0	60,0	122,0	1,0	3	✓	80000	0,2	5
MM12-16170.0-1080	75034507	Cylindrical	11,4	16,0	170,0	80,0	122,0	1,0	3	✓	80000	0,2	5
MM12-12070.0-0008DS	02580668	Cylindrical	11,5	12,0	70,0	8,5	25,0	0,0	2	✓	63600	0,1	3
MM12-16095.0-0024DS	02580690	Cylindrical	11,4	16,0	95,0	24,0	47,0	0,0	2	✓	63600	0,3	3
MM12-16090.0-3044DS	02580705	Cylindrical	11,4	16,0	90,0	43,9	42,0	3,0	4	✓	63600	0,3	3
MM12-16120.0-1045DS	02580752	Cylindrical	11,4	16,0	120,0	45,0	72,0	1,0	3	✓	63600	0,3	3
MM12-16115.0-0048DS	02580691	Cylindrical	11,4	16,0	115,0	48,0	67,0	0,0	2	✓	63600	0,3	3
MM12-16170.0-1060DS	02580753	Cylindrical	11,4	16,0	170,0	60,0	122,0	1,0	3	✓	63600	0,5	3
MM12-16170.0-1080DS	02580755	Cylindrical	11,4	16,0	170,0	80,0	122,0	1,0	3	✓	63600	0,5	3
MM12-20250.0-1060DS	02580756	Cylindrical	11,4	20,0	250,0	60,0	200,0	1,0	5	✓	63600	1,0	3

Spare Parts, included in delivery

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
4	MM-06048	MM12-0637	–
5	MM-06116	MM12-0637	–
2	MM-06020	MM12-0637	H05-4
1	MM-06032	MM12-0637	–
3	–	MM12-061037	–

MM12 Shank – *Inch*

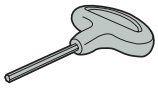


- For ISO attribute explanation, see page 25

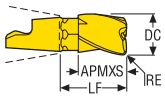
Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			inch	inch	inch	inch	inch					lbs	
MM12-0.75-3.1-3-0004	75015055	Weldon	0.449	0.750	3.150	0.472	1.181	0,0	2	✓	80000	0.440	3
MM12-0.75-3.7-3-3010	75015056	Weldon	0.449	0.750	3.740	1.063	1.772	3,0	3	✓	80000	0.440	3
MM12-0.75-5.9-3-5017	75015057	Weldon	0.449	0.750	5.906	1.720	3.937	5,0	4	✓	80000	0.660	5
MM12-0.50-2.2-0-0003	00096133	Cylindrical	0.453	0.500	2.165	0.335	0.394	0,0	2	✓	80000	0.220	2
MM12-0.62-2.6-0-0000	75005070	Cylindrical	0.449	0.625	2.559	0	0.669	60,0	1	✓	80000	0.220	1
MM12-0.62-6.7-0-1015	75054728	Cylindrical	0.449	0.625	6.693	1.575	4.803	1,0	3	✓	80000	0.440	5
MM12-0.62-6.7-0-1023	75054729	Cylindrical	0.449	0.625	6.693	2.362	4.803	1,0	3	✓	80000	0.440	5
MM12-0.62-6.7-0-1023DS	02593423	Cylindrical	0.449	0.625	6.693	2.362	4.803	1,0	3	✓	63600	1.100	4
MM12-0.62-6.7-0-1031DS	02593426	Cylindrical	0.449	0.625	6.693	3.150	4.803	1,0	3	✓	63600	0.880	4
MM12-0.75-10.0-0-1023DS	02593427	Cylindrical	0.449	0.750	9.843	2.362	7.874	1,0	5	✓	63600	1.980	4
MM12-0.75-3.8-0-0009DS	02593428	Cylindrical	0.449	0.750	3.740	0.945	1.772	0,0	2	✓	63600	0.880	4
MM12-0.75-4.5-0-0018DS	02593430	Cylindrical	0.449	0.750	4.528	1.890	2.559	0,0	2	✓	63600	0.880	4

Spare Parts, included in delivery

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
3	MM-06048	MM12-0637	–
5	MM-06116	MM12-0637	–
2	MM-06020	MM12-0637	H05-4
1	MM-06032	MM12-0637	–
4	–	MM12-061037	–

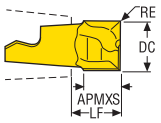
Slot milling/square shoulder milling



• For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM12-11715-R03A30-M04	11,7 *0.461*	15,35 *0.604*	0,3 *0.012*	19,9 *0.783*	15,0	14,2	22,6	30	3	MM0416	✓				■
MM12-12015-A30-E04	12,0 *0.472*	15,35 *0.604*	0,0 *–*	19,9 *0.783*	15,0	14,6	23,8	30	3	MM0416	✓			■	
MM12-12015-R05A30-M04	12,0 *0.472*	15,35 *0.604*	0,5 *0.020*	19,9 *0.783*	15,0	14,6	22,8	30	3	MM0416	✓				■
MM12-12015-R10A30-E04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓			■	
MM12-12015-R10A30-M04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓				■
MM12-12015-R15A30-D04	12,0 *0.472*	15,35 *0.604*	1,5 *0.059*	19,9 *0.783*	15,0	14,6	20,8	30	3	MM0416	✓			■	
MM12-12015-R20A30-M04	12,0 *0.472*	15,35 *0.604*	2,0 *0.079*	19,9 *0.783*	15,0	14,6	19,8	30	3	MM0416	✓				■
MM12-12015-R30A30-E04	12,0 *0.472*	15,3 *0.602*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓			■	
MM12-12015-R30A30-M04	12,0 *0.472*	15,35 *0.604*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓				■
MM12-12015-R40A30-M04	12,0 *0.472*	15,35 *0.604*	4,0 *0.157*	19,9 *0.783*	15,0	14,6	15,8	30	3	MM0416	✓				■
MM12-12715-A30-E04	12,7 *0.500*	15,35 *0.604*	0,0 *–*	19,9 *0.783*	15,0	15,4	25,2	30	3	MM0416	✓			■	
MM12-12715-R08A30-M04	12,7 *0.500*	15,35 *0.604*	0,8 *0.031*	19,9 *0.783*	15,0	15,4	23,6	30	3	MM0416	✓				■
MM12-12715-R16A30-M04	12,7 *0.500*	15,35 *0.604*	1,6 *0.063*	19,9 *0.783*	15,0	15,4	22,0	30	3	MM0416	✓				■

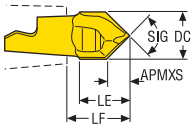
Slot milling/square shoulder milling



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM12-11708T-R03-D05	11,7 *0.461*	8,2 *0.323*	0,3 *0.012*	10,18 *0.401*	15,0	14,2	22,6	0	2	MM0612	■			
MM12-12008-M04	12,0 *0.472*	8,2 *0.323*	0,0 *–*	10,2 *0.402*	15,0	14,6	23,8	0	2	MM0612	■			
MM12-12008-R08A8-E04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,15 *0.400*	15,0	14,6	22,2	8	2	MM0612	■			
MM12-12008-R08-MD05	12,0 *0.472*	8,2 *0.323*	0,8 *0.031*	10,18 *0.401*	15,0	14,6	22,2	0	2	MM0612	■		■	
MM12-12008-R08P-M04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,05 *0.396*	15,0	14,6	22,2	0	2	MM0612			■	
MM12-12008-R20-MD05	12,0 *0.472*	8,2 *0.323*	2,0 *0.079*	10,16 *0.400*	15,0	14,6	19,8	0	2	MM0612			■	
MM12-12008-R30-MD05	12,0 *0.472*	8,2 *0.323*	3,0 *0.118*	10,14 *0.399*	15,0	14,6	17,8	0	2	MM0612			■	
MM12-12708-M04	12,7 *0.500*	9,3 *0.366*	0,0 *–*	11,25 *0.443*	15,0	15,4	25,2	0	2	MM1420	■			
MM12-12708-R08-MD05	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420	■			
MM12-12708-R08P-M04	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420			■	
MM12-13709T-R03-D05	13,7 *0.539*	9,3 *0.366*	0,3 *0.012*	11,25 *0.443*	15,0	16,6	26,6	0	2	MM1420	■			
MM12-14009-M04	14,0 *0.551*	9,3 *0.366*	0,0 *–*	11,26 *0.443*	15,0	17,0	27,8	0	2	MM1420	■			
MM12-14009-R08A8-E04	14,0 *0.551*	9,2 *0.362*	0,8 *0.031*	11,06 *0.435*	15,0	17,0	26,2	8	2	MM1420	■		■	
MM12-14009-R08-MD05	14,0 *0.551*	9,3 *0.366*	0,8 *0.031*	11,26 *0.443*	15,0	17,0	26,2	0	2	MM1420	■		■	

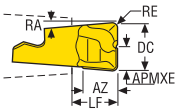
Centre drilling



• For Torque keys and torque values, see page 673

Designation	DC	APMXS	LE	LF	SIG°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM12-12006-C90-M04	12,0 *0.472*	5,65 *0.222*	12,65 *0.498*	14,64 *0.576*	90,0	2	MM0612	■			

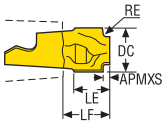
Plunge milling



• For Torque keys and torque values, see page 673

Designation	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM12-12008-R10-PL-MD05	12,0 *0.472*	6,0 *0.236*	1,0 *0.039*	8,5 *0.335*	10,2 *0.402*	5,0	2	MM0612			■	

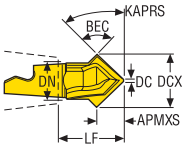
Concave radius



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			T60M	F15M	F30M	F40M
MM12-12010-CR10-MD05	12,0 *0.472*	2,2 *0.087*	1,0 *0.039*	12,14 *0.478*	2	MM0612	■			
MM12-12010-CR20-MD05	12,0 *0.472*	2,4 *0.094*	2,0 *0.079*	12,25 *0.482*	2	MM0612	■			
MM12-12010-CR30-MD05	12,0 *0.472*	3,3 *0.130*	3,0 *0.118*	12,2 *0.480*	2	MM0612	■			

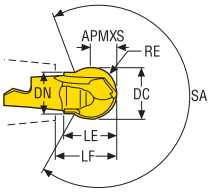
Double chamfering

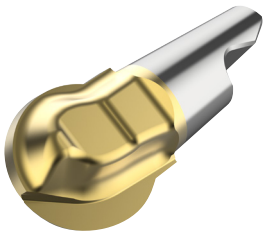


- For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	LF	DN	BEC°	KAPRS°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM12-16016-D3020P-M02	16,0 *0.630*	1,0 *0.039*	4,3 *0.169*	15,2 *0.598*	11,5 *0.453*	60,0	30,0	2	MM1420		■		
MM12-16016-D4520P-M02	16,0 *0.630*	1,0 *0.039*	7,5 *0.295*	17,2 *0.677*	11,5 *0.453*	90,0	45,0	2	MM1420		■		

Precision inserts for semi-finishing in all materials

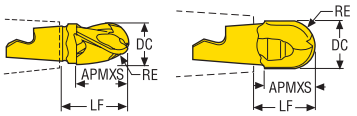




• For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LE	LF	DN	SA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM12-14014-B120P-M05	14,0 *0.551*	7,0 *0.276*	7,0 *0.276*	14,0 *0.551*	15,45 *0.608*	12,0 *0.472*	242,0	2	MM1420			■	
MM12-16016-B120PF-M03	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	17,46 *0.687*	12,0 *0.472*	263,0	2	MM1420		■		
MM12-16016-B120P-M07	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	17,46 *0.687*	12,0 *0.472*	263,0	2	MM1420			■	

