CATALOG & TECHNICAL GUIDE 2020.2

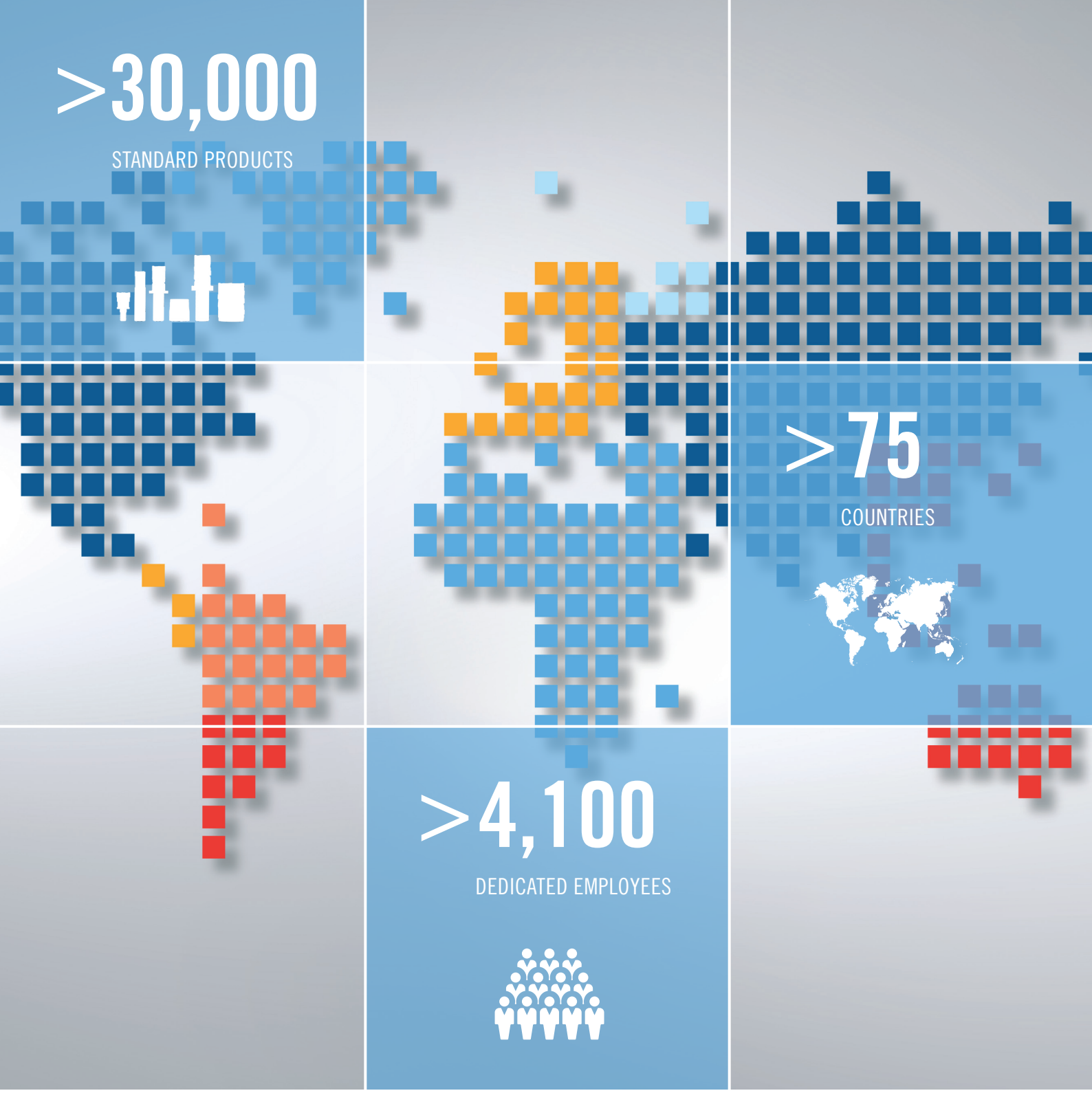
SOLID END MILLS

SECO

AHB TOOLING & MACHINERY

COMPLETE METALWORKING SOLUTIONS

(800) 991-4225
www.ahbinc.com
ISO Certified
customerservice@ahbinc.com



Headquartered in Fagersta, Sweden and present in more than 75 countries, Seco Tools is a leading global provider of metal cutting solutions for milling, stationary tools, holemaking and tooling systems.

For more than 80 years, the company has provided the technologies, processes and support that manufacturers depend on for maximum productivity and profitability. For more information on how Seco's innovative products and expert services bring success to manufacturers across all industry segments, please visit www.secotools.com.

WELCOME TO SECO SOLID MILLING

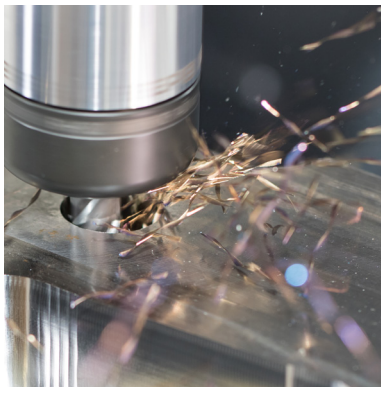
JABRO was founded in 1976 in Lottum, Netherlands.
JABRO is Seco's competence centre for solid milling solutions, and has the global responsibility for Research & Development, Manufacturing and Application Engineering.

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)

NIAGARA CUTTER™ SOLID MILLING SOLUTIONS AVAILABLE THROUGHOUT NORTH AMERICA



SECO OFFERS EVEN MORE WITH NIAGARA CUTTER

Extended offering of solid carbide end mills from Niagara Cutter, a wholly owned subsidiary of Seco Tools, available to North American customers. Everything from aerospace to general engineering is covered in the 4,000-product selection of high performance and general purpose solid milling solutions.

High performance roughing products such as the Stabilizer™ 2.0 and Multi Flute families for optimized roughing raise the bar in performance. Couple these products with the general-purpose C-Series, a full range of 2, 3, and 4 flute square end and ball nose products, to achieve a blend of performance and value fine-tuned to your unique challenges.

SOLID SOLUTIONS FOR ALL YOUR MACHINING CHALLENGES

Thrive in all types of workpiece materials and cutting parameters, with our comprehensive selection of solid carbide, cobalt, and diamond-coated end mills as well as solid carbide multi purpose thread milling solutions.

For more information about all the products offered, please reference the Niagara Cutter catalog available at Secotools.com/NiagaraCutter or search for specific tooling details via the site search. You can also download our Solid Milling app to access all your cutting data needs, available on the Google Play and Apple App stores.

END MILL FAMILY HIGHLIGHTS

HIGH PERFORMANCE STABILIZER™ AND STABILIZER 2.0 SERIES

The Stabilizer 2.0 family of end mills raises the bar in high performance milling by incorporating a patented continuously varying asymmetrical geometry which helps create a smooth chatter free milling condition. This configuration, along with a specially engineered flute shape, allow for feed rates twice that of the previous Stabilizer.

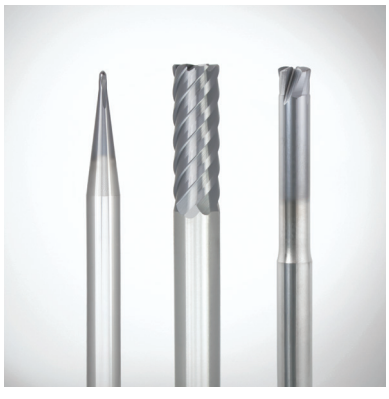
Simplify tool selection and part programming with the newly expanded ST540 family of 5-flute end mills from Niagara Cutter™. Gain part processing versatility with the ability to handle slot milling, side mill roughing, side mill finishing, and face milling applications as well as in traditional and high performance optimized roughing, pocketing, and ramping in all major material families – all with a single product family.

ELITE A & S SERIES

Our Elite series of end mills feature specific geometries for ferrous or non ferrous materials, available in 0.125 - 1.25” diameters.

The S638, S738, and S938 Multi flute end mills are designed for optimized and peripheral roughing and finishing applications in stainless steel, titanium, and high temperature alloys.

The A series is designed for aluminum and non ferrous materials and is available with two or three flutes in a variety of configurations. The S series provides high performance machining in steel, stainless steel, and high temperature alloys with three, four, five, six, seven, and nine flutes.



HIGH FEED & MOLD & DIE

The mold & die range offers geometries for hard milling of steels up to 65Rc.

The SN200R, SN400R, and SN500R cover a broad range of applications and materials. These end mills direct radial cutting pressure up into spindle for increased metal removal rates in deep pockets and long reach applications.

The MZN and MBZ family of end mills are designed to maximize productivity in hardened steels and superalloys. These end mills feature optimized substrate, geometry, and coating to offer superior performance and process reliability.

GENERAL PURPOSE C SERIES

The C series end mills with two, three, or four flutes are available in square, corner radius or ball end, uncoated or with TiAlN as standard. This broad range of end mills is typical for job shop environments where one tool can handle a variety of applications.

For more information about the C series end mills or other end mills, refer to the Solid Milling app, available for download.

General

Universal

Steel and cast iron

Stainless steel and S-materials (HRSA and Titanium alloys)

Non-ferrous

Hardened steels

Plastic and CFRPs

Graphite

Technical information

Minimaster® Plus

Minimaster®

SMG

SOLID²

TORNADO

HPM

HFM

MINI

DIAMOND

COMPOSITE

VHM

CERAMIC

HSS-E

MINIMASTER

MINIMASTER PLUS

MINIMASTER

MINIMASTER PLUS

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 11 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 11 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 12 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 12 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 12 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 12 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 12 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 13 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 13 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 13 for a grouped overview of HSS-CO 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 - Composites	Composite machining	JC, JPD						■	
Jabro - VHM	General machining	J		■					■
Jabro-HSS-E	General machining	JCO					■		
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 618									

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
	34	JS²	JS512	●	○	●	○	●	○	○	○	○	●	○	○			○				○
	41		JS513	●	○	●	○	●	○	○	○	○	●	○	○			○				○
	49		JS514	●	○	○	○	●	○	○	○	○	●	○	○			○				○
	56		JS553	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	72		JS554	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	302		JS412						●	●					●			●				
	305		JS413						●	●					●			●				
	308		JS452						●	●					●			●				
	313		JS453						●	●					●			●				
	104		JS520	●	○	○	○	●	●	●	●	○	●	○	●			●				○
	108		JS522	●	●	●	●	●	●	●	●	○	●		●			●				○
	111		JS532	●	○	●	●	●	●	●	●	○	●		●			●				○
	115		JS533	●	○	●	●	●	●	●	●	○	●		●			●				○
	119		JS534	●	○	●	●	●	●	●	●	○	●		●			●				○
	123		JS506	●	○	●	●	●	●	●	●	○	●	●	●			●				○
	127		JS509	●	○	●	●	●	●	●	●	○	●	●	●			●				○
	96		JS564	●	○	●	●	●	●	●	●	●	●	●								
	100		JS565	●	○	●	●	●	●	●	●	●	●	●								
	241		JS720			●	●						●									
	251		JS730			●	●						●									
	213		JS754		○	●	●					●	●									
	230		JS755		○	●	●					●	●									
	320	HSM/TORNADO	JH40						●		●				●							
	201, 360		JH112					●						●								
	350		JH120											●								
	352		JH130											●								
	196, 357		JH142	●	●			●						●								
	362		JH150					●						●								
	365		JH160	●	○									●								
	329		JH410						●		●				●							
	325		JH421						●		●				●			●				
	331		JH440						●	●	●				●			●				
	333		JH450						●	●	●				●			●				
	335		JH460						●		●		●		●			●				
	280		JH710									●	●									
	300		JH720			●	●		●	●	●	○	●		●			●				
	292		JH721									●	●									
	294		JH722									●	●									
	284		JH730									●	●									
	278		JH740									●	●									
	276		JH770									●	●									
	288		JH780									●	●									
	282		JH790									●	●									
	131		JH910	●	○	●	●	●				●	●					●				●
	135, 354		JH930	●	○			●				●	●	●								
	137, 199		JH970	●	○	●	●					●	●									

● 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
	344	HPM	JHP170											●								
	255		JHP750									●	●									
	258		JHP760			●	●															
	262		JHP770										●									
	269		JHP780									●										
	318		JHP490						●	●												
	194		JHP951	●	○			●														
	186		JHP993	●	○			●														
	286		JHP994									●	●									
	347	HFM	JHF181	○	○			●				●	●	●								
	141		JHF980	●	○	●	●	●				●	●	○								
	374	MINI	JMB112											●								
	367		JME142											●								
	372		JME144											●								
	337		JM403/404/406						●	●												
	339		JM413/416						●	●	●				●		●					
	171		JMB542	●	●	●	●		○	○	○		●	○								○
	177		JMB562	●	●	●	●		○	○	○		●	○								○
	181		JMB563	●	●	●	●		○	○	○		●	○								○
	164		JME542	●	●	●	●		○	○	○		●	○								○
	167		JME562	●	●	●	●		○	○	○		●	○								○
	174		JME564	●	●	●	●		○	○	○		●	○								○
	444	MINI DIAMOND	JMB642																			●
	444		JMB662																			●
	442		JME642																			●
	434	DIAMOND	JD620																			●
	436		JD630																			●
	438		JD640																			●
	440		JD660																			●
	382	COMPOSITE	JC845													●		●				
	384		JC850													●		●				
	386		JC860													●		●			●	
	388		JC870													●		●			●	
	394		JC871													●		●			●	
	400		JC875													●		●				
	404		JC876													●		●				
	408		JC877													●		●				
	412		JC880													●		●				
	414		JC885													●		●				
	416		JC898																●	●		
	418		JC899																●	●		
	421	PCD	JPD850													●		●				
	423		JPD880													●		●				
	425		JPD890													●		●				

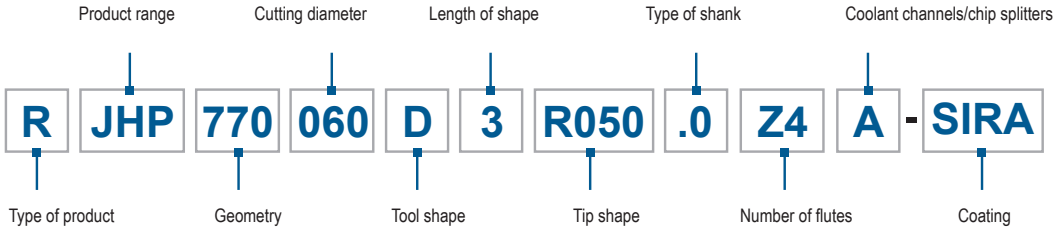
● Preferred choice, ○ Alternative choice

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
	428	VHM	J28												●							
	146		J36	○	●	○	○	○	○	●	●	○	○		○			○				
	149		HK/HKM	●		●	●	●	●	○		●	●		●			●				
	161		V31	●	○	●	○	●	●	●		●	●		●			●				●
	143		J29	●	●	●	●	●	●	●	●	●	●	○	●			●				●
	427		J93F												●			●				
	274	Ceramic	JCG790									●										
	296	HSS-Co	JCO710			●	●						●									

● Preferred choice, ○ Alternative choice

Code key



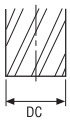
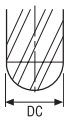
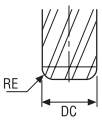
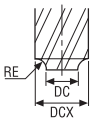
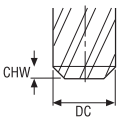
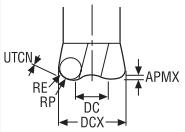
Product range	Type of product
J = JABRO® VHM JC = JABRO® Composites JD = JABRO® Diamond JH = JABRO® HSM/Tornado JHF = JABRO® HFM JHP = JABRO® HPM JM = JABRO® Mini JS = JABRO® SOLID² JPD = JABRO® PCD JCO = JABRO® HSS-Co JCG = JABRO® Ceramic	BLANK = Standard (catalogue) product R = Reconditioned product (complete) RK = Reconditioned product (frontal)

Length of shape	Number of flutes
A single digit that gives an indication of the length of the cutter compared to other products with the same cutting geometry. This replaces the previous L, XL, SL, K, and other versions. For most products 1=K, 2=N, 3=L, 4=XL	This figure indicates the number of flutes in the cutter. For example; PCEDC2= 2 flutes, PCEDC6 = 6 flutes

Cutting diameter	Coolant channels/chip splitters
Metric = 3 digit code (in case of 4 digit code – xx,xx mm) Imperial = a dot followed by a 3 digit code For example: (050 = metric, 5 mm) / (.500 = imperial, ½ *inch*)	BLANK = No coolant channels A = Internal coolant channel(s) C = Chip splitters

Geometry	Type of shank
Geometry A three-digit combination specifying the cutting geometry. For example; 111, 950, 553, 514, etc.	Indicates the shank types that are available. .0 = Cylindrical .3 = Weldon .5 = Whistle Notch .9 = Safe-Lock

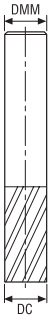
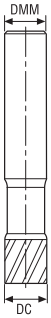
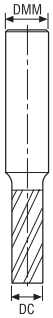
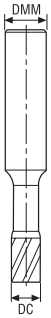
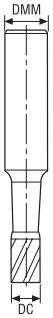
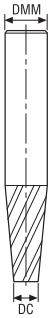
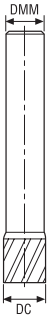
Description

Tip shape						Coating
Sharp	Ball-nose	Corner radius	Concave radius	Chamfer	High feed	4 character code specifying the coating on the cutter.
						MEGA = MEGA MT = MEGA-T M64 = MEGA-64 M64T = MEGA-64-T TRI = TRIBON SIRA = SIRON-A HEMI = HEMI DIA = DIAMOND DURA = DURA NXT = NXT HXT = HXT STAX = STAX
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*).