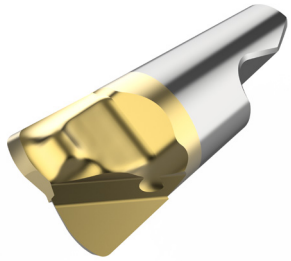
Copy milling

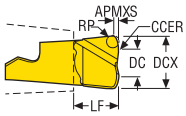


- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM12-12012-B90-MD05	12,0 *0.472*	12,2 *0.480*	6,0 *0.236*	14,12 *0.556*	0,0	2	MM0612		■		■	
MM12-12012-B90PF-M02	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*	0,0	2	MM0612			■		
MM12-12012-B90P-M05	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*	0,0	2	MM0612				■	
MM12-12012-B90S-E05	12,0 *0.472*	12,3 *0.484*	6,0 *0.236*	14,12 *0.556*	0,0	2	MM0612				■	
MM12-12015-B90A30-E04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓			■	
MM12-12015-B90A30-M04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓				■
MM12-12713-B90P-M05	12,7 *0.500*	12,2 *0.480*	6,35 *0.250*	15,92 *0.627*	0,0	2	MM1420		■		■	
MM12-12715-B90A30-M04	12,7 *0.500*	15,3 *0.602*	6,35 *0.250*	19,75 *0.778*	30,0	3	MM0416	✓				■
MM12-14014-B90S-E05	14,0 *0.551*	14,1 *0.555*	7,0 *0.276*	15,92 *0.627*	0,0	2	MM1420				■	

High feed





- For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM12-12.60-HF-MD10	12,0 *0.472*	6,0 *0.236*	0,51 *0.020*	1,21 *0.048*	6,5 *0.256*	10,25 *0.404*	5,0	14,6	22,2	2	MM0612			■	■	

MM12 - Slot and Side milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P3	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
P4	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P5	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P6	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P7	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P8	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
P11	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P12	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,036 *0.0014*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*
M1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
M2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
M3	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,042 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
M4	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
M5	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
K1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
K2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K4	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K5	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
K6	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,090 *0.0036*
K7	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
N1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N11	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S1	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S2	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S3	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,046 *0.0018*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0024*
S11	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
S12	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
S13	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
H5	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H8	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H11	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H12	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H21	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM12 - Slot and Side milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	250 *820*	315 *1025*	350 *1150*	385 *1275*	240 *790*	300 *980*	335 *1100*	365 *1200*	185 *610*	225 *740*	255 *840*	280 *920*
P2	245 *800*	305 *1000*	340 *1125*	375 *1225*	235 *770*	290 *950*	325 *1075*	355 *1175*	175 *570*	220 *720*	250 *820*	275 *900*
P3	210 *690*	265 *870*	295 *970*	325 *1075*	200 *660*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	215 *710*	235 *770*
P4	190 *620*	235 *770*	260 *850*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P5	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	240 *790*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P6	205 *670*	250 *820*	280 *920*	310 *1025*	195 *640*	240 *790*	270 *890*	295 *970*	150 *490*	185 *610*	205 *670*	225 *740*
P7	190 *620*	240 *790*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	215 *710*
P8	175 *570*	220 *720*	245 *800*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P11	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	220 *720*	245 *800*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P12	115 *375*	145 *475*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	170 *560*	85 *280*	110 *360*	120 *395*	130 *425*
M1	200 *660*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
M2	160 *520*	200 *660*	225 *740*	245 *800*	155 *510*	195 *640*	215 *710*	235 *770*	120 *395*	145 *475*	165 *540*	180 *590*
M3	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	145 *475*
M4	100 *330*	125 *410*	140 *460*	150 *490*	95 *310*	115 *375*	130 *425*	145 *475*	75 *245*	90 *295*	100 *330*	110 *360*
M5	80 *260*	100 *330*	115 *375*	125 *410*	80 *260*	95 *310*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K1	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	230 *750*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	220 *720*
K2	170 *560*	215 *710*	240 *790*	260 *850*	165 *540*	205 *670*	225 *740*	245 *800*	125 *410*	155 *510*	175 *570*	190 *620*
K3	145 *475*	180 *590*	200 *660*	220 *720*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	145 *475*	160 *520*
K4	140 *460*	170 *560*	190 *620*	210 *690*	130 *425*	165 *540*	185 *610*	200 *660*	100 *330*	125 *410*	140 *460*	155 *510*
K5	85 *280*	105 *345*	115 *375*	125 *410*	80 *260*	100 *330*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K6	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	110 *360*	125 *410*	135 *445*
K7	105 *345*	135 *445*	150 *490*	165 *540*	100 *330*	125 *410*	140 *460*	155 *510*	80 *260*	100 *330*	110 *360*	120 *395*
N1	1450 *4750*	1800 *5900*	2025 *6650*	2225 *7300*	1375 *4500*	1725 *5650*	1925 *6325*	2125 *6975*	1050 *3450*	1300 *4275*	1450 *4750*	1600 *5250*
N2	580 *1900*	730 *2400*	820 *2700*	900 *2950*	560 *1825*	690 *2275*	780 *2550*	860 *2825*	420 *1375*	530 *1750*	590 *1925*	650 *2125*
N3	390 *1275*	485 *1600*	550 *1800*	600 *1975*	370 *1225*	460 *1500*	520 *1700*	570 *1875*	280 *920*	350 *1150*	395 *1300*	435 *1425*
N11	445 *1450*	550 *1800*	620 *2025*	690 *2275*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	320 *1050*	405 *1325*	450 *1475*	495 *1625*
S1	46 *150*	55 *180*	65 *215*	70 *230*	44 *145*	55 *180*	60 *195*	65 *215*	34 *110*	43 *140*	47 *155*	50 *165*
S2	37 *120*	46 *150*	50 *165*	55 *180*	35 *115*	44 *145*	49 *160*	55 *180*	28 *90*	34 *110*	38 *125*	42 *140*
S3	32 *105*	40 *130*	45 *150*	50 *165*	31 *100*	38 *125*	43 *140*	47 *155*	24 *80*	30 *100*	33 *110*	37 *120*
S11	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	95 *310*	48 *155*	60 *195*	65 *215*	75 *245*
S12	45 *150*	55 *180*	60 *195*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	33 *110*	41 *135*	47 *155*	50 *165*
S13	26 *85*	32 *105*	36 *120*	40 *130*	25 *80*	31 *100*	34 *110*	38 *125*	19 *60*	24 *80*	27 *90*	29 *95*
H5	39 *130*	49 *160*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
H8	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*
H11	49 *160*	60 *195*	70 *230*	75 *245*	47 *155*	60 *195*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
H12	75 *245*	90 *295*	100 *330*	110 *360*	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	65 *215*	75 *245*	85 *280*
H21	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*

MM12 Z3 – Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,095 *0.0038*
P2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
P3	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P4	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
P6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P8	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P11	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P12	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
M1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
M2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
M3	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
M4	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
M5	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
K6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
S1	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S2	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S3	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,046 *0.0018*	0,046 *0.0018*	0,046 *0.0018*	0,055 *0.0024*
S11	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
S12	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
S13	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM12 Z3 – Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
P5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
P6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P8	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P12	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
M1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
M2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
M3	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
M4	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
M5	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
K6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
S1	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
S2	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
S3	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,050 *0.0020*	0,055 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
S11	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
S12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
S13	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM12 Z3 – Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	270 *890*	315 *1025*	335 *1100*	365 *1200*	360 *1175*	255 *840*	300 *980*	320 *1050*	345 *1125*	340 *1125*
P2	265 *870*	305 *1000*	325 *1075*	355 *1175*	350 *1150*	250 *820*	290 *950*	310 *1025*	335 *1100*	330 *1075*
P3	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P4	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*
P5	195 *640*	225 *740*	240 *790*	260 *850*	255 *840*	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*
P6	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*
P7	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*	195 *640*	230 *750*	240 *790*	260 *850*	260 *850*
P8	190 *620*	225 *740*	240 *790*	255 *840*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
P11	200 *660*	235 *770*	245 *800*	265 *870*	265 *870*	190 *620*	220 *720*	235 *770*	255 *840*	255 *840*
P12	125 *410*	150 *490*	155 *510*	170 *560*	165 *540*	120 *395*	140 *460*	145 *490*	160 *520*	160 *520*
M1	210 *690*	245 *800*	265 *870*	285 *940*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
M2	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*	165 *540*	195 *640*	205 *670*	220 *720*	220 *720*
M3	140 *460*	165 *540*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	160 *540*	175 *570*	175 *570*
M4	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M5	80 *260*	110 *360*	110 *375*	115 *375*	115 *375*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
K1	210 *690*	240 *790*	260 *850*	280 *920*	275 *900*	200 *660*	230 *750*	245 *800*	265 *870*	265 *870*
K2	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*
K3	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	180 *590*	200 *660*	195 *640*
K4	150 *490*	175 *570*	180 *590*	200 *660*	195 *640*	140 *460*	165 *540*	175 *570*	190 *620*	185 *610*
K5	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*	85 *280*	100 *330*	105 *345*	115 *375*	115 *375*
K6	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	145 *475*	155 *510*	165 *540*	165 *540*
K7	115 *375*	135 *445*	140 *460*	155 *510*	155 *510*	110 *360*	125 *410*	135 *445*	145 *475*	145 *475*
N1	1575 *5175*	1825 *6000*	1950 *6400*	2100 *6900*	2100 *6900*	1500 *4925*	1750 *5750*	1850 *6075*	2000 *6550*	2000 *6550*
N2	640 *2100*	740 *2425*	790 *2600*	850 *2800*	840 *2750*	610 *2000*	700 *2300*	750 *2450*	810 *2650*	800 *2625*
N3	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*	405 *1325*	470 *1550*	500 *1650*	540 *1775*	540 *1775*
N11	485 *1600*	560 *1825*	600 *1975*	650 *2125*	640 *2100*	460 *1500*	540 *1775*	570 *1875*	620 *2025*	610 *2000*
S1	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	60 *195*	60 *195*	65 *215*	60 *195*
S2	37 *120*	50 *165*	49 *165*	55 *180*	55 *180*	35 *115*	47 *155*	47 *165*	50 *165*	50 *165*
S3	32 *105*	43 *140*	43 *150*	46 *150*	46 *150*	31 *100*	41 *135*	41 *140*	44 *145*	44 *145*
S11	70 *230*	85 *280*	85 *295*	95 *310*	90 *295*	65 *215*	80 *260*	80 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *195*	65 *215*	65 *215*	46 *150*	55 *180*	55 *195*	60 *195*	60 *195*
S13	26 *85*	35 *115*	34 *120*	37 *120*	37 *120*	25 *80*	33 *110*	33 *115*	35 *115*	35 *115*
H5	42 *140*	50 *165*	50 *165*	55 *180*	55 *180*	40 *130*	47 *155*	49 *160*	55 *180*	55 *180*
H8	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H11	55 *180*	65 *215*	65 *215*	70 *230*	70 *230*	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*
H12	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	75 *245*	90 *295*	90 *310*	100 *330*	100 *330*
H21	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*

Seco

MM12 Z2 – Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P4	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
P6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P8	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P11	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P12	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
M1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
M2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
M3	MM12-12012-B90S-E05 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
M4	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
M5	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
K1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
K2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K4	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
K6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
N1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N11	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
S1	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
S2	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
S3	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,050 *0.0020*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0030*
S11	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
S12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
S13	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
H5	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
H8	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*
H11	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
H12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*
H21	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM12 Z2 – Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
P3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P8	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P12	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
M2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
M3	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
M4	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
M5	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
K1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
K2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
K6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
N1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
S2	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
S3	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
S12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
S13	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
H5	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

MM12 Z2 – Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	310 *1025*	390 *1275*	410 *1350*	445 *1450*	440 *1450*	240 *790*	300 *980*	325 *1075*	350 *1150*	345 *1125*	195 *640*	240 *790*	265 *870*	285 *940*	280 *920*
P2	300 *980*	380 *1250*	400 *1300*	430 *1400*	430 *1400*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	275 *900*
P3	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	205 *670*	225 *740*	240 *790*	240 *790*
P4	230 *750*	290 *950*	305 *1000*	325 *1075*	330 *1075*	175 *570*	225 *740*	245 *800*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P5	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*	140 *460*	170 *560*	190 *620*	205 *670*	200 *660*
P6	245 *800*	310 *1025*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	260 *850*	285 *940*	280 *920*	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*
P7	230 *750*	295 *970*	310 *1025*	335 *1100*	335 *1100*	180 *590*	230 *750*	245 *800*	270 *890*	265 *870*	145 *475*	185 *610*	200 *660*	215 *710*	215 *710*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*	135 *445*	170 *560*	190 *620*	200 *660*	200 *660*
P11	225 *740*	285 *940*	300 *980*	325 *1075*	325 *1075*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*
P12	140 *460*	180 *590*	180 *610*	195 *640*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	160 *520*	95 *310*	120 *395*	120 *410*	135 *445*	130 *425*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	225 *740*	220 *720*
M2	195 *640*	250 *820*	260 *850*	285 *940*	285 *940*	155 *510*	190 *620*	210 *690*	225 *740*	225 *740*	125 *410*	155 *510*	170 *560*	185 *610*	180 *590*
M3	155 *510*	200 *660*	205 *670*	220 *720*	220 *720*	125 *410*	160 *520*	165 *560*	180 *590*	180 *590*	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*
M4	120 *395*	155 *510*	155 *540*	165 *540*	165 *540*	100 *330*	130 *425*	130 *445*	135 *445*	140 *460*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	105 *375*	115 *375*	115 *375*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	340 *1125*	340 *1125*	180 *590*	230 *750*	250 *820*	270 *890*	270 *890*	145 *475*	185 *610*	205 *670*	220 *720*	215 *710*
K2	205 *670*	265 *870*	275 *900*	300 *980*	300 *980*	160 *520*	200 *660*	220 *720*	240 *790*	235 *770*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*
K3	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	135 *445*	170 *560*	185 *610*	205 *670*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*
K4	165 *540*	215 *710*	225 *740*	240 *790*	240 *790*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*	105 *345*	130 *425*	145 *475*	155 *510*	155 *510*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	80 *260*	100 *330*	110 *360*	115 *375*	115 *375*	65 *215*	80 *260*	85 *280*	95 *310*	95 *310*
K6	145 *475*	185 *610*	195 *640*	215 *710*	215 *710*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	135 *445*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	100 *330*	125 *410*	140 *460*	150 *490*	150 *490*	80 *260*	105 *345*	110 *360*	120 *395*	120 *395*
N1	1825 *6000*	2300 *7550*	2425 *7950*	2625 *8600*	2600 *8525*	1375 *4500*	1725 *5650*	1900 *6225*	2025 *6650*	2000 *6550*	1100 *3600*	1400 *4600*	1525 *5000*	1650 *5425*	1625 *5325*
N2	730 *2400*	930 *3050*	980 *3225*	1050 *3450*	1050 *3450*	550 *1800*	690 *2275*	760 *2500*	820 *2700*	810 *2650*	450 *1475*	560 *1825*	620 *2025*	660 *2175*	660 *2175*
N3	490 *1600*	620 *2025*	650 *2125*	710 *2325*	700 *2300*	370 *1225*	465 *1525*	510 *1675*	550 *1800*	540 *1775*	300 *980*	375 *1225*	410 *1350*	440 *1450*	440 *1450*
N11	560 *1825*	710 *2325*	750 *2450*	810 *2650*	800 *2625*	425 *1400*	530 *1750*	580 *1900*	620 *2025*	620 *2025*	340 *1125*	430 *1400*	470 *1550*	500 *1650*	500 *1650*
S1	55 *180*	70 *230*	70 *260*	80 *260*	80 *260*	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
S2	45 *150*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	39 *130*	39 *135*	42 *140*	42 *140*
S3	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	43 *140*	42 *145*	45 *150*	45 *150*	27 *90*	34 *110*	34 *120*	37 *120*	36 *120*
S11	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	45 *150*	60 *195*	60 *195*	65 *215*	60 *195*	37 *120*	47 *155*	47 *160*	50 *165*	50 *165*
S13	32 *105*	41 *135*	40 *145*	44 *145*	44 *145*	26 *85*	34 *110*	34 *120*	36 *120*	36 *120*	21 *70*	28 *90*	27 *95*	29 *95*	29 *95*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	50 *165*	55 *180*	55 *180*	31 *100*	39 *130*	41 *135*	44 *145*	44 *145*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	49 *160*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*

MM12 High-Feed – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,95 *0.038*
P2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
P6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P8	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P12	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
M1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
M2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
M3	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
M4	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
M5	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
K1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
K6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
N1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
S1	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
S2	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
S3	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,34 *0.013*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
S11	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S12	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S13	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
H5	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
H8	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*
H11	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
H12	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*
H21	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*

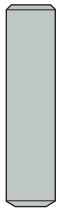
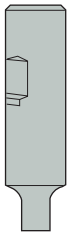
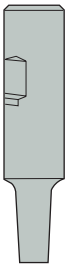
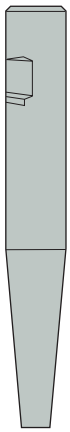
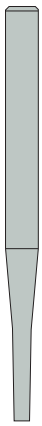
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

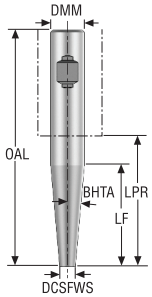
MM12 High-Feed – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	225	275	315	330
	—	—	—	—	*740*	*900*	*1025*	*1075*
P2	—	—	—	—	220	265	310	320
	—	—	—	—	*720*	*870*	*1025*	*1050*
P3	—	—	—	—	190	230	270	280
	—	—	—	—	*620*	*750*	*890*	*920*
P4	—	—	—	—	165	205	235	245
	—	—	—	—	*540*	*670*	*770*	*800*
P5	—	—	—	—	165	195	225	240
	—	—	—	—	*540*	*640*	*740*	*790*
P6	—	—	—	—	185	225	255	270
	—	—	—	—	*610*	*740*	*840*	*890*
P7	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P8	—	—	—	—	160	195	225	235
	—	—	—	—	*520*	*640*	*740*	*770*
P11	—	—	—	—	165	205	235	245
	—	—	—	—	*540*	*670*	*770*	*800*
P12	—	—	—	—	110	130	150	160
	—	—	—	—	*360*	*425*	*490*	*520*
M1	—	—	—	—	175	215	250	260
	—	—	—	—	*570*	*710*	*820*	*850*
M2	—	—	—	—	145	175	205	215
	—	—	—	—	*475*	*570*	*670*	*710*
M3	—	—	—	—	120	140	165	175
	—	—	—	—	*395*	*460*	*540*	*570*
M4	—	—	—	—	95	110	125	130
	—	—	—	—	*310*	*360*	*410*	*425*
M5	—	—	—	—	80	90	105	110
	—	—	—	—	*260*	*295*	*345*	*360*
K1	185	225	260	275	175	210	245	255
	610	*740*	*850*	*900*	*570*	*690*	*800*	*840*
K2	165	200	230	245	155	185	215	225
	540	*660*	*750*	*800*	*510*	*610*	*710*	*740*
K3	140	170	195	205	130	155	180	190
	460	*560*	*640*	*670*	*425*	*510*	*590*	*620*
K4	135	160	185	195	125	150	175	185
	445	*520*	*610*	*640*	*410*	*490*	*570*	*610*
K5	80	100	115	120	75	90	105	110
	260	*330*	*375*	*395*	*245*	*295*	*345*	*360*
K6	120	140	165	175	110	130	155	160
	395	*460*	*540*	*570*	*360*	*425*	*510*	*520*
K7	105	125	145	155	95	115	135	145
	345	*410*	*475*	*510*	*310*	*375*	*445*	*475*
N1	—	—	—	—	1275	1575	1800	1875
	—	—	—	—	*4175*	*5175*	*5900*	*6150*
N2	—	—	—	—	520	630	730	750
	—	—	—	—	*1700*	*2075*	*2400*	*2450*
N3	—	—	—	—	345	420	485	500
	—	—	—	—	*1125*	*1375*	*1600*	*1650*
N11	—	—	—	—	395	480	550	570
	—	—	—	—	*1300*	*1575*	*1800*	*1875*
S1	—	—	—	—	44	50	60	60
	—	—	—	—	*145*	*165*	*195*	*195*
S2	—	—	—	—	35	41	47	50
	—	—	—	—	*115*	*135*	*155*	*165*
S3	—	—	—	—	31	36	42	44
	—	—	—	—	*100*	*120*	*140*	*145*
S11	—	—	—	—	60	70	85	90
	—	—	—	—	*195*	*230*	*280*	*295*
S12	—	—	—	—	42	50	55	60
	—	—	—	—	*140*	*165*	*180*	*195*
S13	—	—	—	—	25	29	33	35
	—	—	—	—	*80*	*95*	*110*	*115*
H5	39	46	55	55	36	43	50	55
	130	*150*	*180*	*180*	*120*	*140*	*165*	*180*
H8	41	49	55	60	38	45	50	55
	135	*160*	*180*	*195*	*125*	*150*	*165*	*180*
H11	49	60	70	70	46	55	65	65
	160	*195*	*230*	*230*	*150*	*180*	*215*	*215*
H12	75	90	100	105	70	80	95	100
	245	*295*	*330*	*345*	*230*	*260*	*310*	*330*
H21	41	49	55	60	38	45	50	55
	135	*160*	*180*	*195*	*125*	*150*	*165*	*180*

Shank design

Design 1, Keyway shank	Design 2, Cylindrical/Weldon back end and 90º front
	
Design 3, Cylindrical/Weldon back end tapered front 87º/89º	**Design 4, Cylindrical/Weldon back end tapered front 80º/85º/87º**
	