Tool shape						
(DC = DMM)		(DC < DMM)				(DC > DMM)
						
D	E	F	G	J	N	P

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

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.

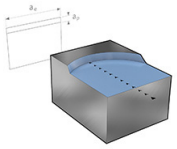
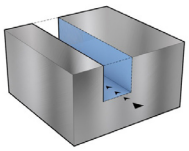
However good a tool is, as part of its function, it will eventually show signs of wear on the cutting edge. Controlling this wear and the timely replacement of the tool will allow the used tool to be reconditioned, thus reducing tool investment costs. And we use the same advanced technology to recondition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

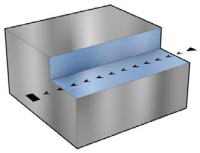
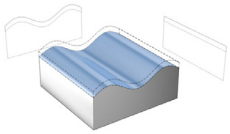
Reconditioning cuts cost and tools inventory

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:

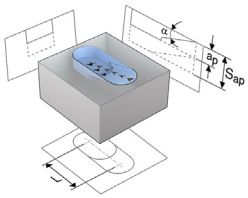
Face milling:	Slot milling:
Operation where the tool is in engagement with less than 180° arc of contact. Tool engagement: Small a_p and large a_e. 	Operation where the full diameter is in engagement, a_e is equal to DC and a_p up to 2 times DC depending on the machining strategy in use. 

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:

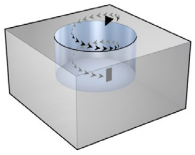
Ramping:

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



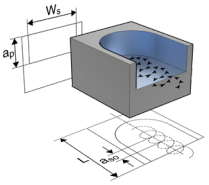
Helical interpolation ramping:

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



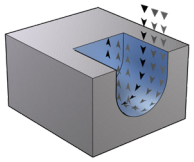
Trochoidal:

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



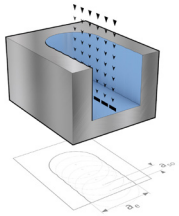
Push-pull:

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



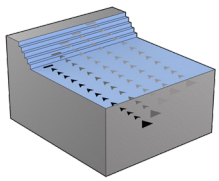
Plunge milling:

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



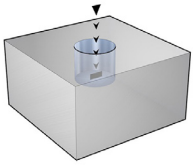
Z-leveling:

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



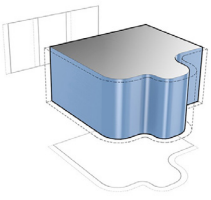
Drilling:

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.

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 274.

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 416 - 418.

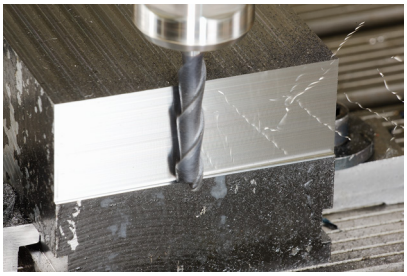
Take the risk out of micro milling operations

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 12.

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 108.

Explanation of Advanced Roughing

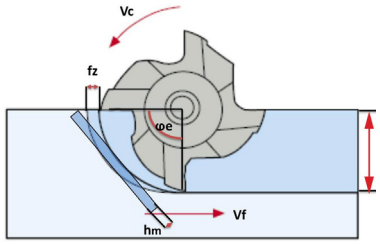
Advanced Roughing, what does it mean?

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.

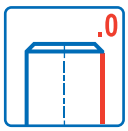
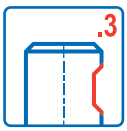
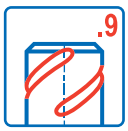
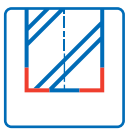
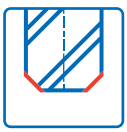
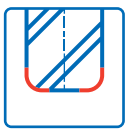
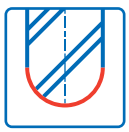
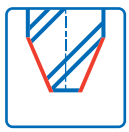
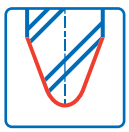
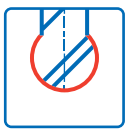
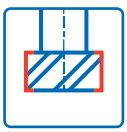
In advanced roughing, to maintain arc of contact, CAM packages need to employ trochoidal machining-like techniques when entering a radius.

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, JS574, JS575 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.

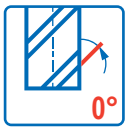
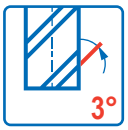
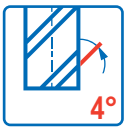
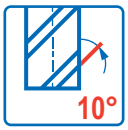
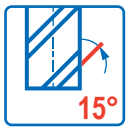
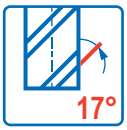
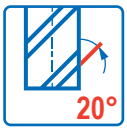
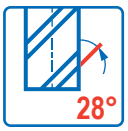
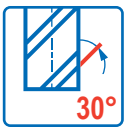
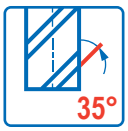
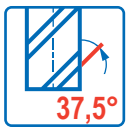
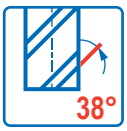
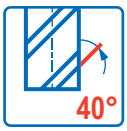
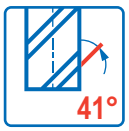
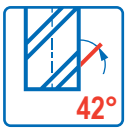
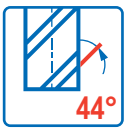
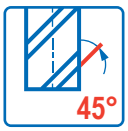
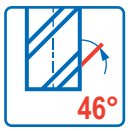
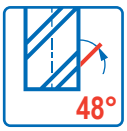
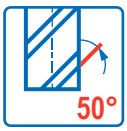
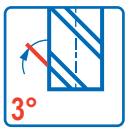
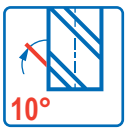
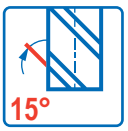
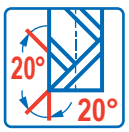
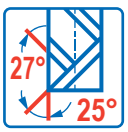
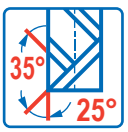
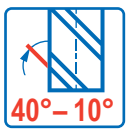
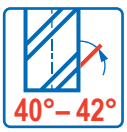
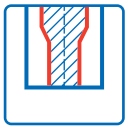
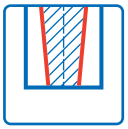
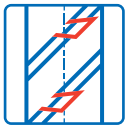
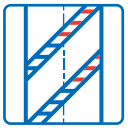
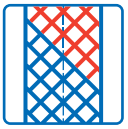
Impact of arc of contact on cutting speed and feed per tooth



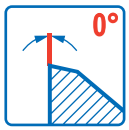
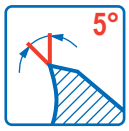
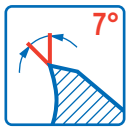
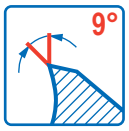
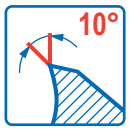
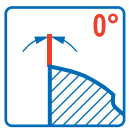
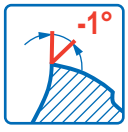
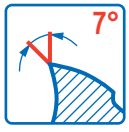
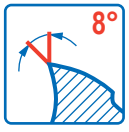
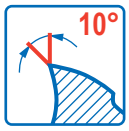
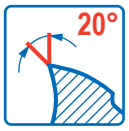
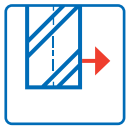
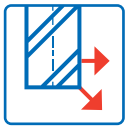
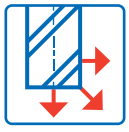
Key symbols

 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	 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
 250° Cutter	 T-shape				

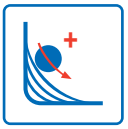
Key symbols

 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 helix 20° - 20°	 Double helix 27° - 25°	 Double helix 35° - 25°	 Double helix 34° - 36°	 Left hand helix 40° - 10°	 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 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		
 ICC straight	 ICC and Y					
 Radial	 Radial/Ramping	 Radial/Ramping/Plunging				

Key symbols

DIAMOND Diamond	DURA Dura	HEMI Hemi	HSCO HSS-Co	HXT HXT
MEGA Mega	MEGA-T Mega-T	MEGA-64 Mega-64	MEGA-64-T Mega-64-T	NXT NXT
STAX Stax	SIRON-A Siron-A	TRIBON Tribon	CERAMIC Ceramic	PCD PCD
RECONDITIONING *Regrind possible*	 *Advanced roughing*			

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.

- JS512, JS513, JS514, JS553, JS554, JS564, JS565 and JS520 with 45° chamfer type.
- JS522, JS553, JS554, JH910, JH930, JHF980, J36, JME542, JME562 and JME564 for radius type.
- JS506, JS509, J29 and V31 with V-type.
- JS532, JS533, JS534, JH970, JMB542, JMB562 and JMB563 for ball-nose type.

Tool selection Universal

						
Name		JS512	JS513	JS514	JS553	JS554
Page(s)		34	41	49	56	72
Family name		JS²	JS²	JS²	JS²	JS²
Type of mill						
Shank	Cylindrical	■	■	■	■	■
	Weldon	□	□	□	■	■
Number of Flutes		2	3	4	3	4
ICC						
Diameter range	Metric	1-25	1-25	1-25	2-25	3-25
	Inch				1/8 - 1/2	1/4-1
Length availability						
		2,3,4	2,3,4	2,3,4	2,3	2,3
Operation						
						
						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	●	●
M1-3		●	●	○	●	●
M4-5		○	○	○	●	●
K1-7		●	●	●	●	●
S1-3		○	○	○	●	●
S11-13		●	●	●	●	●
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.

Tool selection Universal

						
Name		JS564	JS565	JS520	JS522	JS532
Page(s)		96	100	104	108	111
Family name		JS²	JS²	JS²	JS²	JS²
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	1-20
	Inch					
Length availability						
		2,3	2,3	2,3	4	1,2,3
Operation						
						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	●	○
M1-3		●	●	○	●	●
M4-5		●	●	○	●	●
K1-7		●	●	●	●	●
S1-3		●	●	○	○	○
S11-13		●	●	●	●	●
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 Universal

					
Name		JS533	JS534	JS506	JS509
Page(s)		115	119	123	127
Family name		JS²	JS²	JS²	JS²
Type of mill					
Shank	Cylindrical	■	■	■	■
	Weldon	□	□	■	■
Number of Flutes		3	4	3-4	3-4
ICC					
Diameter range	Metric	1-20	2-20	3-12	3-12
	Inch				
Length availability					
		1,2	1,2,3	2	2
Operation					
					
SMG					
P1-8		●	●	●	●
P11-12		○	○	○	○
M1-3		●	●	●	●
M4-5		●	●	●	●
K1-7		●	●	●	●
S1-3		○	○	○	○
S11-13		●	●	●	●
H5 H8 H11 H12 H21				●	●
N1		●	●	●	●
N2-3		●	●	●	●
N11		●	●	●	●
TS1		●	●	●	●
TP1		●	●	●	●
GR		○	○	○	○

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

Tool selection Universal

					
Name		JH910	JH930	JH970	JHF980
Page(s)		131	135, 354	137, 199	141
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	2-17	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 H7 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 Universal

					
Name		J29	J36	HK/HKM	V31
Page(s)		143	146	149	161
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		●	○	●	●
H5 H8 H11 H12 H21		○		●	●
N1		●	○	●	●
N2-3		●	●	○	●
N11		●	●		
TS1		●	○	●	●
TP1		●	○	●	●
GR		●			●

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

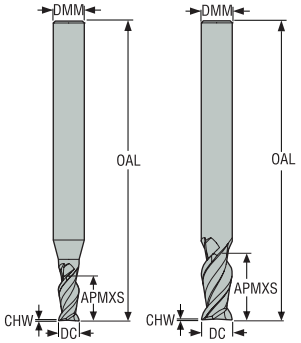
Tool selection Universal

							
Name		JME542	JME562	JME564	JMB542	JMB562	JMB563
Page(s)		164	167	174	171	177	181
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	0,2-3,0	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	2,4,5,6,7	2,4
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		○	○	○	○	○	○

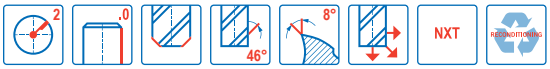
■ Stock standard ☐ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

JS512

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



- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible if DC is ≥Ø6

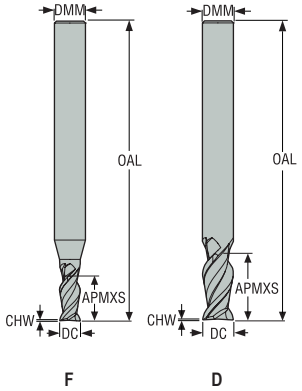


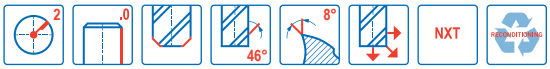
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS512010F2C.0Z2-NXT	02927161	2	F	1,0	3	2,0	38	0,01	2	■
JS512015F2C.0Z2-NXT	02927163	2	F	1,5	3	3,0	38	0,015	2	■
JS512021F2C.0Z2-NXT	02927165	2	F	2,0	3	4,0	38	0,02	2	■
JS512020F2C.0Z2-NXT	02927164	2	F	2,0	6	4,0	57	0,02	2	■
JS512030D2C.0Z2-NXT	02927167	2	D	3,0	3	6,0	38	0,03	2	■
JS512030F2C.0Z2-NXT	02927166	2	F	3,0	6	6,0	57	0,03	2	■
JS512040D2C.0Z2-NXT	02927169	2	D	4,0	4	8,0	50	0,04	2	■
JS512040F2C.0Z2-NXT	02927168	2	F	4,0	6	8,0	57	0,04	2	■
JS512050D2C.0Z2-NXT	02927171	2	D	5,0	5	10,0	50	0,05	2	■
JS512050F2C.0Z2-NXT	02927170	2	F	5,0	6	10,0	57	0,05	2	■
JS512060D2C.0Z2-NXT	02927172	2	D	6,0	6	12,0	57	0,06	2	■
JS512080D2C.0Z2-NXT	02927173	2	D	8,0	8	16,0	63	0,08	2	■
JS512100D2C.0Z2-NXT	02927174	2	D	10,0	10	20,0	72	0,1	2	■
JS512120D2C.0Z2-NXT	02927175	2	D	12,0	12	24,0	83	0,12	2	■
JS512160D2C.0Z2-NXT	02927176	2	D	16,0	16	30,0	92	0,16	2	■
JS512200D2C.0Z2-NXT	02927191	2	D	20,0	20	35,0	104	0,2	2	■
JS512250D2C.0Z2-NXT	02927192	2	D	25,0	25	40,0	125	0,25	2	■
JS512010F3C.0Z2-NXT	02927193	3	F	1,0	3	3,0	38	0,01	2	■
JS512015F3C.0Z2-NXT	02927194	3	F	1,5	3	6,0	38	0,015	2	■
JS512020F3C.0Z2-NXT	02927177	3	F	2,0	6	7,0	57	0,02	2	■
JS512030F3C.0Z2-NXT	02927178	3	F	3,0	6	10,0	57	0,03	2	■
JS512040F3C.0Z2-NXT	02927179	3	F	4,0	6	14,0	57	0,04	2	■
JS512050F3C.0Z2-NXT	02927195	3	F	5,0	6	18,0	57	0,05	2	■
JS512060D3C.0Z2-NXT	02927180	3	D	6,0	6	20,0	63	0,06	2	■
JS512080D3C.0Z2-NXT	02927181	3	D	8,0	8	28,0	80	0,08	2	■
JS512100D3C.0Z2-NXT	02927182	3	D	10,0	10	35,0	89	0,1	2	■
JS512120D3C.0Z2-NXT	02927183	3	D	12,0	12	42,0	100	0,12	2	■
JS512160D3C.0Z2-NXT	02927196	3	D	16,0	16	50,0	115	0,16	2	■
JS512200D3C.0Z2-NXT	02927197	3	D	20,0	20	60,0	125	0,2	2	■

■ Stocked standard.