Design 5, Cylindrical back end double tapered front end 89º/85º	
	

MM16 Shank – Metric

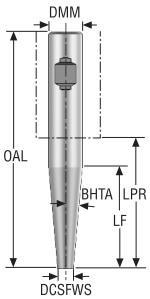


Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM16-20115.3-3045	75014109	Weldon	15,2	20,0	115,0	45,8	65,0	3,0	4	✓	63600	0,2	3
MM16-25100.3-0019	75012790	Weldon	15,2	25,0	100,0	19,0	40,0	0,0	2	✓	63600	0,3	3
MM16-25115.3-3035	75012791	Weldon	15,2	25,0	115,0	35,0	59,0	3,0	3	✓	63600	0,3	3
MM16-25170.3-5056	75012792	Weldon	15,2	25,0	170,0	56,0	114,0	5,0	4	✓	63600	0,6	4
MM16-16070.0-0011M	00023547	Cylindrical	15,2	16,0	70,0	11,3	22,0	0,0	2	✓	63600	0,1	1
MM16-20070.0-0000	00023548	Cylindrical	15,2	20,0	70,0	0,0	20,0	60,0	1	✓	63600	0,2	1
MM16-20190.0-1055M	00094766	Cylindrical	15,2	20,0	190,0	55,0	140,0	1,0	3	✓	63600	0,4	5
MM16-20190.0-1075M	00094768	Cylindrical	15,2	20,0	190,0	75,0	140,0	1,0	3	✓	63600	0,4	5
MM16-20190.0-1095M	00094770	Cylindrical	15,2	20,0	190,0	95,0	140,0	1,0	3	✓	63600	0,4	6
MM16-25170.0-1060	00094767	Cylindrical	19,0	25,0	170,0	60,0	114,0	1,0	3	✓	63600	0,5	5
MM16-32250.0-10047	75069368	Cylindrical	15,2	32,0	250,0	47,6	190,0	10,0	4	✓	63600	1,3	4
MM16-16150.0-0080DS	02580692	Cylindrical	15,2	16,0	150,0	80,0	102,0	0,0	2	✓	47600	0,4	2
MM16-20080.0-0011DS	02580669	Cylindrical	15,2	20,0	80,0	11,3	30,0	0,0	2	✓	47600	0,3	2
MM16-20150.0-0038DS	02580695	Cylindrical	15,2	20,0	150,0	38,0	100,0	0,0	2	✓	47600	0,6	2
MM16-20160.0-0076DS	02580699	Cylindrical	15,2	20,0	160,0	76,0	110,0	0,0	2	✓	47600	0,6	2
MM16-20130.0-1045DS	02580757	Cylindrical	15,2	20,0	130,0	45,0	80,0	1,0	3	✓	47600	0,5	2
MM16-20190.0-1075DS	02580758	Cylindrical	15,2	20,0	190,0	75,0	140,0	1,0	3	✓	47600	0,8	2
MM16-20190.0-1095DS	02580760	Cylindrical	15,2	20,0	190,0	95,0	140,0	1,0	3	✓	47600	0,8	2
MM16-25250.0-1075DS	02580761	Cylindrical	15,2	25,0	250,0	75,0	194,0	1,0	5	✓	47600	1,5	2

Spare Parts, included in delivery

For cutter	Sleeve	Tension screw
3	MM-10062	MM16-1045
4	MM-10132	MM16-1045
1	MM-10030	MM16-1045
5	MM-10062	MM16-1093
6	MM-10062	MM16-10113
2	–	MM16-1045

MM16 Shank – *Inch*

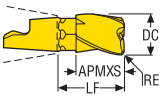


Designation	Item number	Type of mounting	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			inch	inch	inch	inch	inch					lbs	
MM16-0.75-4.5-3-3018	75054603	Weldon	0.598	0.750	4.528	1.445	2.559	3,0	3	✓	63600	0.440	4
MM16-1.00-3.9-3-0007	75015058	Weldon	0.598	1.000	3.937	0.748	1.732	0,0	2	✓	63600	0.660	4
MM16-1.00-4.5-3-3013	75015059	Weldon	0.598	1.000	4.528	1.378	2.323	3,0	3	✓	63600	0.660	4
MM16-1.00-6.7-3-5022	75015060	Weldon	0.598	1.000	6.693	2.295	4.488	5,0	4	✓	63600	1.320	5
MM16-0.62-2.8-0M-0004	00037209	Cylindrical	0.598	0.625	2.756	0.445	0.866	0,0	2	✓	63600	0.220	1
MM16-0.75-2.8-0-0000	00037175	Cylindrical	0.598	0.750	2.756	0	0.787	60,0	1	✓	63600	0.440	1
MM16-0.75-7.5-0-1021	75054731	Cylindrical	0.598	0.750	7.480	2.165	5.512	1,0	3	✓	63600	0.660	6
MM16-0.75-7.5-0-1037	75054733	Cylindrical	0.598	0.750	7.480	3.740	5.512	1,0	3	✓	63600	0.880	7
MM16-0.75-7.5-0-1029DS	02567719	Cylindrical	0.598	0.750	7.480	2.953	5.512	1,0	3	✓	47600	1.760	3
MM16-0.75-7.5-0-1037DS	02593431	Cylindrical	0.598	0.750	7.480	3.740	5.512	1,0	3	✓	47600	1.540	3
MM16-1.00-5.9-0-0015DS	02593433	Cylindrical	0.598	1.000	5.906	1.496	3.701	0,0	2	✓	47600	2.200	3
MM16-1.00-6.3-0-0030DS	02593434	Cylindrical	0.598	1.000	6.299	2.992	4.094	0,0	2	✓	47600	1.980	3

Spare Parts, included in delivery

For cutter	Sleeve	Tension screw
4	MM-10062	MM16-1045
5	MM-10132	MM16-1045
1	MM-10030	MM16-1045
6	MM-10062	MM16-1093
7	MM-10062	MM16-10113
3	–	MM16-1045

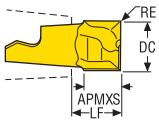
Slot milling/square shoulder milling



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*								T60M	F15M	F30M	F40M
MM16-15719-R03A30-M06	15,7 *0.618*	19,05 *0.750*	0,3 *0.012*	24,5 *0.965*	15,0	19,0	30,6	30	3	MM0416	✓				■
MM16-15919-R08A30-M06	15,875 *0.625*	19,05 *0.750*	0,8 *0.031*	24,5 *0.965*	15,0	19,2	29,9	30	3	MM0416	✓				■
MM16-16019-A30-E06	16,0 *0.630*	19,05 *0.750*	0,0 –	24,5 *0.965*	15,0	19,4	31,8	30	3	MM0416	✓			■	
MM16-16019-R05A30-M06	16,0 *0.630*	19,05 *0.750*	0,5 *0.020*	24,5 *0.965*	15,0	19,4	30,8	30	3	MM0416	✓				■
MM16-16019-R10A30-E06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓			■	
MM16-16019-R10A30-M06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓				■
MM16-16019-R20A30-M06	16,0 *0.630*	19,05 *0.750*	2,0 *0.079*	24,5 *0.965*	15,0	19,4	27,8	30	3	MM0416	✓				■
MM16-16019-R30A30-E06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓			■	
MM16-16019-R30A30-M06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓				■
MM16-16019-R40A30-M06	16,0 *0.630*	19,05 *0.750*	4,0 *0.157*	24,5 *0.965*	15,0	19,4	23,8	30	3	MM0416	✓				■
MM16-16019-R50A30-M06	16,0 *0.630*	19,05 *0.750*	5,0 *0.197*	24,5 *0.965*	15,0	19,4	21,8	30	3	MM0416	✓				■
MM16-16019-R60A30-M06	16,0 *0.630*	19,05 *0.750*	6,0 *0.236*	24,5 *0.965*	15,0	19,4	19,8	30	3	MM0416	✓				■
MM16-20015-A30-E06	20,0 *0.787*	15,0 *0.591*	0,0 –	20,15 *0.793*	15,0	24,2	39,8	30	3	MM0416	✓			■	
MM16-20015-R05A30-M06	20,0 *0.787*	15,0 *0.591*	0,5 *0.020*	20,15 *0.793*	15,0	24,2	38,8	30	3	MM0416	✓				■
MM16-20015-R10A30-M06	20,0 *0.787*	15,0 *0.591*	1,0 *0.039*	20,15 *0.793*	15,0	24,2	37,8	30	3	MM0416	✓				■
MM16-20015-R20A30-D06	20,0 *0.787*	15,0 *0.591*	2,0 *0.079*	20,15 *0.793*	15,0	24,2	35,8	30	3	MM0416	✓			■	
MM16-20015-R30A30-M06	20,0 *0.787*	15,0 *0.591*	3,0 *0.118*	20,15 *0.793*	15,0	24,2	33,8	30	3	MM0416	✓				■
MM16-20015-R50A30-M06	20,0 *0.787*	15,0 *0.591*	5,0 *0.197*	20,15 *0.793*	15,0	24,2	29,8	30	3	MM0416	✓				■

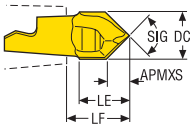
Slot milling/square shoulder milling



• For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							T60M	F15M	F30M	F40M
MM16-15711T-R03-D07	15,7 *0.618*	11,0 *0.433*	0,3 *0.012*	13,6 *0.535*	15,0	19,0	30,6	0	2	MM1420	■			
MM16-16011-M06	16,0 *0.630*	11,0 *0.433*	0,0 –	13,6 *0.535*	15,0	19,4	31,8	0	2	MM1420	■			
MM16-16011-R08A8-E06	16,0 *0.630*	10,5 *0.413*	0,8 *0.031*	13,62 *0.536*	15,0	19,4	30,2	8	2	MM1420	■		■	
MM16-16011-R08-MD07	16,0 *0.630*	11,0 *0.433*	0,8 *0.031*	13,58 *0.535*	15,0	19,4	30,2	0	2	MM1420	■		■	
MM16-16011-R08P-M05	16,0 *0.630*	10,8 *0.425*	0,8 *0.031*	13,41 *0.528*	15,0	19,4	30,2	0	2	MM1420			■	
MM16-16011-R20-MD07	16,0 *0.630*	10,9 *0.429*	2,0 *0.079*	13,55 *0.533*	15,0	19,4	27,8	0	2	MM1420			■	
MM16-16011-R30-MD07	16,0 *0.630*	10,9 *0.429*	3,0 *0.118*	13,54 *0.533*	15,0	19,4	25,8	0	2	MM1420			■	
MM16-16011-R40-MD07	16,0 *0.630*	10,9 *0.429*	4,0 *0.157*	13,52 *0.532*	15,0	19,4	23,8	0	2	MM1420	■			
MM16-16011-R50-MD07	16,0 *0.630*	10,9 *0.429*	5,0 *0.197*	13,5 *0.531*	15,0	19,4	21,8	0	2	MM1420	■			
MM16-19013-R08A8-E06	19,05 *0.750*	12,7 *0.500*	0,8 *0.031*	15,39 *0.606*	15,0	23,1	36,3	8	2	MM1420			■	
MM16-20013-R08A8-E06	20,0 *0.787*	12,7 *0.500*	0,8 *0.031*	15,42 *0.607*	15,0	24,2	38,2	8	2	MM1420	■		■	

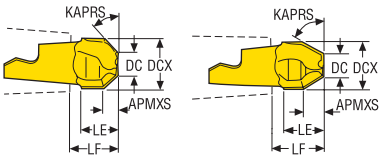
Centre drilling



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	LE	LF	SIG°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM16-16008-C90-M06	16,0 *0.630*	7,53 *0.296*	16,7 *0.657*	19,2 *0.756*	90,0	2	MM1420	■			
MM16-16011-C120-M06	16,0 *0.630*	4,3 *0.169*	16,64 *0.655*	18,9 *0.744*	120,0	2	MM1420	■			
MM16-19019-C90	19,05 *0.750*	9,6 *0.378*	20,3 *0.799*	22,15 *0.872*	90,0	2	MM1420	■			

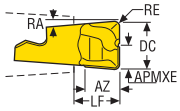
Chamfering



- For Torque keys and torque values, see page 673

Designation	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM16-16011-4540-E06	16,0 *0.630*	7,69 *0.303*	3,9 *0.154*	10,9 *0.429*	13,25 *0.522*	45,0	2	MM1420	■			
MM16-16012-6060-E06	16,0 *0.630*	8,38 *0.330*	6,7 *0.264*	12,9 *0.508*	15,3 *0.602*	60,0	2	MM1420	■			

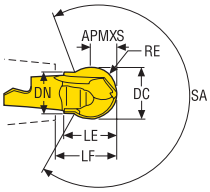
Plunge milling

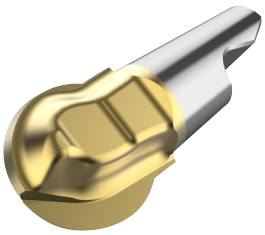


• For Torque keys and torque values, see page 673

Designation	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM16-16011-R10-PL-MD07	16,0 *0.630*	8,0 *0.315*	1,0 *0.039*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	
MM16-16011-R20-PL-MD07	16,0 *0.630*	8,0 *0.315*	2,0 *0.079*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	

Precision inserts for semi-finishing in all materials

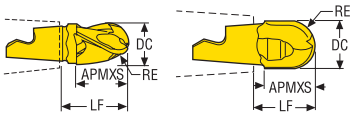




• For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LE	LF	DN	SA°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM16-20020-B120PF-M04	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	21,94 *0.864*	15,9 *0.626*	254,0	2	MM1420		■		
MM16-20020-B120P-M07	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	21,94 *0.864*	15,9 *0.626*	254,0	2	MM1420			■	

Copy milling



- For Torque keys and torque values, see page 673

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM16-15916-B90P-M07	15,875 *0.625*	13,8 *0.543*	7,938 *0.313*	18,4 *0.724*	0,0	2	MM1420				■	
MM16-16016-B90-MD07	16,0 *0.630*	16,2 *0.638*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420		■		■	
MM16-16016-B90PF-M03	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420			■		
MM16-16016-B90P-M07	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420				■	
MM16-16019-B90A30-E06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM0416	✓			■	
MM16-16019-B90A30-M06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM0416	✓				■
MM16-19020-B90P-M07	19,05 *0.750*	7,4 *0.291*	9,525 *0.375*	22,12 *0.871*	0,0	2	MM1420		■			
MM16-20015-B90A30-E06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM0416	✓			■	
MM16-20015-B90A30-M06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM0416	✓				■
MM16-20020-B90-MD07	20,0 *0.787*	20,3 *0.799*	10,0 *0.394*	22,15 *0.872*	0,0	2	MM1420		■		■	
MM16-20020-B90P-M07	20,0 *0.787*	17,4 *0.685*	10,0 *0.394*	22,12 *0.871*	0,0	2	MM1420				■	

MM16 - Slot and Side milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*
P2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
P3	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
P4	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
P5	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
P6	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P7	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P8	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
P11	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
M2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
M3	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
M4	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
M5	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
K1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K4	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K5	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
K6	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K7	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
N1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N11	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
S1	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
S2	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
S3	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
S11	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
S12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
S13	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
H5	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
H8	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
H11	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
H12	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
H21	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM16 - Slot and Side milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	230 *750*	285 *940*	315 *1025*	350 *1150*	215 *710*	270 *890*	300 *980*	335 *1100*	200 *660*	250 *820*	275 *900*	310 *1025*
P2	220 *720*	275 *900*	310 *1025*	345 *1125*	210 *690*	260 *850*	290 *950*	325 *1075*	195 *640*	240 *790*	270 *890*	295 *970*
P3	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	225 *740*	255 *840*	280 *920*	170 *560*	210 *690*	235 *770*	260 *850*
P4	170 *560*	215 *710*	240 *790*	265 *870*	160 *520*	205 *670*	225 *740*	250 *820*	150 *490*	185 *610*	205 *670*	225 *740*
P5	165 *540*	205 *670*	230 *750*	250 *820*	155 *510*	195 *640*	215 *710*	240 *790*	140 *460*	175 *570*	200 *660*	220 *720*
P6	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	215 *710*	245 *800*	270 *890*	160 *520*	200 *660*	220 *720*	245 *800*
P7	175 *570*	220 *720*	245 *800*	265 *870*	165 *540*	205 *670*	230 *750*	255 *840*	150 *490*	190 *620*	210 *690*	235 *770*
P8	160 *520*	205 *670*	230 *750*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	140 *460*	175 *570*	200 *660*	215 *710*
P11	170 *560*	210 *690*	235 *770*	260 *850*	160 *520*	200 *660*	225 *740*	245 *800*	145 *475*	185 *610*	205 *670*	225 *740*
P12	110 *360*	135 *445*	150 *490*	165 *540*	105 *345*	130 *425*	145 *475*	155 *510*	95 *310*	120 *395*	130 *425*	145 *475*
M1	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	155 *510*	190 *620*	215 *710*	240 *790*
M2	150 *490*	185 *610*	205 *670*	225 *740*	140 *460*	175 *570*	195 *640*	215 *710*	125 *410*	160 *520*	180 *590*	200 *660*
M3	120 *395*	150 *490*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	175 *570*	105 *345*	130 *425*	145 *475*	155 *510*
M4	90 *295*	115 *375*	130 *425*	140 *460*	85 *280*	110 *360*	120 *395*	135 *445*	80 *260*	100 *330*	110 *360*	120 *395*
M5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	85 *280*	95 *310*	100 *330*
K1	175 *570*	220 *720*	245 *800*	270 *890*	165 *540*	205 *670*	230 *750*	260 *850*	150 *490*	190 *620*	210 *690*	235 *770*
K2	155 *510*	195 *640*	215 *710*	240 *790*	145 *475*	185 *610*	205 *670*	225 *740*	135 *445*	170 *560*	190 *620*	210 *690*
K3	130 *425*	165 *540*	185 *610*	205 *670*	125 *410*	155 *510*	175 *570*	190 *620*	115 *375*	145 *475*	160 *520*	175 *570*
K4	125 *410*	160 *520*	175 *570*	195 *640*	120 *395*	150 *490*	165 *540*	185 *610*	110 *360*	135 *445*	150 *490*	170 *560*
K5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	80 *260*	95 *310*	100 *330*
K6	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	130 *425*	145 *475*	160 *520*	95 *310*	120 *395*	135 *445*	150 *490*
K7	100 *330*	120 *395*	135 *445*	150 *490*	95 *310*	115 *375*	130 *425*	140 *460*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1325 *4350*	1650 *5425*	1825 *6000*	2025 *6650*	1225 *4025*	1550 *5075*	1725 *5650*	1925 *6325*	1125 *3700*	1425 *4675*	1575 *5175*	1750 *5750*
N2	530 *1750*	670 *2200*	730 *2400*	820 *2700*	500 *1650*	630 *2075*	690 *2275*	770 *2525*	455 *1500*	570 *1875*	640 *2100*	700 *2300*
N3	355 *1175*	445 *1450*	490 *1600*	540 *1775*	335 *1100*	420 *1375*	465 *1525*	520 *1700*	305 *1000*	385 *1275*	425 *1400*	470 *1550*
N11	405 *1325*	510 *1675*	560 *1825*	620 *2025*	380 *1250*	475 *1550*	530 *1750*	590 *1925*	345 *1125*	435 *1425*	485 *1600*	540 *1775*
S1	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	38 *125*	46 *150*	50 *165*	55 *180*
S2	35 *115*	43 *140*	48 *155*	55 *180*	33 *110*	41 *135*	45 *150*	50 *165*	30 *100*	37 *120*	42 *140*	46 *150*
S3	30 *100*	38 *125*	42 *140*	46 *150*	29 *95*	35 *115*	40 *130*	44 *145*	27 *90*	33 *110*	37 *120*	40 *130*
S11	60 *195*	75 *245*	85 *280*	90 *295*	55 *180*	70 *230*	80 *260*	90 *295*	50 *165*	65 *215*	75 *245*	80 *260*
S12	42 *140*	50 *165*	60 *195*	65 *215*	39 *130*	49 *160*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*
S13	24 *80*	30 *100*	34 *110*	37 *120*	23 *75*	29 *95*	32 *105*	35 *115*	21 *70*	26 *85*	29 *95*	32 *105*
H5	36 *120*	45 *150*	50 *165*	55 *180*	34 *110*	43 *140*	48 *155*	50 *165*	31 *100*	39 *130*	44 *145*	48 *155*
H8	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*
H11	46 *150*	60 *195*	65 *215*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*
H12	70 *230*	85 *280*	95 *310*	105 *345*	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	90 *295*
H21	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*

MM16 Z3 – Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*
P2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
P3	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,14 *0.0055*
P4	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P5	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P6	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P7	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P8	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,14 *0.0055*
P11	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
M1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
M2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
M3	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,080 *0.0032*	0,11 *0.0044*
M4	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
M5	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,085 *0.0034*	0,090 *0.0036*	0,12 *0.0048*
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,085 *0.0034*	0,090 *0.0036*	0,12 *0.0048*
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
S1	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
S2	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
S3	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0036*
S11	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S13	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

MM16 Z3 – Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*	0,32 *0.013*
P2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
P3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,32 *0.013*
P4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,19 *0.0075*	0,30 *0.012*
P5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P8	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,32 *0.013*
P11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
M1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
M2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
M3	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
M4	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
M5	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
S1	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S2	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S3	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,075 *0.0030*	0,085 *0.0036*	0,12 *0.0048*	0,19 *0.0075*
S11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
S12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
S13	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM16 Z3 – Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	245 *800*	295 *970*	310 *1025*	335 *1100*	335 *1100*	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*
P2	240 *790*	285 *940*	300 *980*	325 *1075*	320 *1050*	230 *750*	270 *890*	285 *940*	310 *1025*	305 *1000*
P3	210 *690*	250 *820*	260 *850*	285 *940*	280 *920*	200 *660*	240 *790*	250 *820*	270 *890*	265 *870*
P4	185 *610*	220 *720*	235 *770*	250 *820*	250 *820*	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*
P5	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*	170 *560*	200 *660*	215 *710*	230 *750*	230 *750*
P6	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P7	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	240 *790*
P8	175 *570*	210 *690*	220 *720*	240 *790*	235 *770*	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*
P11	185 *610*	215 *710*	230 *750*	250 *820*	245 *800*	175 *570*	205 *670*	220 *720*	235 *770*	235 *770*
P12	115 *375*	145 *475*	145 *475*	160 *520*	155 *510*	110 *360*	140 *460*	140 *460*	150 *490*	150 *490*
M1	195 *640*	230 *750*	240 *790*	265 *870*	260 *850*	185 *610*	220 *720*	230 *750*	250 *820*	245 *800*
M2	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	150 *490*	180 *590*	190 *620*	205 *670*	205 *670*
M3	130 *425*	160 *520*	160 *520*	170 *560*	170 *560*	120 *395*	150 *490*	150 *490*	165 *540*	165 *540*
M4	90 *295*	125 *410*	125 *425*	130 *425*	135 *445*	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*
M5	75 *245*	105 *345*	100 *360*	110 *360*	110 *360*	70 *230*	100 *330*	100 *345*	105 *345*	105 *345*
K1	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K2	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*
K3	140 *460*	170 *560*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K4	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	165 *540*	175 *570*	175 *570*
K5	85 *280*	100 *330*	105 *345*	110 *360*	110 *360*	80 *260*	95 *310*	100 *330*	105 *345*	105 *345*
K6	120 *395*	140 *460*	150 *490*	165 *540*	160 *520*	115 *375*	135 *445*	145 *475*	155 *510*	155 *510*
K7	105 *345*	125 *410*	130 *425*	145 *475*	145 *475*	100 *330*	120 *395*	125 *410*	135 *445*	135 *445*
N1	1425 *4675*	1700 *5575*	1775 *5825*	1925 *6325*	1900 *6225*	1350 *4425*	1625 *5325*	1700 *5575*	1850 *6075*	1800 *5900*
N2	580 *1900*	690 *2275*	720 *2350*	780 *2550*	770 *2525*	550 *1800*	650 *2125*	680 *2225*	740 *2425*	730 *2400*
N3	385 *1275*	455 *1500*	480 *1575*	520 *1700*	510 *1675*	365 *1200*	435 *1425*	455 *1500*	495 *1625*	485 *1600*
N11	440 *1450*	520 *1700*	550 *1800*	600 *1975*	580 *1900*	420 *1375*	495 *1625*	520 *1700*	570 *1875*	560 *1825*
S1	42 *140*	60 *195*	55 *195*	60 *195*	60 *195*	40 *130*	55 *180*	55 *195*	60 *195*	60 *195*
S2	34 *110*	48 *155*	46 *160*	50 *165*	50 *165*	33 *110*	45 *150*	44 *155*	47 *155*	48 *155*
S3	30 *100*	41 *135*	40 *140*	43 *140*	43 *140*	28 *90*	39 *130*	38 *135*	41 *135*	41 *135*
S11	65 *215*	80 *260*	80 *280*	85 *280*	85 *280*	60 *195*	80 *260*	75 *260*	85 *280*	80 *260*
S12	45 *150*	55 *180*	55 *195*	60 *195*	60 *195*	43 *140*	55 *180*	55 *180*	55 *180*	55 *180*
S13	24 *80*	33 *110*	32 *110*	35 *115*	35 *115*	23 *75*	32 *105*	31 *110*	33 *110*	33 *110*
H5	39 *130*	48 *155*	48 *160*	55 *180*	50 *165*	37 *120*	46 *150*	46 *150*	50 *165*	50 *165*
H8	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
H11	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
H12	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
H21	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*