JS512

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





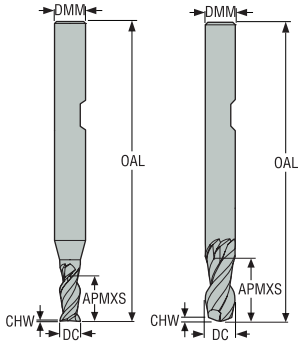
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS512020F4C.0Z2-NXT	02927184	4	F	2,0	6,0	10,0	57,0	0,02	2	■
JS512030F4C.0Z2-NXT	02927185	4	F	3,0	6,0	15,0	57,0	0,03	2	■
JS512040F4C.0Z2-NXT	02927186	4	F	4,0	6,0	20,0	63,0	0,04	2	■
JS512050F4C.0Z2-NXT	02927199	4	F	5,0	6,0	25,0	63,0	0,05	2	■
JS512060D4C.0Z2-NXT	02927188	4	D	6,0	6,0	30,0	75,0	0,06	2	■
JS512080D4C.0Z2-NXT	02927189	4	D	8,0	8,0	40,0	100,0	0,08	2	■
JS512100D4C.0Z2-NXT	02927190	4	D	10,0	10,0	50,0	100,0	0,1	2	■
JS512120D4C.0Z2-NXT	02927200	4	D	12,0	12,0	60,0	125,0	0,12	2	■
JS512160D4C.0Z2-NXT	02927201	4	D	16,0	16,0	70,0	130,0	0,16	2	■
JS512200D4C.0Z2-NXT	02927202	4	D	20,0	20,0	80,0	150,0	0,2	2	■
JS512250D4C.0Z2-NXT	02927203	4	D	25,0	25,0	90,0	165,0	0,25	2	■

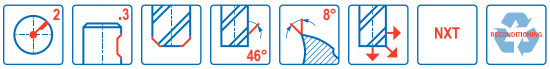
■ Stocked standard.

JS512

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



- Tolerances:
- DMM=h5
- DC=e8
- 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		
JS512020F2C.3Z2-NXT	02927267	2	F	2,0	6,0	4,0	57,0	0,02	2	☐
JS512030F2C.3Z2-NXT	02927268	2	F	3,0	6,0	6,0	57,0	0,03	2	☐
JS512040F2C.3Z2-NXT	02927269	2	F	4,0	6,0	8,0	57,0	0,04	2	☐
JS512050F2C.3Z2-NXT	02927270	2	F	5,0	6,0	10,0	57,0	0,05	2	☐
JS512060D2C.3Z2-NXT	02927271	2	D	6,0	6,0	12,0	57,0	0,06	2	☐
JS512080D2C.3Z2-NXT	02927272	2	D	8,0	8,0	16,0	63,0	0,08	2	☐
JS512100D2C.3Z2-NXT	02927273	2	D	10,0	10,0	20,0	72,0	0,1	2	☐
JS512120D2C.3Z2-NXT	02927274	2	D	12,0	12,0	24,0	83,0	0,12	2	☐
JS512160D2C.3Z2-NXT	02927275	2	D	16,0	16,0	30,0	92,0	0,16	2	☐
JS512200D2C.3Z2-NXT	02927276	2	D	20,0	20,0	35,0	104,0	0,2	2	☐
JS512250D2C.3Z2-NXT	02927277	2	D	25,0	25,0	40,0	125,0	0,25	2	☐
JS512020F3C.3Z2-NXT	02927278	3	F	2,0	6,0	7,0	57,0	0,02	2	☐
JS512030F3C.3Z2-NXT	02927279	3	F	3,0	6,0	10,0	57,0	0,03	2	☐
JS512040F3C.3Z2-NXT	02927280	3	F	4,0	6,0	14,0	57,0	0,04	2	☐
JS512050F3C.3Z2-NXT	02927281	3	F	5,0	6,0	18,0	57,0	0,05	2	☐
JS512060D3C.3Z2-NXT	02927282	3	D	6,0	6,0	20,0	63,0	0,06	2	☐
JS512080D3C.3Z2-NXT	02927283	3	D	8,0	8,0	28,0	80,0	0,08	2	☐
JS512100D3C.3Z2-NXT	02927284	3	D	10,0	10,0	35,0	89,0	0,1	2	☐
JS512120D3C.3Z2-NXT	02927285	3	D	12,0	12,0	42,0	100,0	0,12	2	☐
JS512160D3C.3Z2-NXT	02927286	3	D	16,0	16,0	50,0	115,0	0,16	2	☐
JS512200D3C.3Z2-NXT	02927287	3	D	20,0	20,0	60,0	125,0	0,2	2	☐
JS512250D3C.3Z2-NXT	02927288	3	D	25,0	25,0	70,0	150,0	0,25	2	☐
JS512020F4C.3Z2-NXT	02927289	4	F	2,0	6,0	10,0	57,0	0,02	2	☐
JS512030F4C.3Z2-NXT	02927290	4	F	3,0	6,0	15,0	57,0	0,03	2	☐
JS512040F4C.3Z2-NXT	02927291	4	F	4,0	6,0	20,0	63,0	0,04	2	☐
JS512050F4C.3Z2-NXT	02927292	4	F	5,0	6,0	25,0	63,0	0,05	2	☐
JS512060D4C.3Z2-NXT	02927293	4	D	6,0	6,0	30,0	75,0	0,06	2	☐
JS512080D4C.3Z2-NXT	02927294	4	D	8,0	8,0	40,0	100,0	0,08	2	☐
JS512100D4C.3Z2-NXT	02927295	4	D	10,0	10,0	50,0	100,0	0,1	2	☐
JS512120D4C.3Z2-NXT	02927296	4	D	12,0	12,0	60,0	125,0	0,12	2	☐
JS512160D4C.3Z2-NXT	02927297	4	D	16,0	16,0	70,0	130,0	0,16	2	☐
JS512200D4C.3Z2-NXT	02927298	4	D	20,0	20,0	80,0	150,0	0,2	2	☐
JS512250D4C.3Z2-NXT	02927299	4	D	25,0	25,0	90,0	165,0	0,25	2	☐

☐ Weldon available. Delivery time is 3 days.

Cutting data – JS512 Side milling a_e/DC = 0,2

SMG		a_e/DC	a_p/DC	f_z												v_c
				1	2	3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.2 *1,2*	0.0085 *0,00034*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	190 (160 — 220) *620 (530–720)*
P2	M/A/D/E	0.400 *0,400*	1.2 *1,2*	0.0090 *0,00036*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (160 — 210) *590 (530 — 680)*
P3	M/A/D/E	0.400 *0,400*	1.2 *1,2*	0.0085 *0,00034*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	160 (140–180) *520 (460 — 590)*
P4	M/A/D/E	0.400 *0,400*	1.2 *1,2*	0.0080 *0,00032*	0.016 *0,00065*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	140 (120–160) *460 (400 — 520)*
P5	M/A/D/E	0.400 *0,400*	1.2 *1,2*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	135 (120–150) *445 (400 — 490)*
P6	M/A/D/E	0.400 *0,400*	1.2 *1,2*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	150 (130–170) *490 (430 — 550)*
P7	M/A/D/E	0.400 *0,400*	1.2 *1,2*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	145 (120–160) *475 (400 — 520)*
P8	M/A/D/E	0.400 *0,400*	1.2 *1,2*	0.0085 *0,00034*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	135 (120–150) *445 (400 — 490)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.024 *0,00095*	0.036 *0,0014*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	140 (130–150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	90 (79–100) *295 (260 — 320)*
M1	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	110 (95–120) *360 (320 — 390)*
M2	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	90 (79–100) *295 (260 — 320)*
M3	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	55 (46 — 67) *180 (160 — 210)*
M4	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0070 *0,00028*	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*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	44 (35 — 52) *145 (120–170)*
M5	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0070 *0,00028*	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*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	36 (30 — 43) *120 (99–140)*
K1	A/D/M/E	0.400 *0,400*	1.2 *1,2*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	170 (150–190) *560 (500 — 620)*
K2	A/D/M/E	0.400 *0,400*	1.2 *1,2*	0.0075 *0,00030*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	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*	150 (130–160) *490 (430 — 520)*
K3	A/D/M/E	0.400 *0,400*	1.2 *1,2*	0.0075 *0,00030*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	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*	125 (110–140) *410 (370 — 450)*
K4	A/D/M/E	0.400 *0,400*	1.2 *1,2*	0.0075 *0,00030*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	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*	120 (110–130) *395 (370 — 420)*
K5	A/D/M/E	0.400 *0,400*	1.2 *1,2*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*
K6	A/D/M/E	0.400 *0,400*	1.2 *1,2*	0.0090 *0,00036*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	210 (180 — 240) *690 (600–780)*
K7	A/D/M/E	0.400 *0,400*	1.2 *1,2*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	185 (160 — 210) *610 (530 — 680)*

For cutting data recalculations, see pages 447 - 454

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 – JS512 Side milling a_e/DC = 0,2

SMG		a_e/DC	a_p/DC	f_z												v_c
				1	2	3	4	5	6	8	10	12	16	20	25	
N1	E/M/A	0.300	1.0	0.011	0.022	0.032	0.044	0.055	0.065	0.085	0.11	0.13	0.16	0.18	0.20	465 (350 — 570)
		0,300	*1,0*	*0,00044*	*0,00085*	*0,0013*	*0,0017*	*0,0022*	*0,0026*	*0,0034*	*0,0044*	*0,0050*	*0,0065*	*0,0070*	*0,0080*	*1525 (1200–1800)*
N2	E/M/A	0.300	1.0	0.011	0.022	0.032	0.044	0.055	0.065	0.085	0.11	0.13	0.16	0.18	0.20	300 (230 — 370)
		0,300	*1,0*	*0,00044*	*0,00085*	*0,0013*	*0,0017*	*0,0022*	*0,0026*	*0,0034*	*0,0044*	*0,0050*	*0,0065*	*0,0070*	*0,0080*	*980 (760–1200)*
N3	E/M/A	0.300	1.0	0.011	0.022	0.032	0.044	0.055	0.065	0.085	0.11	0.13	0.16	0.18	0.20	200 (150 — 240)
		0,300	*1,0*	*0,00044*	*0,00085*	*0,0013*	*0,0017*	*0,0022*	*0,0026*	*0,0034*	*0,0044*	*0,0050*	*0,0065*	*0,0070*	*0,0080*	*660 (500–780)*
S1	E	0.200	1.0	0.0044	0.0085	0.013	0.017	0.022	0.026	0.034	0.044	0.050	0.065	0.075	0.085	45 (28 — 63)
		0,200	*1,0*	*0,00017*	*0,00034*	*0,00050*	*0,00065*	*0,00085*	*0,0010*	*0,0013*	*0,0017*	*0,0020*	*0,0026*	*0,0030*	*0,0034*	*150 (92 — 200)*
S2	E	0.200	1.0	0.0044	0.0085	0.013	0.017	0.022	0.026	0.034	0.044	0.050	0.065	0.075	0.085	36 (22 — 51)
		0,200	*1,0*	*0,00017*	*0,00034*	*0,00050*	*0,00065*	*0,00085*	*0,0010*	*0,0013*	*0,0017*	*0,0020*	*0,0026*	*0,0030*	*0,0034*	*120 (73–160)*
S3	E	0.200	1.0	0.0040	0.0080	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.060	0.070	0.075	32 (20 — 44)
		0,200	*1,0*	*0,00016*	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0024*	*0,0028*	*0,0030*	*105 (66–140)*
S11	E	0.300	1.0	0.0070	0.014	0.022	0.028	0.036	0.044	0.060	0.070	0.085	0.11	0.12	0.14	110 (78–130)
		0,300	*1,0*	*0,00028*	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0024*	*0,0028*	*0,0034*	*0,0044*	*0,0048*	*0,0055*	*360 (260 — 420)*
S12	E	0.300	1.0	0.0070	0.014	0.022	0.028	0.036	0.044	0.060	0.070	0.085	0.11	0.12	0.14	85 (60–100)
		0,300	*1,0*	*0,00028*	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0024*	*0,0028*	*0,0034*	*0,0044*	*0,0048*	*0,0055*	*280 (200 — 320)*
S13	E	0.300	1.0	0.0065	0.013	0.019	0.025	0.032	0.038	0.050	0.065	0.075	0.095	0.11	0.12	65 (47 — 84)
		0,300	*1,0*	*0,00026*	*0,00050*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0030*	*0,0038*	*0,0044*	*0,0048*	*215 (160 — 270)*
H5	M/A/D	0.0300	0.50	0.012	0.024	0.036	0.048	0.060	0.070	0.095	0.12	0.14	0.19	0.24	0.30	80 (65 — 96)
		0,0300	*0,50*	*0,00048*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0055*	*0,0075*	*0,0095*	*0,012*	*260 (220 — 310)*
H8	M/A/D	0.0300	0.50	0.012	0.024	0.036	0.048	0.060	0.070	0.095	0.12	0.14	0.19	0.24	0.30	80 (65 — 96)
		0,0300	*0,50*	*0,00048*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0055*	*0,0075*	*0,0095*	*0,012*	*260 (220 — 310)*
H21	M/A/D	0.0300	0.50	0.012	0.024	0.036	0.048	0.060	0.070	0.095	0.12	0.14	0.19	0.24	0.30	80 (65 — 96)
		0,0300	*0,50*	*0,00048*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0055*	*0,0075*	*0,0095*	*0,012*	*260 (220 — 310)*
H31	M/A/D	0.0300	0.50	0.012	0.024	0.036	0.048	0.060	0.070	0.095	0.12	0.14	0.19	0.24	0.30	60 (49–72)
		0,0300	*0,50*	*0,00048*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0055*	*0,0075*	*0,0095*	*0,012*	*195 (170 — 230)*
TS1	A/D	0.400	1.4	0.013	0.026	0.038	0.050	0.065	0.080	0.10	0.13	0.15	0.19	0.22	0.25	550 (450 — 660)
		0,400	*1,4*	*0,00050*	*0,0010*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*0,0040*	*0,0050*	*0,0060*	*0,0075*	*0,0085*	*0,010*	*1800 (1500 — 2100)*
TP1	A/D	0.400	1.4	0.013	0.026	0.038	0.050	0.065	0.080	0.10	0.13	0.15	0.19	0.22	0.25	550 (450 — 660)
		0,400	*1,4*	*0,00050*	*0,0010*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*0,0040*	*0,0050*	*0,0060*	*0,0075*	*0,0085*	*0,010*	*1800 (1500 — 2100)*
GR1	A/D	0.400	1.4	0.013	0.026	0.038	0.050	0.065	0.080	0.10	0.13	0.15	0.19	0.22	0.25	550 (450 — 660)
		0,400	*1,4*	*0,00050*	*0,0010*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*0,0040*	*0,0050*	*0,0060*	*0,0075*	*0,0085*	*0,010*	*1800 (1500 — 2100)*

For cutting data recalculations, see pages 447 - 454

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 – JS512 Slot milling

SMG		a_p/DC	f_z												v_c
			1	2	3	4	5	6	8	10	12	16	20	25	
P1	E	1.0 *1,0*	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*	0.13 *0,0050*	170 (150–190) *560 (500 — 620)*
P2	E	1.0 *1,0*	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*	0.13 *0,0050*	165 (140–190) *540 (460 — 620)*
P3	E	1.0 *1,0*	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*	0.13 *0,0050*	145 (120–160) *475 (400 — 520)*
P4	E	1.0 *1,0*	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*	0.13 *0,0050*	125 (110–140) *410 (370 — 450)*
P5	E	1.0 *1,0*	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*	0.13 *0,0050*	120 (110–140) *395 (370 — 450)*
P6	E	1.0 *1,0*	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*	0.13 *0,0050*	135 (120–150) *445 (400 — 490)*
P7	E	1.0 *1,0*	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*	0.13 *0,0050*	125 (110–140) *410 (370 — 450)*
P8	E	1.0 *1,0*	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*	0.13 *0,0050*	120 (110–140) *395 (370 — 450)*
P11	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	135 (120–150) *445 (400 — 490)*
P12	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	80 (70 — 89) *260 (230 — 290)*
M1	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	100 (87–110) *330 (290 — 360)*
M2	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	80 (71 — 89) *260 (240 — 290)*
M3	E	0.60 *0,60*	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*	0.13 *0,0050*	50 (40 — 60) *165 (140–190)*
M4	E	0.60 *0,60*	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*	0.13 *0,0050*	38 (30 — 45) *125 (99–140)*
M5	E	0.60 *0,60*	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*	0.13 *0,0050*	31 (25 — 37) *100 (83–120)*
K1	E	1.0 *1,0*	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*	0.13 *0,0050*	150 (130–170) *490 (430 — 550)*
K2	E	1.0 *1,0*	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*	0.13 *0,0050*	130 (120–140) *425 (400 — 450)*
K3	E	1.0 *1,0*	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*	0.13 *0,0050*	110 (96–120) *360 (320 — 390)*
K4	E	1.0 *1,0*	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*	0.13 *0,0050*	105 (91–110) *345 (300 — 360)*
K5	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	130 (110–150) *425 (370 — 490)*
K6	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	190 (170 — 220) *620 (560–720)*
K7	E	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	165 (150–190) *540 (500 — 620)*

For cutting data recalculations, see pages 447 - 454

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 – JS512 Slot milling

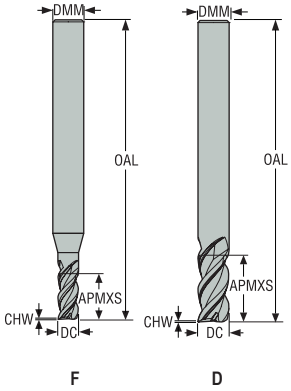
SMG		a_p/DC	f_z												v_c
			1	2	3	4	5	6	8	10	12	16	20	25	
N1	E	0.40 *0,40*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	400 (300 — 500) *1300 (990–1600)*
N2	E	0.40 *0,40*	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*	0.15 *0,0060*	255 (200 — 320) *840 (660–1000)*
N3	E	0.40 *0,40*	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*	0.15 *0,0060*	170 (130 — 210) *560 (430 — 680)*
N11	E	1.0 *1,0*	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*	0.15 *0,0060*	300 (210 — 400) *980 (690–1300)*
S1	E	0.20 *0,20*	0.0020 *0,000080*	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*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	36 (22 — 50) *120 (73–160)*
S2	E	0.20 *0,20*	0.0020 *0,000080*	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*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	29 (18 — 40) *95 (60–130)*
S3	E	0.20 *0,20*	0.0020 *0,000080*	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*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	25 (15 — 35) *80 (50–110)*
S11	E	0.60 *0,60*	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*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	90 (65–110) *295 (220 — 360)*
S12	E	0.60 *0,60*	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*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	70 (50 — 90) *230 (170 — 290)*
S13	E	0.60 *0,60*	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*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	50 (41 — 60) *165 (140–190)*
H8	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	50 (41 — 60) *165 (140–190)*
H11	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52–77) *215 (180 — 250)*
H12	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	60 (47–70) *195 (160 — 220)*
H21	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	50 (41 — 60) *165 (140–190)*
TS1	A	1.0 *1,0*	0.0080 *0,00032*	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*	0.20 *0,0080*	500 (400 — 600) *1650 (1400–1900)*
TP1	A	1.0 *1,0*	0.0080 *0,00032*	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*	0.20 *0,0080*	500 (410 — 600) *1650 (1400–1900)*
GR1	D/A	1.0 *1,0*	0.0080 *0,00032*	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*	0.20 *0,0080*	500 (400 — 600) *1650 (1400–1900)*

For cutting data recalculations, see pages 447 - 454

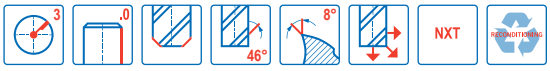
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

JS513

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



F D



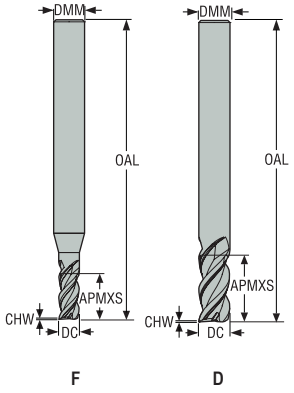
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS513010F2C.0Z3-NXT	02927301	2	F	1,0	3,0	2,0	38,0	0,01	3	■
JS513015F2C.0Z3-NXT	02928157	2	F	1,5	3,0	3,0	38,0	0,015	3	■
JS513021F2C.0Z3-NXT	02927304	2	F	2,0	3,0	4,0	38,0	0,02	3	■
JS513020F2C.0Z3-NXT	02927303	2	F	2,0	6,0	4,0	57,0	0,02	3	■
JS513025F2C.0Z3-NXT	02927305	2	F	2,5	6,0	5,0	57,0	0,025	3	■
JS513030F2C.0Z3-NXT	02927306	2	F	3,0	6,0	6,0	57,0	0,03	3	■
JS513030D2C.0Z3-NXT	02927307	2	D	3,0	3,0	6,0	38,0	0,03	3	■
JS513040F2C.0Z3-NXT	02927308	2	F	4,0	6,0	8,0	57,0	0,04	3	■
JS513040D2C.0Z3-NXT	02927310	2	D	4,0	4,0	8,0	50,0	0,04	3	■
JS513050F2C.0Z3-NXT	02927311	2	F	5,0	6,0	10,0	57,0	0,05	3	■
JS513050D2C.0Z3-NXT	02927312	2	D	5,0	5,0	10,0	50,0	0,05	3	■
JS513060D2C.0Z3-NXT	02927313	2	D	6,0	6,0	12,0	57,0	0,06	3	■
JS513080D2C.0Z3-NXT	02927314	2	D	8,0	8,0	16,0	63,0	0,08	3	■
JS513100D2C.0Z3-NXT	02927315	2	D	10,0	10,0	20,0	72,0	0,1	3	■
JS513120D2C.0Z3-NXT	02927316	2	D	12,0	12,0	24,0	83,0	0,12	3	■
JS513140D2C.0Z3-NXT	02927317	2	D	14,0	14,0	28,0	83,0	0,14	3	■
JS513160D2C.0Z3-NXT	02927318	2	D	16,0	16,0	30,0	92,0	0,16	3	■
JS513180D2C.0Z3-NXT	02927319	2	D	18,0	18,0	35,0	100,0	0,18	3	■
JS513200D2C.0Z3-NXT	02927341	2	D	20,0	20,0	35,0	104,0	0,2	3	■
JS513250D2C.0Z3-NXT	02927342	2	D	25,0	25,0	40,0	125,0	0,25	3	■
JS513010F3C.0Z3-NXT	02927302	3	F	1,0	3,0	3,0	38,0	0,01	3	■
JS513015F3C.0Z3-NXT	02927320	3	F	1,5	3,0	6,0	38,0	0,015	3	■
JS513020F3C.0Z3-NXT	02927321	3	F	2,0	6,0	7,0	57,0	0,02	3	■
JS513025F3C.0Z3-NXT	02927343	3	F	2,5	6,0	9,0	57,0	0,025	3	■
JS513030F3C.0Z3-NXT	02927322	3	F	3,0	6,0	10,0	57,0	0,03	3	■
JS513040F3C.0Z3-NXT	02927323	3	F	4,0	6,0	14,0	57,0	0,04	3	■
JS513050F3C.0Z3-NXT	02927324	3	F	5,0	6,0	18,0	57,0	0,05	3	■
JS513060D3C.0Z3-NXT	02927325	3	D	6,0	6,0	20,0	63,0	0,06	3	■
JS513080D3C.0Z3-NXT	02927326	3	D	8,0	8,0	28,0	80,0	0,08	3	■
JS513100D3C.0Z3-NXT	02927327	3	D	10,0	10,0	35,0	89,0	0,1	3	■
JS513120D3C.0Z3-NXT	02927328	3	D	12,0	12,0	42,0	100,0	0,12	3	■
JS513140D3C.0Z3-NXT	02927329	3	D	14,0	14,0	50,0	120,0	0,14	3	■
JS513160D3C.0Z3-NXT	02927330	3	D	16,0	16,0	50,0	115,0	0,16	3	■
JS513200D3C.0Z3-NXT	02927331	3	D	20,0	20,0	60,0	125,0	0,2	3	■
JS513250D3C.0Z3-NXT	02927344	3	D	25,0	25,0	70,0	150,0	0,25	3	■

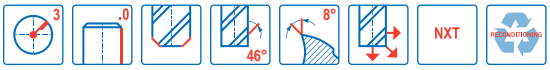
■ Stocked standard.

JS513

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



- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø6

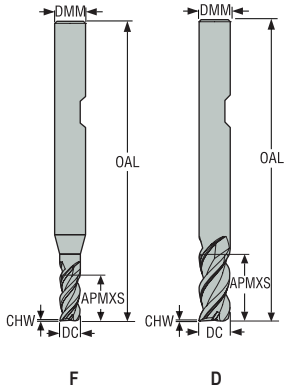


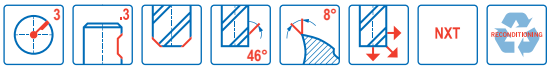
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS513020F4C.0Z3-NXT	02927332	4	F	2,0	6,0	10,0	57,0	0,02	3	■
JS513025F4C.0Z3-NXT	02927345	4	F	2,5	6,0	13,0	57,0	0,025	3	■
JS513030F4C.0Z3-NXT	02927333	4	F	3,0	6,0	15,0	57,0	0,03	3	■
JS513040F4C.0Z3-NXT	02927334	4	F	4,0	6,0	20,0	57,0	0,04	3	■
JS513050F4C.0Z3-NXT	02927335	4	F	5,0	6,0	25,0	63,0	0,05	3	■
JS513060D4C.0Z3-NXT	02927336	4	D	6,0	6,0	30,0	80,0	0,06	3	■
JS513080D4C.0Z3-NXT	02927337	4	D	8,0	8,0	40,0	100,0	0,08	3	■
JS513100D4C.0Z3-NXT	02927338	4	D	10,0	10,0	50,0	100,0	0,1	3	■
JS513120D4C.0Z3-NXT	02927339	4	D	12,0	12,0	60,0	125,0	0,12	3	■
JS513140D4C.0Z3-NXT	02927346	4	D	14,0	14,0	65,0	140,0	0,14	3	■
JS513160D4C.0Z3-NXT	02927340	4	D	16,0	16,0	70,0	130,0	0,16	3	■
JS513200D4C.0Z3-NXT	02927348	4	D	20,0	20,0	80,0	150,0	0,2	3	■
JS513250D4C.0Z3-NXT	02927349	4	D	25,0	25,0	90,0	165,0	0,25	3	■

■ Stocked standard.

JS513

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





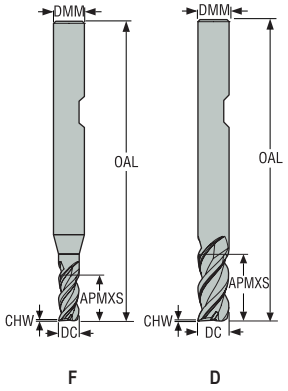
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS513020F2C.3Z3-NXT	02927355	2	F	2,0	6,0	4,0	57,0	0,02	3	□
JS513025F2C.3Z3-NXT	02927356	2	F	2,5	6,0	5,0	57,0	0,025	3	□
JS513030F2C.3Z3-NXT	02927357	2	F	3,0	6,0	6,0	57,0	0,03	3	□
JS513040F2C.3Z3-NXT	02927358	2	F	4,0	6,0	8,0	57,0	0,04	3	□
JS513050F2C.3Z3-NXT	02927359	2	F	5,0	6,0	10,0	57,0	0,05	3	□
JS513060D2C.3Z3-NXT	02927360	2	D	6,0	6,0	12,0	57,0	0,06	3	■
JS513080D2C.3Z3-NXT	02927361	2	D	8,0	8,0	16,0	63,0	0,08	3	■
JS513100D2C.3Z3-NXT	02927362	2	D	10,0	10,0	20,0	72,0	0,1	3	■
JS513120D2C.3Z3-NXT	02927363	2	D	12,0	12,0	24,0	83,0	0,12	3	■
JS513140D2C.3Z3-NXT	02927364	2	D	14,0	14,0	28,0	83,0	0,14	3	□
JS513160D2C.3Z3-NXT	02927365	2	D	16,0	16,0	30,0	92,0	0,16	3	□
JS513180D2C.3Z3-NXT	02927366	2	D	18,0	18,0	35,0	100,0	0,18	3	□
JS513200D2C.3Z3-NXT	02927367	2	D	20,0	20,0	35,0	104,0	0,2	3	□
JS513250D2C.3Z3-NXT	02927368	2	D	25,0	25,0	40,0	125,0	0,25	3	□
JS513020F3C.3Z3-NXT	02927369	3	F	2,0	6,0	7,0	57,0	0,02	3	□
JS513025F3C.3Z3-NXT	02927370	3	F	2,5	6,0	9,0	57,0	0,025	3	□
JS513030F3C.3Z3-NXT	02927371	3	F	3,0	6,0	10,0	57,0	0,03	3	□
JS513040F3C.3Z3-NXT	02927372	3	F	4,0	6,0	14,0	57,0	0,04	3	■
JS513050F3C.3Z3-NXT	02927373	3	F	5,0	6,0	18,0	57,0	0,05	3	□
JS513060D3C.3Z3-NXT	02927374	3	D	6,0	6,0	20,0	63,0	0,06	3	■
JS513080D3C.3Z3-NXT	02927375	3	D	8,0	8,0	28,0	80,0	0,08	3	□
JS513100D3C.3Z3-NXT	02927376	3	D	10,0	10,0	35,0	89,0	0,1	3	□
JS513120D3C.3Z3-NXT	02927377	3	D	12,0	12,0	42,0	100,0	0,12	3	□
JS513140D3C.3Z3-NXT	02927378	3	D	14,0	14,0	50,0	120,0	0,14	3	□
JS513160D3C.3Z3-NXT	02927379	3	D	16,0	16,0	50,0	115,0	0,16	3	□
JS513200D3C.3Z3-NXT	02927380	3	D	20,0	20,0	60,0	125,0	0,2	3	□
JS513250D3C.3Z3-NXT	02927381	3	D	25,0	25,0	70,0	150,0	0,25	3	□

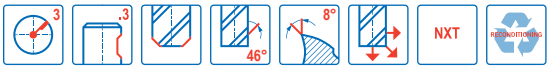
■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS513

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



- Tolerances:
- DMM=h5
- DC=e8
- 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		
JS513020F4C.3Z3-NXT	02927382	4	F	2,0	6,0	10,0	57,0	0,02	3	☐
JS513025F4C.3Z3-NXT	02927383	4	F	2,5	6,0	13,0	57,0	0,025	3	☐
JS513030F4C.3Z3-NXT	02927384	4	F	3,0	6,0	15,0	57,0	0,03	3	☐
JS513040F4C.3Z3-NXT	02927385	4	F	4,0	6,0	20,0	57,0	0,04	3	☐
JS513050F4C.3Z3-NXT	02927386	4	F	5,0	6,0	25,0	63,0	0,05	3	☐
JS513060D4C.3Z3-NXT	02927387	4	D	6,0	6,0	30,0	80,0	0,06	3	☐
JS513080D4C.3Z3-NXT	02927388	4	D	8,0	8,0	40,0	100,0	0,08	3	☐
JS513100D4C.3Z3-NXT	02927389	4	D	10,0	10,0	50,0	100,0	0,1	3	☐
JS513120D4C.3Z3-NXT	02927390	4	D	12,0	12,0	60,0	125,0	0,12	3	☐
JS513140D4C.3Z3-NXT	02927391	4	D	14,0	14,0	65,0	140,0	0,14	3	☐
JS513160D4C.3Z3-NXT	02927392	4	D	16,0	16,0	70,0	130,0	0,16	3	☐
JS513200D4C.3Z3-NXT	02927393	4	D	20,0	20,0	80,0	150,0	0,2	3	☐
JS513250D4C.3Z3-NXT	02927394	4	D	25,0	25,0	90,0	165,0	0,25	3	☐

☐ Weldon available. Delivery time is 3 days.