Seco

MM16 Z2 – Copy milling – Insert selection – Roughing – mm/*Inch*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P8	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P11	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P12	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
M1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
M3	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,085 *0.0034*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0050*
M4	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
M5	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
K1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S2	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S3	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*
S11	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0050*
S12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0050*
S13	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
H5	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
H8	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
H11	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
H12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
H21	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

MM16 Z2 – Copy milling – Insert selection – Finishing – mm/*Inch*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
P3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P8	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P12	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
M1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
M2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
K2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,13 *0.0050*
K6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,13 *0.0050*
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S1	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H8	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
H11	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
H21	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

Seco

Universal | Steel and cast iron | Stainless steel and S-materials | Non ferrous | Hard | Plastic and cfrp | Graphite | X-Heads | Minimaster Plus | Minimaster

MM16 Z2 – Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	285 *940*	360 *1175*	390 *1275*	420 *1375*	415 *1350*	225 *740*	280 *920*	300 *980*	325 *1075*	325 *1075*	185 *610*	225 *740*	245 *800*	265 *870*	265 *870*
P2	275 *900*	350 *1150*	375 *1225*	405 *1325*	405 *1325*	220 *720*	270 *890*	295 *970*	315 *1025*	315 *1025*	180 *590*	220 *720*	240 *790*	255 *840*	255 *840*
P3	240 *790*	305 *1000*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	255 *840*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P4	215 *710*	270 *890*	285 *940*	310 *1025*	310 *1025*	170 *560*	210 *690*	225 *740*	245 *800*	245 *800*	140 *460*	170 *560*	185 *610*	200 *660*	195 *640*
P5	205 *670*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	200 *660*	220 *720*	235 *770*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	190 *620*
P6	230 *750*	290 *950*	310 *1025*	335 *1100*	335 *1100*	180 *590*	225 *740*	245 *800*	265 *870*	265 *870*	150 *490*	180 *590*	200 *660*	215 *710*	215 *710*
P7	215 *710*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	210 *690*	230 *750*	250 *820*	250 *820*	140 *460*	170 *560*	190 *620*	200 *660*	200 *660*
P8	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	200 *660*	215 *710*	235 *770*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	190 *620*
P11	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	165 *540*	205 *670*	225 *740*	240 *790*	240 *790*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*
P12	135 *445*	175 *570*	175 *590*	190 *620*	190 *620*	110 *360*	140 *460*	145 *475*	155 *510*	155 *510*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
M1	225 *740*	285 *940*	300 *980*	330 *1075*	325 *1075*	175 *570*	220 *720*	235 *770*	255 *840*	250 *820*	145 *475*	180 *590*	190 *620*	205 *670*	205 *670*
M2	185 *610*	230 *750*	250 *820*	270 *890*	265 *870*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*	120 *395*	145 *475*	160 *520*	170 *560*	170 *560*
M3	150 *490*	190 *620*	195 *660*	210 *690*	210 *690*	120 *395*	150 *490*	155 *520*	170 *560*	170 *560*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M4	115 *375*	150 *490*	150 *520*	160 *520*	160 *520*	95 *310*	125 *410*	120 *425*	130 *425*	130 *425*	75 *245*	100 *330*	95 *345*	105 *345*	105 *345*
M5	95 *310*	125 *410*	125 *445*	135 *445*	135 *445*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	85 *280*	80 *280*	90 *295*	85 *280*
K1	220 *720*	280 *920*	295 *970*	320 *1050*	320 *1050*	175 *570*	215 *710*	235 *770*	250 *820*	250 *820*	140 *460*	175 *570*	190 *620*	205 *670*	200 *660*
K2	195 *640*	245 *800*	260 *850*	285 *940*	280 *920*	155 *510*	190 *620*	210 *690*	220 *720*	220 *720*	125 *410*	155 *510*	170 *560*	180 *590*	180 *590*
K3	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*
K4	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*	125 *410*	155 *510*	170 *560*	180 *590*	180 *590*	100 *330*	125 *410*	135 *445*	145 *475*	145 *475*
K5	95 *310*	120 *395*	125 *410*	135 *445*	140 *460*	75 *245*	95 *310*	100 *330*	110 *360*	110 *360*	60 *195*	75 *245*	80 *260*	90 *295*	90 *295*
K6	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	135 *445*	150 *490*	160 *520*	155 *510*	90 *295*	110 *360*	120 *395*	130 *425*	125 *410*
K7	120 *395*	150 *490*	165 *540*	175 *570*	175 *570*	95 *310*	120 *395*	130 *425*	140 *460*	140 *460*	80 *260*	95 *310*	105 *345*	115 *375*	115 *375*
N1	1675 *5500*	2125 *6975*	2250 *7375*	2450 *8050*	2450 *8050*	1300 *4275*	1625 *5325*	1725 *5650*	1875 *6150*	1850 *6075*	1050 *3450*	1325 *4350*	1400 *4600*	1525 *5000*	1500 *4925*
N2	680 *2225*	860 *2825*	910 *2975*	990 *3250*	990 *3250*	530 *1750*	660 *2175*	700 *2300*	760 *2500*	750 *2450*	425 *1400*	530 *1750*	570 *1875*	620 *2025*	610 *2000*
N3	450 *1475*	570 *1875*	610 *2000*	660 *2175*	660 *2175*	350 *1150*	435 *1425*	465 *1525*	510 *1675*	500 *1650*	285 *940*	355 *1175*	380 *1250*	410 *1350*	405 *1325*
N11	520 *1700*	650 *2125*	690 *2275*	750 *2450*	760 *2500*	400 *1300*	500 *1650*	530 *1750*	580 *1900*	570 *1875*	325 *1075*	405 *1325*	430 *1400*	470 *1550*	465 *1525*
S1	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	45 *160*	49 *160*	49 *160*
S2	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	35 *115*	46 *150*	45 *155*	49 *160*	49 *160*	29 *95*	37 *120*	36 *130*	40 *130*	39 *130*
S3	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	40 *130*	39 *140*	43 *140*	43 *140*	25 *80*	32 *105*	32 *110*	35 *115*	35 *115*
S11	75 *245*	100 *330*	100 *345*	105 *345*	105 *345*	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
S12	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	35 *115*	44 *145*	44 *150*	48 *155*	48 *155*
S13	31 *100*	39 *130*	39 *140*	42 *140*	42 *140*	25 *80*	32 *105*	31 *110*	34 *110*	34 *110*	20 *65*	26 *85*	25 *90*	28 *90*	28 *90*
H5	45 *150*	55 *180*	60 *195*	65 *215*	65 *215*	36 *120*	46 *150*	48 *155*	50 *165*	50 *165*	30 *100*	37 *120*	39 *130*	41 *135*	41 *135*
H8	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	31 *100*	40 *130*	40 *140*	44 *145*	43 *140*
H11	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	47 *155*	49 *165*	55 *180*	50 *165*
H12	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	80 *260*	80 *260*
H21	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	31 *100*	40 *130*	40 *140*	44 *145*	43 *140*

Torque wrench and Max RPM information

Torque wrench

Recommended RPM for all Seco cutters are shown on each catalogue page.
Normally there is no need for balancing tools for RPM up to 10 000.
However in some cases balancing is necessary,
for instance when using heavy tools and tool holders in small machines

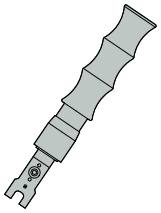
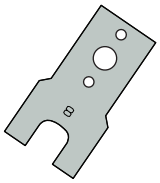
Torque wrench with fixed torque values to ensure the correct tightening force when mounting the Minimaster insert into its holder.
Dynamomentic keys are calibrated according to ISO 6789.
Code key: MM02-4006
MM02 = 2-flute (MM03 = 3-flute)
40 = Torque value 4 Nm
06 = Insert size

Over 10 000 RPM:
We recommend balancing of tool and tool holders at least separately.
Over 20 000 RPM:
Both tool and tool holders must be balanced at least separately.
Over 30 000 RPM:
Tool and tool holders must be balanced as a unit.
The max RPM in the tables should never be exceeded.)

2 flute inserts

Insert size	Torque wrench (including key end)	Replaceable key end	Torque value
MM06	MM02-4006	MM02-06	4 Nm
MM08	MM02-8008	MM02-08	8 Nm
MM10	MM02-1201012	MM02-1012	12 Nm
MM12	MM02-1201012	MM02-1012	12 Nm
MM12 DC= Ø 14,0	MM02-16014	MM02-14	16 Nm
MM12 DCX= Ø 16,0	MM02-1601620	MM02-1620	16 Nm
MM16	MM02-1601620	MM02-1620	16 Nm

3 flute inserts

Insert size	Torque wrench (including key end)	Replaceable key end	Torque value
			
MM06	MM03-4006	MM03-06	4 Nm
MM08	MM03-8008	MM03-08	8 Nm
MM10	MM03-1201012	MM03-1012	12 Nm
MM12	MM03-1201012	MM03-1012	12 Nm
MM16	MM03-16016	MM03-16	16 Nm

SMG – Introduction

The foundation for SMG is a classification of workpiece materials based on their type rather than their relative machinability and consequently it contains workpiece materials like composites. It is comprehensive enough, but still easy to identify which SMG a particular material belongs.
Each SMG has a specific material standard in a specific condition assigned as reference to allow easy adjustment of cutting data for any actual material compared to any Seco reference material see page(s) 676-679.
As example the reference materials EN C45E for SMG P4 and EN 42 CrMo 4 for both SMG P5 and SMG H5 see further details in the following tables.