Cutting data – JS513 Side milling

SMG		a_e/DC	a_p/DC	f_z														v_c
				1	2	3	4	5	6	8	10	12	14	16	18	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.0065 *0,00026*	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*	0.090 *0,0036*	0.095 *0,0038*	0.11 *0,0044*	0.11 *0,0044*	0.13 *0,0050*	195 (170 — 220) *640 (560–720)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.0065 *0,00026*	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*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.11 *0,0044*	0.13 *0,0050*	190 (160 — 210) *620 (530 — 680)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.0065 *0,00026*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	160 (140–180) *520 (460 — 590)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.0060 *0,00024*	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*	0.085 *0,0034*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	150 (130–170) *490 (430 — 550)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	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*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	140 (120–160) *460 (400 — 520)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	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*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	155 (130–180) *510 (430 — 590)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	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*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	145 (130–170) *475 (430 — 550)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.0065 *0,00026*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	135 (120–150) *445 (400 — 490)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.0075 *0,00030*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.14 *0,0055*	140 (130–160) *460 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.10 *0,0040*	90 (81–100) *295 (270 — 320)*
M1	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0055 *0,00022*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.090 *0,0036*	0.095 *0,0038*	0.11 *0,0044*	110 (98–120) *360 (330 — 390)*
M2	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.10 *0,0040*	90 (81–100) *295 (270 — 320)*
M3	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.10 *0,0040*	55 (46 — 68) *180 (160 — 220)*
M4	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0044 *0,00017*	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*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	44 (36 — 52) *145 (120–170)*
M5	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0044 *0,00017*	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*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	37 (30 — 44) *120 (99–140)*
K1	A/D/M/E	0.400 *0,400*	1.0 *1,0*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.10 *0,0040*	175 (150–190) *570 (500 — 620)*
K2	A/D/M/E	0.400 *0,400*	1.0 *1,0*	0.0046 *0,00018*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.090 *0,0036*	150 (140–170) *490 (460 — 550)*
K3	A/D/M/E	0.400 *0,400*	1.0 *1,0*	0.0046 *0,00018*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.090 *0,0036*	130 (120–140) *425 (400 — 450)*
K4	A/D/M/E	0.400 *0,400*	1.0 *1,0*	0.0046 *0,00018*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.090 *0,0036*	125 (110–130) *410 (370 — 420)*
K5	A/D/M/E	0.400 *0,400*	1.0 *1,0*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.10 *0,0040*	150 (130–170) *490 (430 — 550)*
K6	A/D/M/E	0.400 *0,400*	1.0 *1,0*	0.0055 *0,00022*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.090 *0,0036*	0.095 *0,0038*	0.11 *0,0044*	215 (190 — 250) *710 (630 — 820)*
K7	A/D/M/E	0.400 *0,400*	1.0 *1,0*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.10 *0,0040*	190 (170 — 220) *620 (560–720)*

For cutting data recalculations, see pages 447 - 454

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 – JS513 Side milling

SMG		a_e/DC	a_p/DC	f_z														v_c
				1	2	3	4	5	6	8	10	12	14	16	18	20	25	
N1	E/M/A	0.300 *0,300*	1.0 *1,0*	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*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.095 *0,0038*	400 (300 — 490) *1300 (990–1600)*
N2	E/M/A	0.300 *0,300*	1.0 *1,0*	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*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.095 *0,0038*	255 (200 — 320) *840 (660–1000)*
N3	E/M/A	0.300 *0,300*	1.0 *1,0*	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*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	0.085 *0,0034*	0.095 *0,0038*	170 (130 — 210) *560 (430 — 680)*
N11	E/M/A	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.16 *0,0065*	0.18 *0,0070*	350 (240 — 460) *1150 (790–1500)*
S1	E	0.200 *0,200*	1.0 *1,0*	0.0075 *0,00030*	0.015 *0,00060*	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*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.14 *0,0055*	44 (27 — 61) *145 (89 — 200)*
S2	E	0.200 *0,200*	1.0 *1,0*	0.0075 *0,00030*	0.015 *0,00060*	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*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.14 *0,0055*	35 (22 — 49) *115 (73–160)*
S3	E	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	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*	0.095 *0,0038*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	31 (19 — 43) *100 (63–140)*
S11	E	0.400 *0,400*	1.0 *1,0*	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*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	100 (72–120) *330 (240 — 390)*
S12	E	0.400 *0,400*	1.0 *1,0*	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*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.0055 *0,00022*	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*	0.085 *0,0034*	0.090 *0,0036*	0.10 *0,0040*	60 (44–78) *195 (150 — 250)*
H5	M/A/D	0.0300 *0,0300*	0.060 *0,060*	0.010 *0,00040*	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*	0.18 *0,0070*	0.20 *0,0080*	0.25 *0,010*	85 (67–100) *280 (220 — 320)*
H8	M/A/D	0.0300 *0,0300*	0.060 *0,060*	0.010 *0,00040*	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*	0.18 *0,0070*	0.20 *0,0080*	0.25 *0,010*	85 (67–100) *280 (220 — 320)*
H21	M/A/D	0.0300 *0,0300*	0.060 *0,060*	0.010 *0,00040*	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*	0.18 *0,0070*	0.20 *0,0080*	0.25 *0,010*	85 (67–100) *280 (220 — 320)*
H31	M/A/D	0.0300 *0,0300*	0.060 *0,060*	0.010 *0,00040*	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*	0.18 *0,0070*	0.20 *0,0080*	0.25 *0,010*	65 (51–75) *215 (170 — 240)*
TS1	A/D	0.400 *0,400*	1.4 *1,4*	0.013 *0,00050*	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*	0.17 *0,0065*	0.19 *0,0075*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	550 (450 — 660) *1800 (1500 — 2100)*
TP1	A/D	0.400 *0,400*	1.4 *1,4*	0.013 *0,00050*	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*	0.17 *0,0065*	0.19 *0,0075*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	550 (450 — 660) *1800 (1500 — 2100)*
GR1	A/D	0.400 *0,400*	1.4 *1,4*	0.013 *0,00050*	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*	0.17 *0,0065*	0.19 *0,0075*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	550 (450 — 660) *1800 (1500 — 2100)*

For cutting data recalculations, see pages 447 - 454

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 – JS513 Slot milling

SMG		a_p/DC	f_z														v_c
			1	2	3	4	5	6	8	10	12	14	16	18	20	25	
P1	M/A/D/E	0.70 *0,70*	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*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	170 (150–190) *560 (500 — 620)*
P2	M/A/D/E	0.70 *0,70*	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*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	165 (140–190) *540 (460 — 620)*
P3	M/A/D/E	0.70 *0,70*	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*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	145 (120–160) *475 (400 — 520)*
P4	M/A/D/E	0.70 *0,70*	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*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	130 (120–150) *425 (400 — 490)*
P5	M/A/D/E	0.70 *0,70*	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*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	120 (110–140) *395 (370 — 450)*
P6	M/A/D/E	0.70 *0,70*	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*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	135 (120–150) *445 (400 — 490)*
P7	M/A/D/E	0.70 *0,70*	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*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	125 (110–140) *410 (370 — 450)*
P8	M/A/D/E	0.70 *0,70*	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*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	120 (110–140) *395 (370 — 450)*
P11	M/A/D/E	0.60 *0,60*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	135 (120–150) *445 (400 — 490)*
P12	M/A/D/E	0.60 *0,60*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	80 (70 — 89) *260 (230 — 290)*
M1	E/M/A	0.60 *0,60*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	100 (87–110) *330 (290 — 360)*
M2	E/M/A	0.60 *0,60*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	80 (71 — 89) *260 (240 — 290)*
M3	E/M/A	0.60 *0,60*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	50 (40 — 60) *165 (140–190)*
M4	E/M/A	0.60 *0,60*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	37 (30 — 45) *120 (99–140)*
M5	E/M/A	0.60 *0,60*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	31 (25 — 37) *100 (83–120)*
K1	A/D/M/E	0.90 *0,90*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	150 (140–170) *490 (460 — 550)*
K2	A/D/M/E	0.90 *0,90*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	130 (120–140) *425 (400 — 450)*
K3	A/D/M/E	0.90 *0,90*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	110 (96–120) *360 (320 — 390)*
K4	A/D/M/E	0.90 *0,90*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	105 (92–110) *345 (310 — 360)*
K5	A/D/M/E	0.70 *0,70*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	130 (110–150) *425 (370 — 490)*
K6	A/D/M/E	0.70 *0,70*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	190 (170 — 220) *620 (560–720)*
K7	A/D/M/E	0.70 *0,70*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	165 (150–190) *540 (500 — 620)*

For cutting data recalculations, see pages 447 - 454

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 – JS513 Slot milling

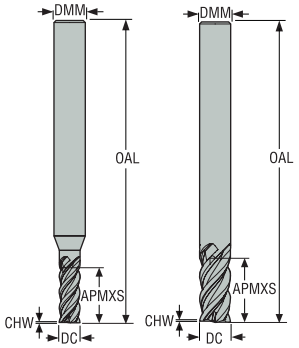
SMG		a_p/DC	f_z														v_c
			1	2	3	4	5	6	8	10	12	14	16	18	20	25	
S1	E	0.20 *0,20*	0.0032 *0,00013*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	36 (22 — 50) *120 (73–160)*
S2	E	0.20 *0,20*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	29 (18 — 40) *95 (60–130)*
S3	E	0.20 *0,20*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	25 (16 — 35) *80 (53–110)*
S11	E	0.40 *0,40*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	90 (66–110) *295 (220 — 360)*
S12	E	0.40 *0,40*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	70 (51 — 90) *230 (170 — 290)*
S13	E	0.40 *0,40*	0.0032 *0,00013*	0.0065 *0,00026*	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*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.060 *0,060*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	50 (41 — 60) *165 (140–190)*
H8	M/A/D	0.060 *0,060*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	50 (41 — 60) *165 (140–190)*
H21	M/A/D	0.060 *0,060*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	50 (41 — 60) *165 (140–190)*
H31	M/A/D	0.060 *0,060*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	38 (31 — 45) *125 (110–140)*
TS1	A/D	0.90 *0,90*	0.0080 *0,00032*	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*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 600) *1650 (1400–1900)*
TP1	A/D	0.90 *0,90*	0.0080 *0,00032*	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*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 600) *1650 (1400–1900)*
GR1	A/D	0.80 *0,80*	0.0080 *0,00032*	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*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (400 — 590) *1650 (1400–1900)*

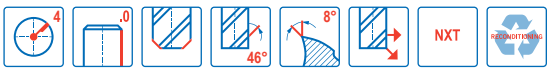
For cutting data recalculations, see pages 447 - 454

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

JS514

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





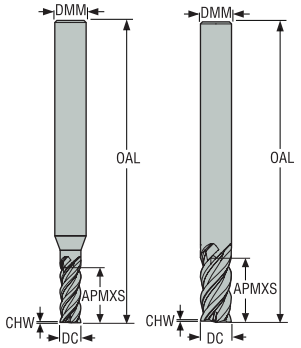
- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS514010F2C.0Z4-NXT	02927398	2	F	1,0	3,0	2,0	38,0	0,01	4	■
JS514015F2C.0Z4-NXT	02927399	2	F	1,5	3,0	3,0	38,0	0,015	4	■
JS514020F2C.0Z4-NXT	02927400	2	F	2,0	6,0	5,0	57,0	0,02	4	■
JS514021F2C.0Z4-NXT	02927401	2	F	2,0	3,0	5,0	38,0	0,02	4	■
JS514030F2C.0Z4-NXT	02927402	2	F	3,0	6,0	7,0	57,0	0,03	4	■
JS514030D2C.0Z4-NXT	02927403	2	D	3,0	3,0	7,0	38,0	0,03	4	■
JS514040F2C.0Z4-NXT	02927404	2	F	4,0	6,0	10,0	57,0	0,04	4	■
JS514040D2C.0Z4-NXT	02927405	2	D	4,0	4,0	10,0	50,0	0,04	4	■
JS514050F2C.0Z4-NXT	02927406	2	F	5,0	6,0	12,0	57,0	0,05	4	■
JS514050D2C.0Z4-NXT	02927407	2	D	5,0	5,0	12,0	50,0	0,05	4	■
JS514060D2C.0Z4-NXT	02927408	2	D	6,0	6,0	13,0	57,0	0,06	4	■
JS514080D2C.0Z4-NXT	02927409	2	D	8,0	8,0	18,0	63,0	0,08	4	■
JS514100D2C.0Z4-NXT	02927410	2	D	10,0	10,0	22,0	72,0	0,1	4	■
JS514120D2C.0Z4-NXT	02927411	2	D	12,0	12,0	26,0	83,0	0,12	4	■
JS514160D2C.0Z4-NXT	02927412	2	D	16,0	16,0	32,0	92,0	0,16	4	■
JS514200D2C.0Z4-NXT	02927413	2	D	20,0	20,0	40,0	104,0	0,2	4	■
JS514250D2C.0Z4-NXT	02927414	2	D	25,0	25,0	50,0	125,0	0,25	4	■
JS514010F3C.0Z4-NXT	02927415	3	F	1,0	3,0	3,0	38,0	0,01	4	■
JS514015F3C.0Z4-NXT	02927416	3	F	1,5	3,0	6,0	38,0	0,015	4	■
JS514020F3C.0Z4-NXT	02927417	3	F	2,0	6,0	8,0	57,0	0,02	4	■
JS514030F3C.0Z4-NXT	02927418	3	F	3,0	6,0	12,0	57,0	0,03	4	■
JS514040F3C.0Z4-NXT	02927419	3	F	4,0	6,0	16,0	57,0	0,04	4	■
JS514050F3C.0Z4-NXT	02927420	3	F	5,0	6,0	21,0	63,0	0,05	4	■
JS514060D3C.0Z4-NXT	02927421	3	D	6,0	6,0	23,0	63,0	0,06	4	■
JS514080D3C.0Z4-NXT	02927422	3	D	8,0	8,0	32,0	80,0	0,08	4	■
JS514100D3C.0Z4-NXT	02927423	3	D	10,0	10,0	40,0	89,0	0,1	4	■
JS514120D3C.0Z4-NXT	02927424	3	D	12,0	12,0	45,0	100,0	0,12	4	■
JS514160D3C.0Z4-NXT	02927425	3	D	16,0	16,0	55,0	115,0	0,16	4	■
JS514200D3C.0Z4-NXT	02927426	3	D	20,0	20,0	65,0	125,0	0,2	4	■
JS514250D3C.0Z4-NXT	02927427	3	D	25,0	25,0	80,0	150,0	0,25	4	■

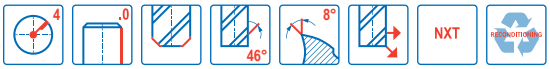
■ Stocked standard.

JS514

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



- Tolerances:
- DMM=h5
- DC=e8
- Regrind possible if DC is ≥Ø6

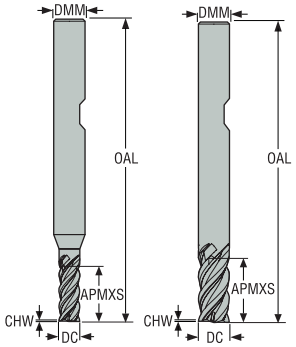


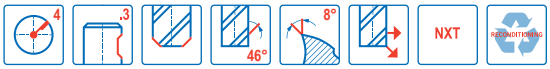
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS514020F4C.0Z4-NXT	02927428	4	F	2,0	6,0	10,0	57,0	0,02	4	■
JS514030F4C.0Z4-NXT	02927429	4	F	3,0	6,0	17,0	57,0	0,03	4	■
JS514040F4C.0Z4-NXT	02927430	4	F	4,0	6,0	25,0	63,0	0,04	4	■
JS514050F4C.0Z4-NXT	02927431	4	F	5,0	6,0	28,0	75,0	0,05	4	■
JS514060D4C.0Z4-NXT	02927432	4	D	6,0	6,0	35,0	75,0	0,06	4	■
JS514080D4C.0Z4-NXT	02927433	4	D	8,0	8,0	45,0	100,0	0,08	4	■
JS514100D4C.0Z4-NXT	02927434	4	D	10,0	10,0	55,0	100,0	0,1	4	■
JS514120D4C.0Z4-NXT	02927435	4	D	12,0	12,0	65,0	125,0	0,12	4	■
JS514160D4C.0Z4-NXT	02927436	4	D	16,0	16,0	80,0	150,0	0,16	4	■
JS514200D4C.0Z4-NXT	02927437	4	D	20,0	20,0	90,0	150,0	0,2	4	■
JS514250D4C.0Z4-NXT	02927438	4	D	25,0	25,0	110,0	196,0	0,25	4	■

■ Stocked standard.