SMG	Description	Properties	Reference
P4	Low-alloy general structural steels, 0.25% < C < 0.67%wt Low-alloy Quench & Temper steels	520 < R_m < 1200	C 45E R_m = 660 N/mm^2
P5	Structural steels, 0.25% < C < 0.67%wt Quench & Temper steels	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm^2

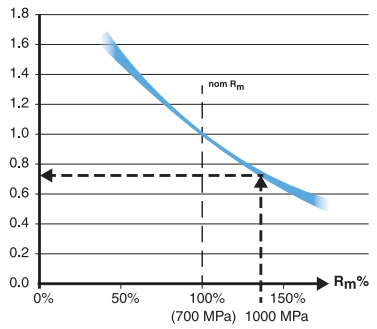
SMG	Description	Properties	Reference
H5	Quenched & Tempered steels	38 < HRC < 56	42 CrMo 4 50 HRC

Focusing specifically on EN 42 CrMo 4 in annealed condition, the ultimate tensile strength R_m may typically vary between Rm = 630 N/mm^2 and R_m = 780 N/mm^2, which provide a reference level for SMG P5. In Quenched & Tempered condition, the ultimate tensile strength R_m may typically be between R_m = 900 N/mm^2 and R_m = 1100 N/mm^2 thus still belongs to SMG P5. However, if hardened above R_m = 1200 N/mm^2 it instead belongs to SMG H5.

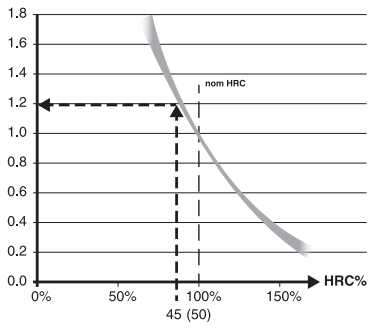
SMG	EN	W.-Nr	AFNOR	BS	UNI	JIS	AISI / ASTM	GOST	Condition	R_{m_nom}	HRC_{nom}
P5	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Annealed	700	
	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Quenched & Tempered	1000	
H5	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Quenched & Tempered		45
	42 CrMo 4	1.1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Quenched & Tempered		50

The EN 42CrMo4 quench & tempered steel could be used to illustrate the machinability dependence of materials' condition.
The graphs below indicate how speed recommendations for a nominal material conditions may be adjusted for relative R_m (left diagram valid for ISO-P) and for relative HRC (valid for ISO-H).

Speed recommendation based in material machining properties, steel



Speed recommendation based in material machining properties, hardened steel



To further illustrate how the SMG P5 nominal v_c can be adjusted to a more accurate recommended v_c we need ultimate tensile strength R_m data and in this case we use the EN 42 CrMo 4 quenched & tempered to R_m = 1000 N/mm^2 according to above table (bold blue arrows).
Assume that we find that the SMG P5 nominal v_c = 280 m/min / *918.64 sfm* for a certain product and machining.
Then, actual recommended v_c = 280 m/min x 0,75 = 210 m/min / v_c = *918.64 sfm x 0.75 = 688.98 sfm.*
Consequently in the SMG H5 the nominal v_c can be adjusted using the hardened EN 42 CrMo 4 at HRC 45 (smaller grey arrows).
Assume that the SMG H5 nominal v_c = 50 m/min / *164.04 sfm* for a certain product and machining using a coated cemented carbide tools then, actual recommended v_c = 50 m/min x 1,2 = 60 m/min / v_c = *164.04 sfm x 1.2 = 196.85 sfm.*
For further workpiece material details please see page(s) 680 - 687 and suggested cutting data at applicable pages.
For more convenient cutting data handling we recommend applicable tools in My Pages – on www.secotools.com
These cutting data compensations for steels are fully implemented at www.secotools.com in MyPages (see QR-code in the upper right corner).

Steels, ferritic and martensitic stainless steels

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
P1	Free-cutting steels	$360 < R_m < 880$	11 SMn30 $R_m = 385$ N/mm^2	1500	0,14
P2	Low-alloy ferritic steels, C < 0.25%wt Low-alloy weldable general structural steels	$320 < R_m < 600$	S235JRG2 $R_m = 420$ N/mm^2	1600	0,23
P3	Ferritic & ferritic/pearlitic steels, C < 0.25%wt Weldable general structural steels Case-hardening steels	$430 < R_m < 610$	16 MnCr 5 $R_m = 550$ N/mm^2	1800	0,14
P4	Low-alloy general structural steels, 0.25% < C < 0.67%wt Low-alloy Quench & Temper steels	$520 < R_m < 1200$	C 45E $R_m = 660$ N/mm^2	2000	0,15
P5	Structural steels, 0.25% < C < 0.67%wt Quench & Temper steels	$550 < R_m < 1200$	42 CrMo 4 $R_m = 700$ N/mm^2	2020	0,18
P6	Low-alloy through-hardening steels, C > 0.67%wt Low-alloy spring and bearing steels	$520 < R_m < 1200$	C 100S $R_m = 600$ N/mm^2	2100	0,17
P7	Through-hardening steels, C > 0.67%wt Spring and bearing steels	$600 < R_m < 1200$	100 Cr 6 $R_m = 650$ N/mm^2	2160	0,17
P8	Tool steels High Speed Steels (HSS)	$600 < R_m < 1200$	X 40 CrMoV 5 1 $R_m = 700$ N/mm^2	2400	0,20
P11	Ferritic & martensitic stainless steels	$415 < R_m < 1200$	X 20 Cr 13 $R_m = 675$ N/mm^2	2000	0,15
P12	Maraging and precipitation-hardening stainless steels	$500 < R_m < 1200$	X 5 CrNiCuNb 16 4 $R_m = 1100$ N/mm^2	2100	0,17

Free-cutting, austenitic and duplex stainless steels

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
M1	Free-cutting austenitic stainless steels		X 10 CrNiS 18 9	1700	0,14
M2	Low-alloy austenitic stainless steels		X 5 CrNi 18 10	1920	0,18
M3	Medium-alloy austenitic stainless steels		X 2 CrNiMo 18 14 3	2070	0,17
M4	High-alloy austenitic and duplex stainless steels		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Difficult high-alloy austenitic and duplex stainless steels		X 2 CrNiMoN 25 7 4	2510	0,13

Cast irons

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
K1	Grey cast irons (GCI)		EN-GJL-250	930	0,32
K2	Compacted graphite irons (CGI)		EN-GJV-400	1000	0,35
K3	Malleable cast irons (MCI)		EN-GJMB-550-4	1050	0,37
K4	Nodular cast irons (SGI)		EN-GJS-500-7	1160	0,37
K5	Austempered ductile irons (ADI)		EN-GJS-1000-5		
K6	Austenitic lamellar cast irons		EN-GJLA-XNiCuCr15-6-2		
K7	Austenitic nodular cast irons		EN-GJSA-XNiMn23-4		

Non-ferrous metals

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
N1	Aluminium alloys, Si < 9%		AW-7075		
N2	Aluminium alloys, 9% < Si < 16%		AC-44200 Si = 12%		
N3	Aluminium alloys, Si >16%		AlSi17Cu5		
N11	Copper alloys		CW614N	740	0,26

Superalloys and titanium

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
S1	Iron-based superalloys		Discalloy		
S2	Cobalt-based superalloys		Stellite 21		
S3	Nickel-based superalloys		Inconel 718	2530	0,21
S11	Titanium, low alloyed, (α)		Ti		
S12	Titanium, medium alloyed, (α+β)		TiAl6V4	1500	0,24
S13	Titanium, high alloyed, (near β and β)		Ti10V2Fe3Al		

Hard materials

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
H3	Case-hardened steels	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Quenched & Tempered steels	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Quenched & Tempered steels Bearing steels	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Tool steels High Speed Steels (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Martensitic stainless steels	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Maraged and precipitation-hardened stainless steels	1200 < R_m < 1650	X 5 CrNiCuNb 16 4 R_m = 1450 N/mm^2	2410	0,17
H21	Manganese steels	23 < HRC < 64	X 120 Mn 12 50 HRC		
H31	White cast irons	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC		

Other difficult materials

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
PM1	Low-alloy PM-materials		F-0008 Fe-0.7C		
PM2	Medium-alloy PM-materials		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C		
PM3	High-alloy PM-materials Exhaust valve seat materials, etc.				
HF1	Hardfacing alloys Welded or plasma-deposited iron-based alloys				
HF2	Hardfacing alloys Welded or plasma-deposited cobalt- and nickel-based alloys				
CC1	Sintered tungsten carbide		G50		

Plastics and Composites

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
TS1	Thermosetting polymers		Urea formaldehyde (UF)		
TS2	Thermosetting carbon-fibre composites		T300 T700 T800 HTA-S IMA - Epoxy (M21)...		
TS3	Thermosetting glass-fibre composites		Epoxy - HX..(42..)/E glass (7781...)...		
TS4	Thermosetting aramide-fibre composites		Kevlar 49		
TP1	Thermoplastic polymers		Polycarbonate (PC)		
TP2	Thermoplastic carbon-fibre composites		PPS/PEEK - T300..		
TP3	Thermoplastic glass-fibre composites		PPS/PEEK - E-glass or A-glass...		
TP4	Thermoplastic aramide-fibre composites				

Graphite

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
GR1	Graphite		R 8500		

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20			
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20			
P1	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922	
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311	
	S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313	
	S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414	
	C 10	1.0301	1.0301	C 10	34 C 10, XC 10	045 M 10	C 10	S 10 C		G10100
P2			1.0401	C 15	37 C 12, XC 18	080 M 15	C 15, C 16		1350	G10170
	C22	1.0402	1.0402	C 22	C 20	050 A 20	C 20, C 21		1450	G10200
	S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132	
	C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
P3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5						
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)		G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H		
	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
			1.7337	16 CrMo 4 4	15 CD 4.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
	10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218	J21890
	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C		
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655	
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600
P4			1.1157	40 Mn 4	35 M 5	150 M 36				G10390
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300
	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640
			1.1740	C 60 W	Y3 55			SK 7		
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
P5	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCR 430 (H)		G51320
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCR 440 (H)		G51400
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
			1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240	
	50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500
	41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065
	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
P6	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.1645	C 105 W2	Y1 105		C 100 KU	SK 3		
			1.1663	C 125 W	Y2 120		C 120 KU	SK 2		