JS514

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





- Tolerances:
- DMM=h5
- DC=e8
- 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		
JS514020F2C.3Z4-NXT	02927441	2	F	2,0	6,0	5,0	57,0	0,02	4	□
JS514030F2C.3Z4-NXT	02927442	2	F	3,0	6,0	7,0	57,0	0,03	4	□
JS514040F2C.3Z4-NXT	02927443	2	F	4,0	6,0	10,0	57,0	0,04	4	□
JS514050F2C.3Z4-NXT	02927444	2	F	5,0	6,0	12,0	57,0	0,05	4	□
JS514060D2C.3Z4-NXT	02927445	2	D	6,0	6,0	13,0	57,0	0,06	4	□
JS514080D2C.3Z4-NXT	02927446	2	D	8,0	8,0	18,0	63,0	0,08	4	□
JS514100D2C.3Z4-NXT	02927447	2	D	10,0	10,0	22,0	72,0	0,1	4	■
JS514120D2C.3Z4-NXT	02927448	2	D	12,0	12,0	26,0	83,0	0,12	4	■
JS514160D2C.3Z4-NXT	02927449	2	D	16,0	16,0	32,0	92,0	0,16	4	■
JS514200D2C.3Z4-NXT	02927450	2	D	20,0	20,0	40,0	104,0	0,2	4	■
JS514250D2C.3Z4-NXT	02927451	2	D	25,0	25,0	50,0	125,0	0,25	4	□
JS514020F3C.3Z4-NXT	02927452	3	F	2,0	6,0	8,0	57,0	0,02	4	□
JS514030F3C.3Z4-NXT	02927453	3	F	3,0	6,0	12,0	57,0	0,03	4	□
JS514040F3C.3Z4-NXT	02927454	3	F	4,0	6,0	16,0	57,0	0,04	4	□
JS514050F3C.3Z4-NXT	02927455	3	F	5,0	6,0	21,0	63,0	0,05	4	□
JS514060D3C.3Z4-NXT	02927456	3	D	6,0	6,0	23,0	63,0	0,06	4	□
JS514080D3C.3Z4-NXT	02927457	3	D	8,0	8,0	32,0	80,0	0,08	4	□
JS514100D3C.3Z4-NXT	02927458	3	D	10,0	10,0	40,0	89,0	0,1	4	■
JS514120D3C.3Z4-NXT	02927459	3	D	12,0	12,0	45,0	100,0	0,12	4	□
JS514160D3C.3Z4-NXT	02927460	3	D	16,0	16,0	55,0	115,0	0,16	4	□
JS514200D3C.3Z4-NXT	02927461	3	D	20,0	20,0	65,0	125,0	0,2	4	□
JS514250D3C.3Z4-NXT	02927462	3	D	25,0	25,0	80,0	150,0	0,25	4	□
JS514020F4C.3Z4-NXT	02927463	4	F	2,0	6,0	10,0	57,0	0,02	4	□
JS514030F4C.3Z4-NXT	02927464	4	F	3,0	6,0	17,0	57,0	0,03	4	□
JS514040F4C.3Z4-NXT	02927465	4	F	4,0	6,0	25,0	63,0	0,04	4	□
JS514050F4C.3Z4-NXT	02927466	4	F	5,0	6,0	28,0	75,0	0,05	4	□
JS514060D4C.3Z4-NXT	02927467	4	D	6,0	6,0	35,0	75,0	0,06	4	□
JS514080D4C.3Z4-NXT	02927468	4	D	8,0	8,0	45,0	100,0	0,08	4	■
JS514100D4C.3Z4-NXT	02927469	4	D	10,0	10,0	55,0	100,0	0,1	4	■
JS514120D4C.3Z4-NXT	02927470	4	D	12,0	12,0	65,0	125,0	0,12	4	□
JS514160D4C.3Z4-NXT	02927471	4	D	16,0	16,0	80,0	150,0	0,16	4	□
JS514200D4C.3Z4-NXT	02927472	4	D	20,0	20,0	90,0	150,0	0,2	4	□
JS514250D4C.3Z4-NXT	02927473	4	D	25,0	25,0	110,0	196,0	0,25	4	■

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

Cutting data – JS514 Side milling

SMG		a_e/DC	a_p/DC	f_z												v_c
				1	2	3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0.300 *0,300*	1.0 *1,0*	0.0095 *0,00038*	0.019 *0,00075*	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*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	195 (190 — 220) *640 (630–720)*
P2	M/A/D/E	0.300 *0,300*	1.0 *1,0*	0.010 *0,00040*	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*	0.17 *0,0065*	0.19 *0,0075*	190 (180 — 220) *620 (600–720)*
P3	M/A/D/E	0.300 *0,300*	1.0 *1,0*	0.0095 *0,00038*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	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*	165 (160–190) *540 (530 — 620)*
P4	M/A/D/E	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	145 (140–170) *475 (460 — 550)*
P5	M/A/D/E	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	140 (130–160) *460 (430 — 520)*
P6	M/A/D/E	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	160 (150–180) *520 (500 — 590)*
P7	M/A/D/E	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (140–170) *490 (460 — 550)*
P8	M/A/D/E	0.300 *0,300*	1.0 *1,0*	0.0095 *0,00038*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	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*	140 (130–160) *460 (430 — 520)*
P11	M/A/D/E	0.300 *0,300*	1.0 *1,0*	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*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	150 (140–160) *490 (460 — 520)*
P12	M/A/D/E	0.300 *0,300*	1.0 *1,0*	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*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	95 (84–100) *310 (280 — 320)*
M1	E/M/A	0.300 *0,300*	1.0 *1,0*	0.0044 *0,00017*	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*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	115 (110–130) *375 (370 — 420)*
M2	E/M/A	0.300 *0,300*	1.0 *1,0*	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*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	95 (84–100) *310 (280 — 320)*
M3	E/M/A	0.300 *0,300*	1.0 *1,0*	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*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	60 (48–71) *195 (160 — 230)*
M4	E/M/A	0.300 *0,300*	1.0 *1,0*	0.0036 *0,00014*	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*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	45 (37 — 54) *150 (130–170)*
M5	E/M/A	0.300 *0,300*	1.0 *1,0*	0.0036 *0,00014*	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*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	38 (31 — 45) *125 (110–140)*
K1	A/D/M/E	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	160 (140–170) *520 (460 — 550)*
K2	A/D/M/E	0.300 *0,300*	1.0 *1,0*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	145 (130–150) *475 (430 — 490)*
K3	A/D/M/E	0.300 *0,300*	1.0 *1,0*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	120 (110–120) *395 (370 — 390)*
K4	A/D/M/E	0.300 *0,300*	1.0 *1,0*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	115 (100–120) *375 (330 — 390)*
K5	A/D/M/E	0.300 *0,300*	1.0 *1,0*	0.0070 *0,00028*	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*	0.13 *0,0050*	145 (130–150) *475 (430 — 490)*
K6	A/D/M/E	0.300 *0,300*	1.0 *1,0*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	210 (180 — 220) *690 (600–720)*
K7	A/D/M/E	0.300 *0,300*	1.0 *1,0*	0.0070 *0,00028*	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*	0.13 *0,0050*	190 (160 — 200) *620 (530 — 650)*

For cutting data recalculations, see pages 447 - 454

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

SMG		a_e/DC	a_p/DC	f_z												v_c
				1	2	3	4	5	6	8	10	12	16	20	25	
N1	E/M/A	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	500 (400 — 590) *1650 (1400–1900)*
N2	E/M/A	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	320 (260 — 380) *1050 (860–1200)*
N3	E/M/A	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	215 (180 — 250) *710 (600 — 820)*
N11	E/M/A	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	350 (240 — 460) *1150 (790–1500)*
S1	E	0.200 *0,200*	0.60 *0,60*	0.0044 *0,00017*	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*	0.085 *0,0034*	45 (28–72) *150 (92 — 230)*
S2	E	0.200 *0,200*	0.60 *0,60*	0.0044 *0,00017*	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*	0.085 *0,0034*	37 (22 — 58) *120 (73–190)*
S3	E	0.200 *0,200*	0.60 *0,60*	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*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	32 (20 — 51) *105 (66–160)*
S11	E	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	105 (76–130) *345 (250 — 420)*
S12	E	0.300 *0,300*	1.0 *1,0*	0.0090 *0,00036*	0.018 *0,00070*	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*	80 (59–100) *260 (200 — 320)*
S13	E	0.300 *0,300*	1.0 *1,0*	0.0080 *0,00032*	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*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	65 (47 — 83) *215 (160 — 270)*
H5	M/A/D	0.0300 *0,0300*	0.60 *0,60*	0.015 *0,00060*	0.030 *0,0012*	0.044 *0,0017*	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*	0.26 *0,010*	0.30 *0,012*	85 (70–100) *280 (230 — 320)*
H8	M/A/D	0.0300 *0,0300*	0.60 *0,60*	0.012 *0,00048*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	90 (73–100) *295 (240 — 320)*
H21	M/A/D	0.0300 *0,0300*	0.60 *0,60*	0.012 *0,00048*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	90 (73–100) *295 (240 — 320)*
H31	M/A/D	0.0300 *0,0300*	0.60 *0,60*	0.010 *0,00040*	0.020 *0,00080*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	70 (57 — 81) *230 (190 — 260)*
TS1	A/D	0.300 *0,300*	1.5 *1,5*	0.0095 *0,00038*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	640 (550–740) *2100 (1900 — 2400)*
TP1	A/D	0.300 *0,300*	1.5 *1,5*	0.0095 *0,00038*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	640 (550–740) *2100 (1900 — 2400)*
GR1	A/D	0.400 *0,400*	1.0 *1,0*	0.013 *0,00050*	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*	0.25 *0,010*	630 (510–750) *2075 (1700 — 2400)*

For cutting data recalculations, see pages 447 - 454

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 Slot milling

SMG		a_p/DC	f_z												v_c
			1	2	3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0.50 *0,50*	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*	0.13 *0,0050*	170 (160–190) *560 (530 — 620)*
P2	M/A/D/E	0.50 *0,50*	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*	0.13 *0,0050*	165 (160–190) *540 (530 — 620)*
P3	M/A/D/E	0.50 *0,50*	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*	0.13 *0,0050*	145 (140–160) *475 (460 — 520)*
P4	M/A/D/E	0.50 *0,50*	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*	0.13 *0,0050*	125 (120–140) *410 (400 — 450)*
P5	M/A/D/E	0.50 *0,50*	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*	0.13 *0,0050*	120 (120–140) *395 (400 — 450)*
P6	M/A/D/E	0.50 *0,50*	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*	0.13 *0,0050*	135 (130–150) *445 (430 — 490)*
P7	M/A/D/E	0.50 *0,50*	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*	0.13 *0,0050*	125 (120–140) *410 (400 — 450)*
P8	M/A/D/E	0.50 *0,50*	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*	0.13 *0,0050*	120 (120–140) *395 (400 — 450)*
P11	M/A/D/E	0.50 *0,50*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	135 (120–150) *445 (400 — 490)*
P12	M/A/D/E	0.50 *0,50*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (70 — 89) *260 (230 — 290)*
M1	E	0.50 *0,50*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	100 (87–110) *330 (290 — 360)*
M2	E	0.50 *0,50*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (71 — 90) *260 (240 — 290)*
M3	E	0.40 *0,40*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	50 (41 — 59) *165 (140–190)*
M4	E	0.40 *0,40*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	37 (30 — 44) *120 (99–140)*
M5	E	0.40 *0,40*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	31 (25 — 37) *100 (83–120)*
K1	E	0.60 *0,60*	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*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	150 (130–150) *490 (430 — 490)*
K2	E	0.60 *0,60*	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*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	130 (120–130) *425 (400 — 420)*
K3	E	0.60 *0,60*	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*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	110 (96–110) *360 (320 — 360)*
K4	E	0.60 *0,60*	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*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	105 (91–110) *345 (300 — 360)*
K5	E	0.50 *0,50*	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*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	130 (110–140) *425 (370 — 450)*
K6	E	0.50 *0,50*	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*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	190 (170 — 200) *620 (560 — 650)*
K7	E	0.50 *0,50*	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*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	165 (150–170) *540 (500 — 550)*

For cutting data recalculations, see pages 447 - 454

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 – JS514 Slot milling

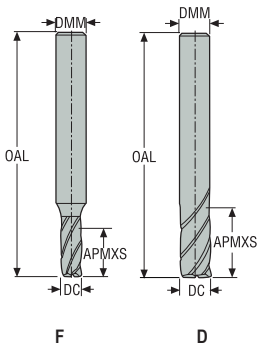
SMG		a_p/DC	f_z												v_c
			1	2	3	4	5	6	8	10	12	16	20	25	
N11	E	0.50 *0,50*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	300 (200 — 400) *980 (660–1300)*
S1	E	0.20 *0,20*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	36 (22 — 57) *120 (73–180)*
S2	E	0.20 *0,20*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	29 (18 — 46) *95 (60–150)*
S3	E	0.20 *0,20*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	25 (15 — 40) *80 (50–130)*
S11	E	0.30 *0,30*	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*	0.13 *0,0050*	90 (66–110) *295 (220 — 360)*
S12	E	0.30 *0,30*	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*	0.13 *0,0050*	70 (51 — 90) *230 (170 — 290)*
S13	E	0.30 *0,30*	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*	0.13 *0,0050*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	55 (46 — 65) *180 (160 — 210)*
H8	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	55 (46 — 65) *180 (160 — 210)*
H11	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	70 (58 — 83) *230 (200 — 270)*
H12	M/A/D	0.50 *0,50*	0.0042 *0,00017*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	55 (47 — 66) *180 (160 — 210)*
H21	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	55 (46 — 65) *180 (160 — 210)*
H31	M/A/D	0.20 *0,20*	0.0020 *0,000080*	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*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	42 (35 — 49) *140 (120–160)*
GR1	A	0.50 *0,50*	0.013 *0,00050*	0.025 *0,0010*	0.038 *0,0015*	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*	0.24 *0,0095*	500 (410 — 590) *1650 (1400–1900)*

For cutting data recalculations, see pages 447 - 454

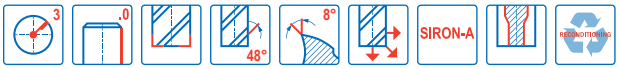
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

JS553

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



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

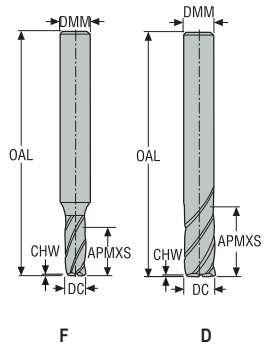


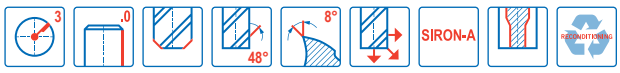
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
553020SZ3.0-SIRON-A	02733903	2	F	2,0	6,0	5,0	50,0	3	■
553030SZ3.0-SIRON-A	02733906	2	F	3,0	6,0	7,0	50,0	3	■
553040SZ3.0-SIRON-A	02733910	2	F	4,0	6,0	10,0	55,0	3	■
553050SZ3.0-SIRON-A	02733912	2	F	5,0	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





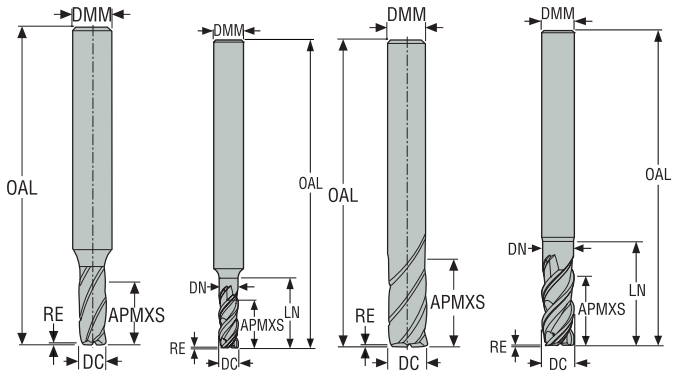
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
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	■
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



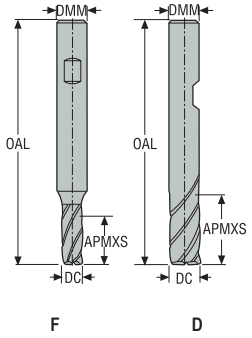
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

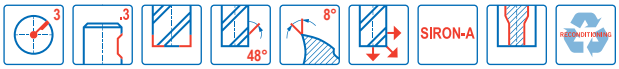
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS553020G2R050.0Z3-SIRA	02881683	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	■
553030R015Z3.0-SIRON-A	02733908	2	F	3,0	6,0	7,0	50,0	8,5	3,0	0,15	3	■
JS553030G2R050.0Z3-SIRA	02881684	2	G	3,0	6,0	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	■
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	■
553100R200Z3.0-SIRON-A	02810364	2	D	10,0	10,0	22,0	70,0	–	–	2,0	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	■
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	■
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	■
553160R250Z3.0-SIRON-A	02810371	2	D	16,0	16,0	34,0	90,0	–	–	2,5	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





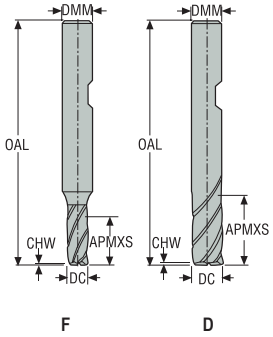
- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

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	■

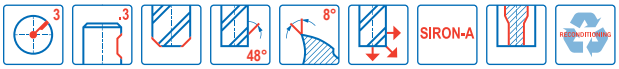
■ Stocked standard.

JS553

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



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

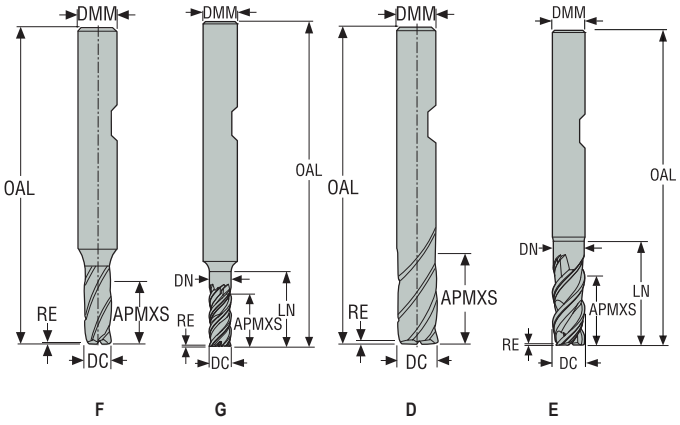


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
553020Z3.0-SIRON-AW	02697423	2	F	2,0	6,0	5,0	50,0	0,025	3	□
553025Z3.0-SIRON-AW	02700354	2	F	2,5	6,0	7,0	50,0	0,025	3	■
553030Z3.0-SIRON-AW	02700355	2	F	3,0	6,0	7,0	50,0	0,035	3	■
553035Z3.0-SIRON-AW	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	■
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



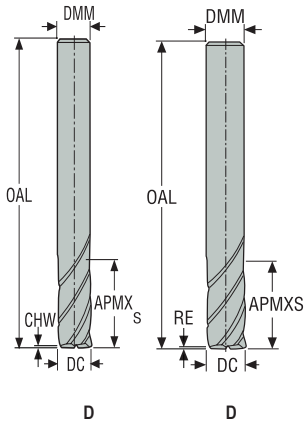
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
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	□
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	54,0	19,0	2,0	3	□
553250R100Z3.0-SIRON-AW	02700385	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	□
553250R050Z3.0-SIRON-AW	02700386	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	□

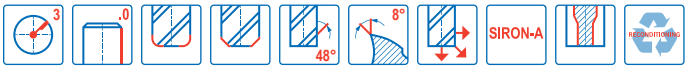
■ Stocked standard. □ Weldon available. Delivery time is 3 days.

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

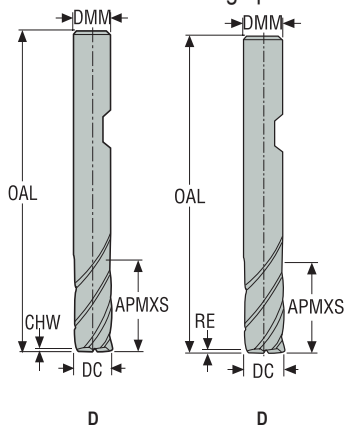


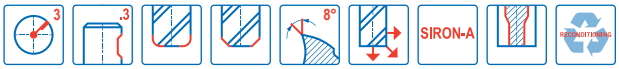
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Cylindrical
				Inch	Inch	Inch	Inch	Inch	Inch		
5530125Z3.0-SIRON-A	02712684	2	D	0.125	0.125	0.250	2.000	0.001	–	3	■
5530187Z3.0-SIRON-A	02712687	2	D	0.188	0.188	0.375	2.000	0.001	–	3	■
5530250Z3.0-SIRON-A	02712688	2	D	0.250	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 *0,400*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	220 (190 — 240) *720 (630–780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	165 (150–190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	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*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140–180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	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*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	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*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	170 (150–190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140–180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	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*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	145 (130–160) *475 (430 — 520)*
P12	M/A/D/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*	95 (82–100) *310 (270 — 320)*
M1	E	0.400 *0,400*	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*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	115 (100–120) *375 (330 — 390)*
M2	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*	95 (82–100) *310 (270 — 320)*
M3	E	0.400 *0,400*	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*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	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*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	45 (36 — 53) *150 (120–170)*
M5	E	0.400 *0,400*	1.0 *1,0*	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*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	37 (30 — 44) *120 (99–140)*
K1	E	0.400 *0,400*	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*	0.16 *0,0065*	165 (160–190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	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*	145 (140–170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	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 (120–140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	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*	120 (110–140) *395 (370 — 450)*
K5	E	0.400 *0,400*	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*	0.14 *0,0055*	0.16 *0,0065*	155 (140–170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *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*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560–720)*

For cutting data recalculations, see pages 447 - 454

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 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 447 - 454

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 447 - 454

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

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

For cutting data recalculations, see pages 447 - 454

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 447 - 454

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	
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 447 - 454

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 447 - 454

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*

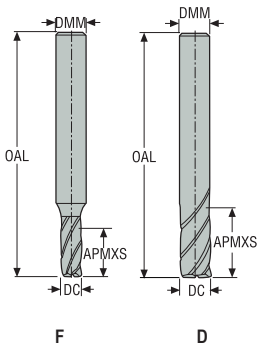
SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *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 447 - 454

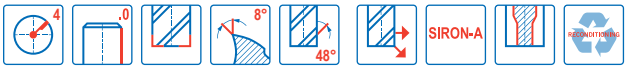
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

JS554

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



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

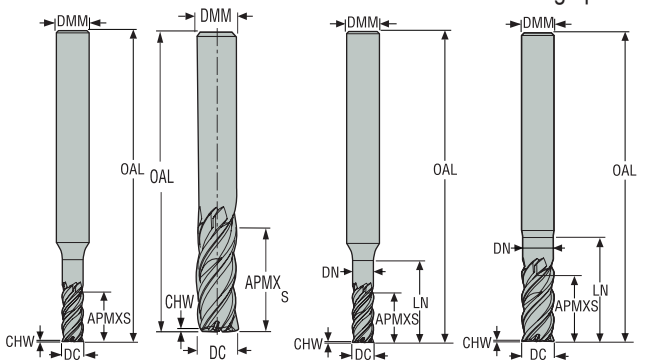


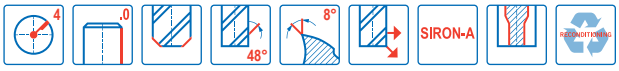
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
554030SZ4.0-SIRON-A	02733453	2	F	3,0	6,0	7,0	50,0	4	■
554040SZ4.0-SIRON-A	02733458	2	F	4,0	6,0	10,0	55,0	4	■
554050SZ4.0-SIRON-A	02733812	2	F	5,0	6,0	12,0	55,0	4	■
554060SZ4.0-SIRON-A	02733814	2	D	6,0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





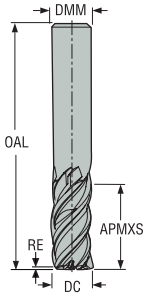
- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

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

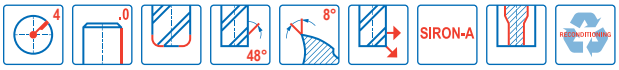
JS554

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



D

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,2 mm
- Regrind possible if DC is ≥Ø6

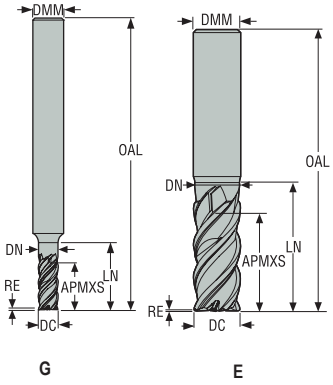


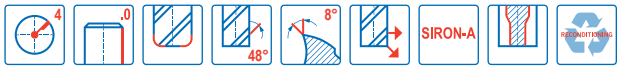
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
554060R020Z4.0-SIRON-A	02679507	2	D	6,0	6,0	14,0	55,0	0,2	4	■
554080R050Z4.0-SIRON-A	02679514	2	D	8,0	8,0	18,0	60,0	0,5	4	■
554100R050Z4.0-SIRON-A	02679540	2	D	10,0	10,0	22,0	70,0	0,5	4	■
554100R100Z4.0-SIRON-A	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





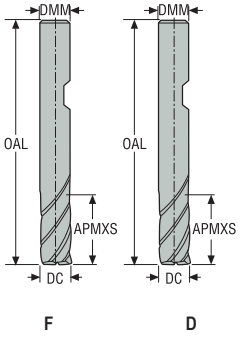
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,2 mm
- Regrind possible if DC is ≥Ø6

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	■

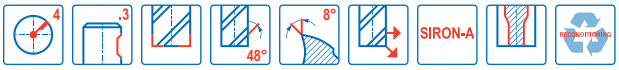
■ Stocked standard.

JS554

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



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

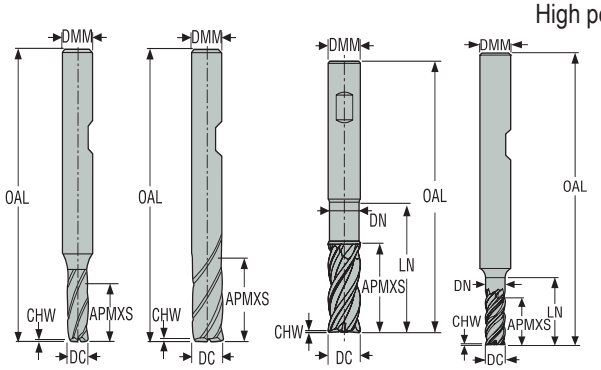


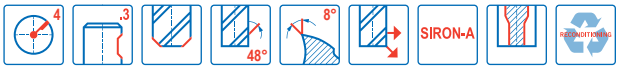
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
554030SZ4.0-SIRON-AW	02733844	2	F	3,0	6,0	7,0	50,0	4	☐
554040SZ4.0-SIRON-AW	02733846	2	F	4,0	6,0	10,0	55,0	4	☐
554050SZ4.0-SIRON-AW	02733847	2	F	5,0	6,0	12,0	55,0	4	☐
554060SZ4.0-SIRON-AW	02733848	2	D	6,0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





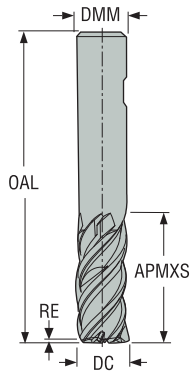
- Tolerances:
- DMM=h5
- DC=e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS554030G2C.3Z4-SIRA	03029973	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	□
554030Z4.3-SIRON-A	02733450	2	F	3,0	6,0	7,0	50,0	8,7	3,0	0,035	4	■
JS554040G2C.3Z4-SIRA	03029974	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	□
554040Z4.3-SIRON-A	02733456	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,045	4	■
JS554050G2C.3Z4-SIRA	03029975	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	□
554050Z4.3-SIRON-A	02733461	2	F	5,0	6,0	12,0	55,0	13,7	5,0	0,055	4	■
JS554060E2C.3Z4-SIRA	03029976	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	□
554060Z4.3-SIRON-A	02679502	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	■
JS554080E2C.3Z4-SIRA	03029978	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	□
554080Z4.3-SIRON-A	02679511	2	D	8,0	8,0	18,0	60,0	–	–	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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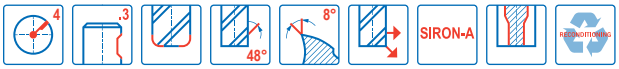


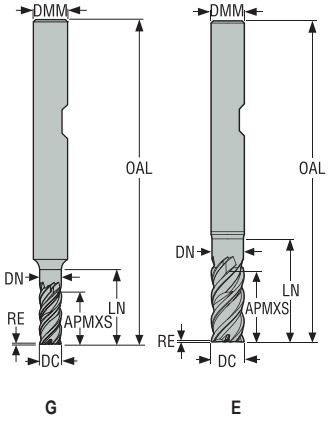
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,2 mm
- Regrind possible if DC is ≥Ø6

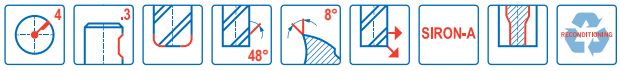
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
554060R020Z4.3-SIRON-A	02679506	2	D	6,0	6,0	14,0	55,0	0,2	4	■
554080R050Z4.3-SIRON-A	02679513	2	D	8,0	8,0	18,0	60,0	0,5	4	■
554100R050Z4.3-SIRON-A	02679539	2	D	10,0	10,0	22,0	70,0	0,5	4	■
554100R100Z4.3-SIRON-A	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





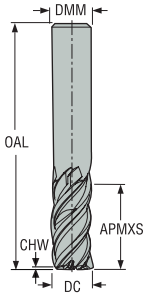
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,2 mm
- Regrind possible if DC is ≥Ø6

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.

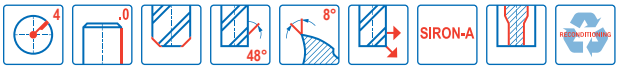
JS554

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



D

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

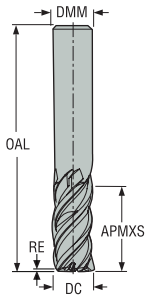


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				Inch	Inch	Inch	Inch	Inch		
5540250Z4.0-SIRON-A	02711329	2	D	0.250	0.250	0.500	2.500	0.003	4	■
5540312Z4.0-SIRON-A	02711340	2	D	0.313	0.313	0.625	2.500	0.004	4	■
5540375Z4.0-SIRON-A	02711344	2	D	0.375	0.375	0.750	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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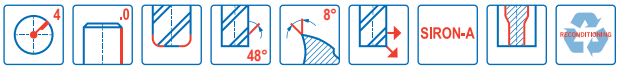


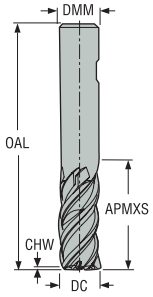
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±.0008 *inch*
- Regrind possible

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.

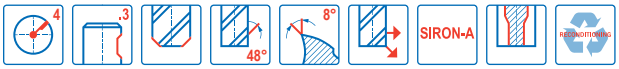
JS554

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



D

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

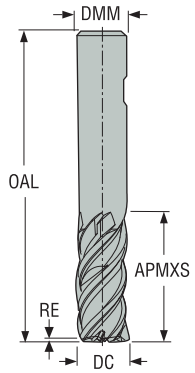


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				Inch	Inch	Inch	Inch	Inch		
5540500Z4.3-SIRON-A	02711608	2	D	0.500	0.500	1.000	3.500	0.006	4	■
5540750Z4.3-SIRON-A	02711632	2	D	0.750	0.750	1.500	4.000	0.010	4	■

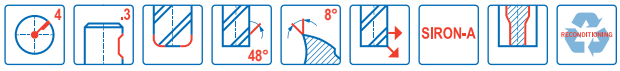
■ Stocked standard.

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 *0,400*	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*	215 (190 — 240) *710 (630–780)*
P2	M/A/D/E	0.400 *0,400*	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*	210 (190 — 240) *690 (630–780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *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*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	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*	160 (140–180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	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*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (140–170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (150–180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *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*	0.026 *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*	140 (130–150) *460 (430 — 490)*
P12	M/A/D/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 (79–100) *295 (260 — 320)*
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 (96–120) *360 (320 — 390)*
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 (79–100) *295 (260 — 320)*
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*	55 (45 — 66) *180 (150 — 210)*
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*	43 (35 — 51) *140 (120–160)*
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*	36 (29 — 42) *120 (96–130)*
K1	E	0.400 *0,400*	1.2 *1,2*	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*	0.16 *0,0065*	175 (160–190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	155 (140–170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	130 (120–140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (110–140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	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*	0.16 *0,0065*	155 (140–170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	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*	0.16 *0,0065*	195 (170 — 220) *640 (560–720)*

For cutting data recalculations, see pages 447 - 454

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 447 - 454

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 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 *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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	195 (170 — 220) *640 (560–720)*
P2	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	165 (140–180) *540 (460 — 590)*
P4	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*
P5	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	135 (120–150) *445 (400 — 490)*
P6	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	155 (140–170) *510 (460 — 550)*
P7	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*
P8	M/A/D/E	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*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	135 (120–150) *445 (400 — 490)*
P11	M/A/D/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*	130 (120–140) *425 (400 — 450)*
P12	M/A/D/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 — 87) *260 (230 — 280)*
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 (85–100) *310 (280 — 320)*
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 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	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*	48 (39 — 57) *155 (130–180)*
M4	E	0.60 *0,60*	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*	36 (29 — 43) *120 (96–140)*
M5	E	0.60 *0,60*	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 — 36) *100 (83–110)*
K1	E	1.0 *1,0*	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*	155 (140–170) *510 (460 — 550)*
K2	E	1.0 *1,0*	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*	135 (120–150) *445 (400 — 490)*
K3	E	1.0 *1,0*	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*	115 (110–120) *375 (370 — 390)*
K4	E	1.0 *1,0*	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*	110 (96–120) *360 (320 — 390)*
K5	E	0.70 *0,70*	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*	135 (120–150) *445 (400 — 490)*
K6	E	0.70 *0,70*	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*	200 (180 — 220) *660 (600–720)*
K7	E	0.70 *0,70*	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*	175 (150–190) *570 (500 — 620)*

For cutting data recalculations, see pages 447 - 454

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 447 - 454

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	
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 447 - 454

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 447 - 454

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	
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 447 - 454

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

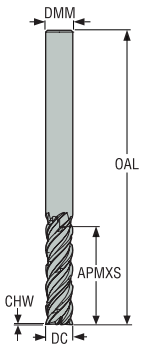
SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	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 447 - 454

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

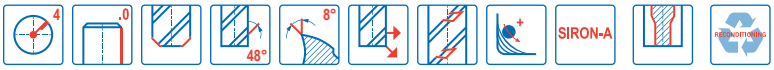
JS554-3C

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



D

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

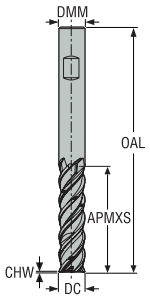


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS554060D3C.0Z4C-SIRA	02810475	3	D	■	6,0	6,0	23,0	65,0	0,075	4	■
JS554080D3C.0Z4C-SIRA	02810477	3	D	■	8,0	8,0	32,0	75,0	0,1	4	■
JS554100D3C.0Z4C-SIRA	02810479	3	D	■	10,0	10,0	40,0	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	■

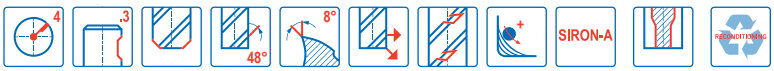
■ Stocked standard.

JS554-3C

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



D



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

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.