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
	1213				Annealed	
	12 L 13				Annealed	
	1108				Annealed	
	11 L 08				Annealed	
					Annealed	
	1140	40			Annealed	
	1146				Annealed	
	1215				Annealed	
	12 L 14				Annealed	
		16D			Annealed	
	A573 Grade 58	18kp	11 378		Annealed	
	A573 Grade 70	St14kP	11 448		Annealed	
	1010	10			Annealed	
F.1110	1015	15			Annealed	
	1020, 1023	20	12 024		Annealed	
		17G1S	11 523		Annealed	
F.1511	1015	15			Annealed	
F.1120	1025	25			Annealed	
					Annealed	
	A204 Grade A		15 020		Annealed	
	4520				Annealed	
	3310, 9314	20X2H4A	16 420		Annealed	
	4320		16 220		Annealed	
					Annealed	
F.1516	5115	12KHN2	14 220		Annealed	
		18HG			Annealed	
	5120	20KH	14 221		Annealed	
	5120 H	20KH			Annealed	
	A182-F11, A182-F12	12KHM	15 121		Annealed	
	A387 Grade 12 Cl. 2				Annealed	
F.155	A182-F22	12KH8	15 313		Annealed	
F.1130	1035	35	12 040		Annealed	
F.5110	1045	45	12 050		Annealed	
	1040	40	12 041		Annealed	
F.1150	1055	55			Annealed	
	1060	60	12 061		Annealed	
	1039	40G			Annealed	
	1330	30G2			Annealed	
F.1135	1035	35			Annealed	
F.1140	1045	45	12 050		Annealed	
F.1150	1064	60			Annealed	
	1060	60			Annealed	
F.144	9255	55S2			Annealed	
F.1250	4135	35KHM			Annealed	
F.5241	S1	5KHV2S			Annealed	
	L6	5KHNV			Annealed	
	5045				Annealed	
	3135				Quenched & Tempered	
	3435				Annealed	
	9840				Quenched & Tempered	
F.1280	4340	38H2N2MA	16 343		Annealed	
	5132	35KH			Quenched & Tempered	
	5140	40H	14 140		Quenched & Tempered	
F.1251	4130	20KHM	15 130		Quenched & Tempered	
F.1252	4142, 4140	38HM	15 142		Annealed	
F.1252	4142, 4140	38HM	15 142		Quenched & Tempered	
					Quenched & Tempered	
F.143	6150	50KHFA	15 260		Quenched & Tempered	
F.1740	A355 Cl. A				Annealed	
F.5103	1070	70			Annealed	
F.5117	1095				Annealed	
F.5118	W1	U10A			Annealed	
		U10			Annealed	
	W1	U13			Annealed	

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3		T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51	2722	T11302
	HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWV 09-04-02-02		HS 2-9-2	SKH 58	2782	T11307
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
	X 3 CrNIMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5	2385	S41500
	X 18 CrN 28	1.4749	1.4749	X 18 CrN 28	Z 18 C 25				2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300
M2	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200
M3	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700
	X 9 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 21 11 2		310 S 31			2368	S30815
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
F.520L	L2	11KHF			Annealed	
F.5220	O1	9KHVG			Annealed	
	O2	9G2F			Annealed	
F.5230	52100	SHKH15	14 109		Annealed	
F.5212	D3	KH12			Annealed	
	H11	4KH5MFS			Annealed	
F.5318	H13	4KH5MF1S			Annealed	
F.5227	A2	9KH5VF			Annealed	
	H10	3KH3M3F			Annealed	
F.5213		KH12			Annealed	
		KH12MF			Annealed	
F.520.S	L6	5KHNM			Annealed	
F.5613	M35	R6M5K5			Annealed	
	M42	R2AM9K5			Annealed	
	T4	R18K5F2			Annealed	
F.5603	M2	R6M5			Annealed	
	M7				Annealed	
	T1	R18			Annealed	
	403	08KH13			Annealed	Ferritic
F.3401	410, CA-15	12KH13, 08KH13			Annealed	Martensitic
F.3113	430	12KH17			Annealed	Ferritic
F.5261	420	20KH13	17 022		Annealed	Martensitic
F.3404	420	40KH13			Annealed	Martensitic
	440 A				Annealed	Martensitic
	440 B	95KH18			Annealed	Martensitic
	440 C	95KH18			Annealed	Martensitic
	A182 F6NM			F6NM	Annealed	Martensitic
	446	15KH28			Annealed	Ferritic
	XM-13			PH 13-8 Mo	Solution annealed	Austenitic
	XM-12			15-5 PH	H1150	Martensitic
	XM-12			15-5 PH	Solution annealed	Martensitic
	XM-12			15-5 PH	H1025	Martensitic
	SAE 630			17-4 PH	H1150	Martensitic
	630			17-4 PH	Solution annealed	Martensitic
	631	09KH17N7YU1		17-7 PH	Solution annealed	Austenitic/Ferritic
	AMS 6515			Marage 350	Solution annealed	Martensitic
	AMS 6521			Marage 300	Solution annealed	Martensitic
	AMS 6514			Marage 300, Vascomax C300	Solution annealed	Martensitic
	AMS 6512			Marage 250	Solution annealed	Martensitic
	AMS 6512			Marage 250, Vascomax C250	Solution annealed	Martensitic
F.3508	303	12KH19N9			Annealed	Austenitic
F.3504	304 L	03KH18N11			Annealed	Austenitic
F.3504	304	08KH18N10	17 240		Annealed	Austenitic
F.3534	316	08KH17H13M2T	17 346		Annealed	Austenitic
F.3524	347	08KH18N12B			Annealed	Austenitic
F.3517	301	07KH16N6			Annealed	Austenitic
	302	12KH18N9			Annealed	Austenitic
F.3533	(316 L)	03KH17N14M3	17 349		Annealed	Austenitic
	316 LN	03KH16N15M3			Annealed	Austenitic
F.3541	304 LN	03KH18N11			Annealed	Austenitic
	317	08KH17H15M3T			Annealed	Austenitic
				253 MA	Annealed	Austenitic
	310 S	12KH25N20			Annealed	Austenitic
	329 LN			SAF 2205	Annealed	Duplex
				3RE60	Annealed	Duplex
	904L				Annealed	Super austenitic
	329				Annealed	Duplex
	660			A286	Solution annealed	Austenitic
				254 SMO	Annealed	Super austenitic
				654 SMO	Annealed	Super austenitic
				Alloy 800	Annealed	Austenitic
	F 53			SAF 2507	Annealed	Super duplex

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
K1	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
K2	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
	EN-GJV-400			GJV-400						
	EN-GJV-450			GJV-450						
	EN-GJV-500			GJV-500						
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130
K4	EN-GJS-350-22	0.7033	0.7033	GGG-35.3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15	
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800
	EN-GJS-400-18	0.7043	0.7043	GGG-40.3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800
K5										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000
K7	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00	
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000
	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006
N1	AW-1050A	Al99.5	3.0255	Al99.5	A-5/1050A	1B		(A1050)	4007	AA1050A
	AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355	AA2011
	AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338	AA2014
	AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106	AA5005
	AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103	AA6060
	AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107	AA6005
	AW-3103	AlMn1	3.0515	AlMn1		N3			4054	AA3103
	AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003		AA3003
	AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425	AA7020
	AW-7075		3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96		A7075		AA7075
	AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599	AC 4C	4244	
	AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3					4251	A13800
	MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121				M11600
	MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)					
	MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE				M12330
N2	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
N11	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600
				CuNi10Zn45						
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1					C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700
			2.1087	CuSn10Zn					5458	C90500
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
	A48 25 B	Sc 15	422 415			Grey cast iron (GCI)
	A48 30 B	Sc 20	422 420			Grey cast iron (GCI)
	A48 35 B	Sc 25	422 425			Grey cast iron (GCI)
	A48 50 B	Sc 35				Grey cast iron (GCI)
	G 3500					Grey cast iron (GCI)
	Grade 350					Compacted graphite iron (CGI)
	Grade 400					Compacted graphite iron (CGI)
	Grade 400-15					Compacted graphite iron (CGI)
	Grade 450					Compacted graphite iron (CGI)
	Grade 500					Compacted graphite iron (CGI)
	A220 60004				Tempered	Malleable cast iron (MCI)
						Nodular cast iron (SGI)
FGE 38-17	60-40-18	Vc 42-12	422 304			Nodular cast iron (SGI)
	60-40-18	Vc 42-12				Nodular cast iron (SGI)
FGE 50-7	A536, 80-55-06	Vc 50-2	422 305			Nodular cast iron (SGI)
FGE 60-2	A476, 80-60-03	Vc 60-2	422 306			Nodular cast iron (SGI)
FGE 70-2	A536, 100-70-03	Vc 70-2				Nodular cast iron (SGI)
	1600/1300/-					Austempered ductile iron (ADI)
	1050/700/7					Austempered ductile iron (ADI)
	1200/850/4					Austempered ductile iron (ADI)
	1400/1100/1					Austempered ductile iron (ADI)
	850/550/10					Austempered ductile iron (ADI)
	A436 Type 2			Ni-Resist 2		Austenitic lamellar cast iron
	A436 Type 3			Ni-Resist 3		Austenitic lamellar cast iron
	A436 Type 1			Ni-Resist 1		Austenitic lamellar cast iron
				Nodumag		Austenitic nodular cast iron
	A436 Type D-2			Ni-Resist D-2		Austenitic nodular cast iron
	A439 Type D-2M			Ni-Resist D-2M		Austenitic nodular cast iron
	A436 Type D-3			Ni-Resist D-3		Austenitic nodular cast iron
	A439 Type D-5			Ni-Resist D-5		Austenitic nodular cast iron
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3									N07500
	NiCr20Co13Mo4Ti3Al		2.4654							N07001
S11			3.7024							
										R54620
S12										R56320
	TiAl6V4		3.7164							R56400
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183	
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
				Discalloy	Precipitation hardened	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel X-750	Solution annealed	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	Commercially pure	Ti (α)
	AMS 4919			Ti 6-2-4-2	Annealed	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	Annealed	Ti (α+β)
	AMS 4920, Grade 5	VT6		Ti 6Al-4V	Annealed	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	Annealed	Ti (β)
F.1516	5115	12KHN2	14 220		Case hardened	
F.5103	1070	70			Quenched & Tempered	
F.5107	1078, 1080	75			Quenched & Tempered	
F.5117	1095				Quenched & Tempered	
F.5118	W1	U10A			Quenched & Tempered	
	S1	5KHV2SF			Quenched & Tempered	
	5155				Quenched & Tempered	
F.1252	4142, 4140	38HM	15 142		Quenched & Tempered	
F.520L	L2	11KHF			Quenched & Tempered	
F.5220	O1	9KHVG			Quenched & Tempered	
	O2	9G2F			Quenched & Tempered	
F.5230	52100	SHKH15	14 109		Quenched & Tempered	
F.5318	H13	4KH5MF1S			Quenched & Tempered	
F.5227	A2	9KH5VF			Quenched & Tempered	
F.5211	D2	KH12MF			Quenched & Tempered	
F.5213		KH12			Quenched & Tempered	
		KH12MF			Quenched & Tempered	
F.520.S	L6	5KHNM			Quenched & Tempered	
F.5613	M35	R6M5K5			Quenched & Tempered	
	M42	R2AM9K5			Quenched & Tempered	
	T1	R18			Quenched & Tempered	
F.5261	420	20KH13	17 022		Quenched & Tempered	Martensitic
	440 A				Quenched & Tempered	Martensitic
	440 B	95KH18			Quenched & Tempered	Martensitic
	440 C	95KH18			Quenched & Tempered	Martensitic
	XM-12			15-5 PH	H900	Martensitic
	SAE 630			17-4 PH	H1025	Martensitic
	SAE 630			17-4 PH	H900	Martensitic
	AMS 5528	09KH17N7YU1		17-7 PH	TH1050	Martensitic
	632			PH 15-7 Mo	TH1050	Martensitic
	660			A286	Precipitation hardened	Austenitic
	AMS 6512			Marage 250	Precipitation hardened	Martensitic
	AMS 6521			Marage 300	Precipitation hardened	Martensitic
	AMS 6521			Marage 300	Precipitation hardened	Martensitic
	AMS 6515			Marage 350	Precipitation hardened	Martensitic
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC			Ni-Hard 2		White cast iron
	A532 IA (NiCr-HC)			Ni-Hard 1		White cast iron
	A532 ID (Ni-HiCr)			Ni-Hard 4		White cast iron

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