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 447 - 454

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

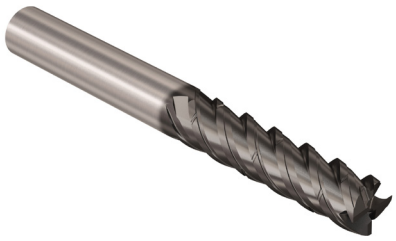
SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	750 (650 — 840) *2450 (2200 — 2700)*
N2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *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)*

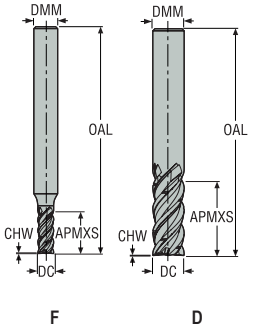
For cutting data recalculations, see pages 447 - 454

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





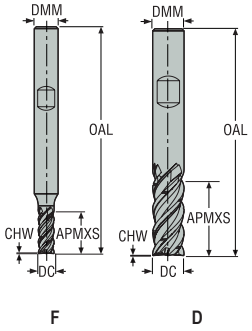
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible if DC is ≥Ø8

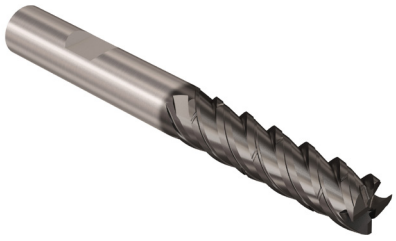
Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS564030F2C.0Z4C-NXT	03067338	2	F	■	3,0	6,0	7,0	57,0	0,04	4	■
JS564040F2C.0Z4C-NXT	03067339	2	F	■	4,0	6,0	10,0	57,0	0,05	4	■
JS564050F2C.0Z4C-NXT	03067340	2	F	■	5,0	6,0	12,5	57,0	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	■

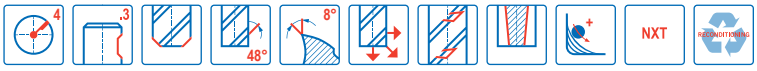
■ Stocked standard.

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.

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 447 - 454

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

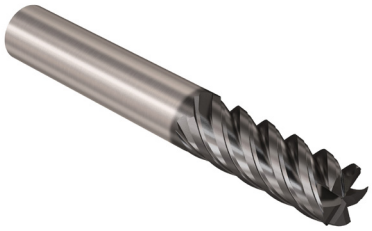
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	700 (600–790) *2300 (2000 — 2500)*
N2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *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)*

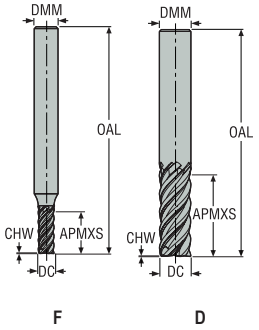
For cutting data recalculations, see pages 447 - 454

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

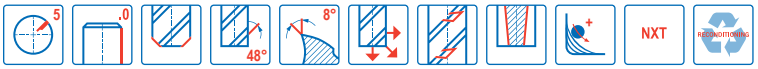
JS565

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

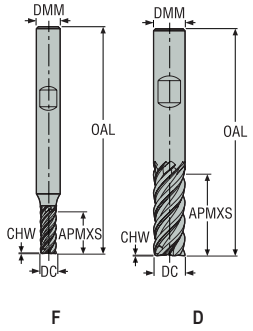


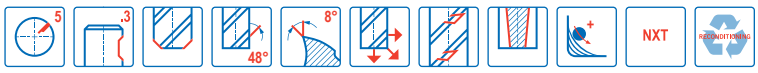
Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS565040F2C.0Z5-NXT	03067369	2	F	–	4,0	6,0	10,0	57,0	0,05	5	■
JS565040F2C.0Z5C-NXT	03067378	2	F	■	4,0	6,0	10,0	57,0	0,05	5	■
JS565050F2C.0Z5-NXT	03067370	2	F	–	5,0	6,0	12,5	57,0	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.

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 447 - 454

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

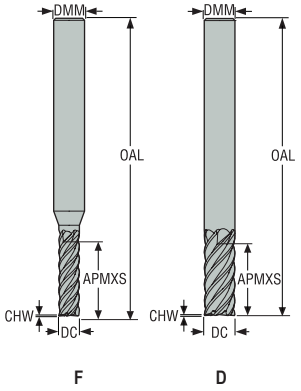
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	740 (600–790) *2425 (2000 — 2500)*
N2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *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 447 - 454

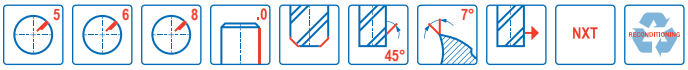
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS520

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



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

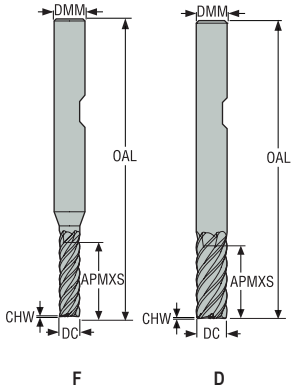


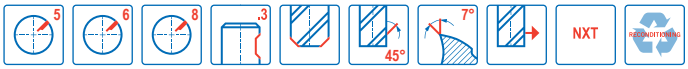
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS520040F2C.0Z5-NXT	02927474	2	F	4,0	6,0	10,0	57,0	0,04	5	■
JS520050F2C.0Z5-NXT	02927476	2	F	5,0	6,0	12,0	57,0	0,05	5	■
JS520060D2C.0Z5-NXT	02927478	2	D	6,0	6,0	15,0	57,0	0,06	5	■
JS520060D2C.0Z6-NXT	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.

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 447 - 454

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

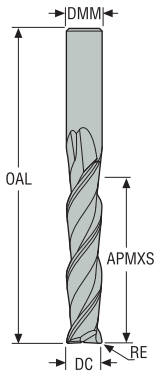
SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500–1800)*
N2	E/M/A	0.100 *0,100*	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 447 - 454

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

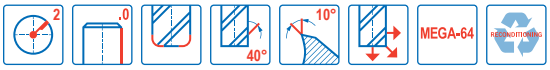
JS522

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 447 - 454

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 – JS522 Side milling semi finishing

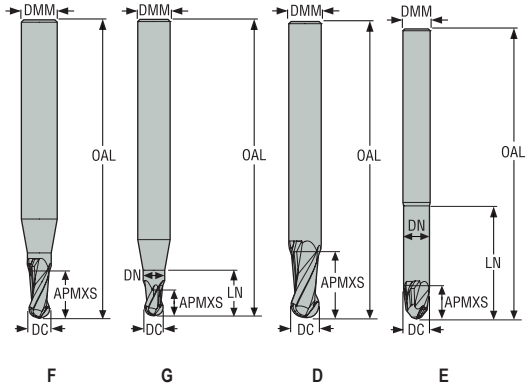
SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
N1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100–1600)*
N2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *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)*

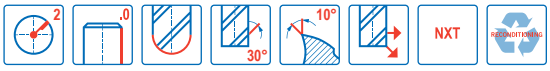
For cutting data recalculations, see pages 447 - 454

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





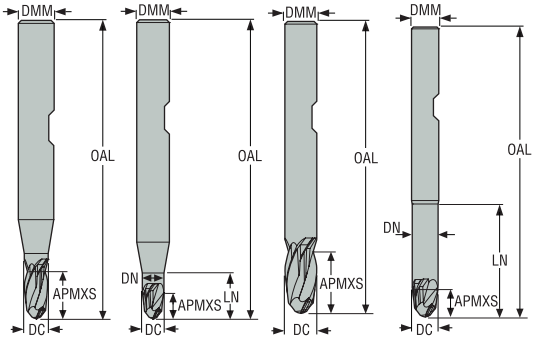
- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

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	■

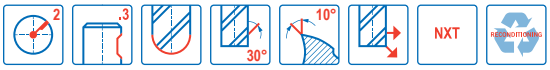
■ Stocked standard.

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 447 - 454

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

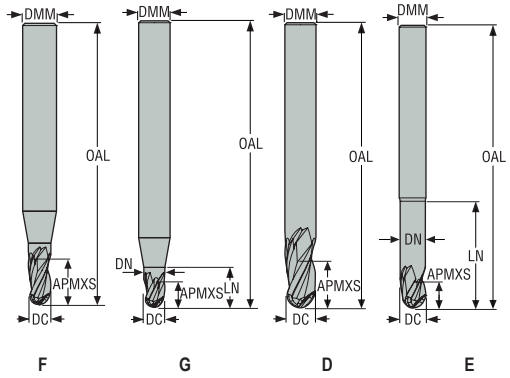
SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	610 (520–710) *2000 (1800 — 2300)*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

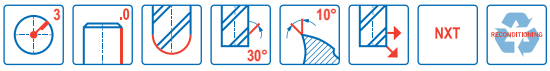
For cutting data recalculations, see pages 447 - 454

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





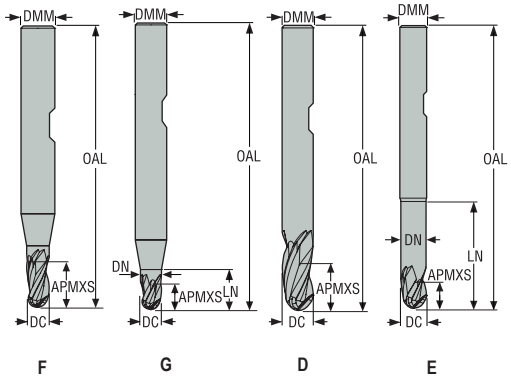
- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

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	■

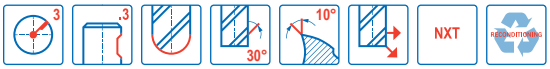
■ Stocked standard.

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 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	200 (180 — 220) *660 (600–720)*
P2	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	195 (170 — 220) *640 (560–720)*
P3	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	165 (150–180) *540 (500 — 590)*
P4	M/A/D/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*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	145 (130–160) *475 (430 — 520)*
P5	M/A/D/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*	140 (130–160) *460 (430 — 520)*
P6	M/A/D/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*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	155 (140–170) *510 (460 — 550)*
P7	M/A/D/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*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	150 (130–160) *490 (430 — 520)*
P8	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	140 (120–150) *460 (400 — 490)*
P11	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	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*	140 (130–160) *460 (430 — 520)*
P12	M/A/D/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*	85 (73 — 97) *280 (240 — 310)*
M1	E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	125 (99–140) *410 (330 — 450)*
M2	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 (80–120) *330 (270 — 390)*
M3	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*	70 (50 — 90) *230 (170 — 290)*
M4	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*	55 (38 — 67) *180 (130 — 210)*
M5	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*	44 (32 — 56) *145 (110–180)*
K1	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*	145 (130–160) *475 (430 — 520)*
K2	E	0.0300 *0,0300*	0.80 *0,80*	0.0036 *0,00014*	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*	125 (110–140) *410 (370 — 450)*
K3	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*	105 (91–110) *345 (300 — 360)*
K4	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*	120 (100–140) *395 (330 — 450)*
K5	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	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*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (61 — 84) *230 (210 — 270)*
K6	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*	105 (89–120) *345 (300 — 390)*
K7	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	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*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	155 (130–180) *510 (430 — 590)*

For cutting data recalculations, see pages 447 - 454

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 – JS533 Copy milling roughing

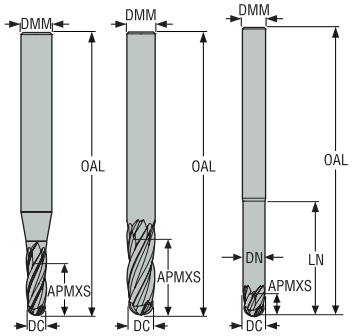
SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	800 (700 — 900) *2625 (2300 — 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)*

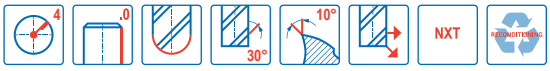
For cutting data recalculations, see pages 447 - 454

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





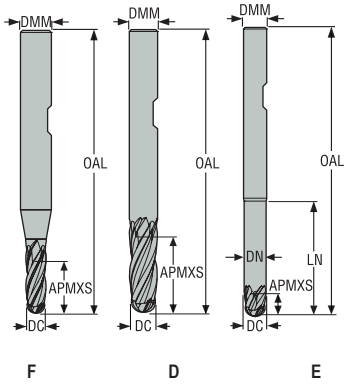
- Tolerances:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

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	■

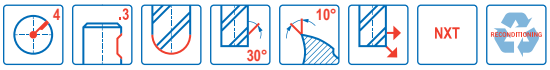
■ Stocked standard.

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 447 - 454

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 – JS534 Copy milling roughing

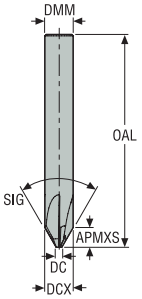
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	1025 (910–1100) *3375 (3000 — 3600)*
N2	E	0.0300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

For cutting data recalculations, see pages 447 - 454

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

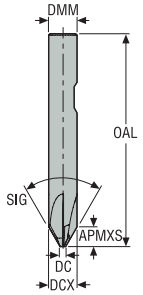
- Tolerances:
- DMM=h5
- SIG= ±0,5°
- Regrind possible if DMM is ≥Ø6

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.

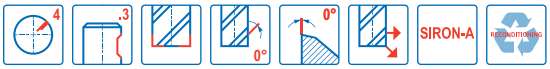
JS506

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



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	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 447 - 454

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 – JS506 Chamfering

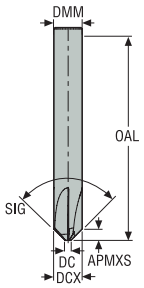
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500–1700)*
N2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	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 447 - 454

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

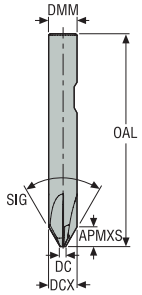
- Tolerances:
- DMM=h5
- SIG= ±0,5°
- Regrind possible if DMM is ≥Ø6

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.

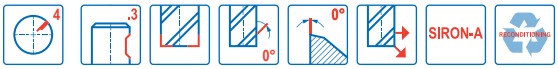
JS509

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



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	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 447 - 454

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 – JS509 Chamfering

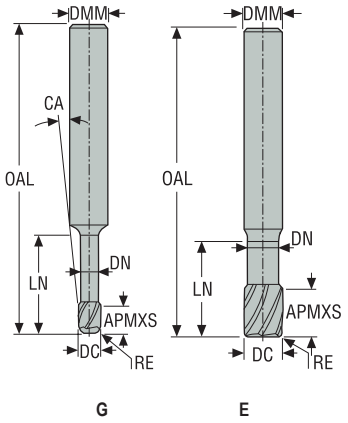
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
N2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	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 447 - 454

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



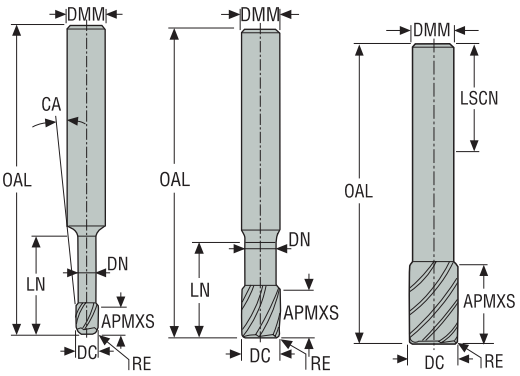
- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

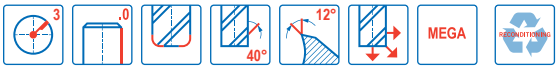
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	–		
910020R020-MEGA	00020058	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	3,5	3	■
910025R020-MEGA	00020065	2	G	2,5	3,0	4,0	40,0	6,0	2,4	0,2	2,0	3	■
910025R020-TRIBON	00020174	2	G	2,5	3,0	4,0	40,0	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	■
910060R050-TRIBON	00021539	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	■
910100R050-TRIBON	00021726	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/-0,04 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6(G+E)

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	–	6,0	0,3	–	36,0	3	■
910RS090-MEGA	00021781	4	P	9,0	8,0	11,0	100,0	–	8,0	0,5	–	36,0	3	■
910RS110-MEGA	00021782	4	P	11,0	10,0	13,0	125,0	–	10,0	0,5	–	40,0	3	■
910RS130-MEGA	00021784	4	P	13,0	12,0	16,0	150,0	–	12,0	0,6	–	45,0	3	■
910RS170-MEGA	00021800	4	P	17,0	16,0	20,0	150,0	–	16,0	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 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	455 (410 — 500) *1500 (1400–1600)*
P2	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	445 (400 — 490) *1450 (1400–1600)*
P3	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	385 (350 — 420) *1275 (1200–1300)*
P4	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	335 (300 — 370) *1100 (990–1200)*
P5	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	320 (290 — 350) *1050 (960–1100)*
P6	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	360 (330 — 400) *1175 (1100–1300)*
P7	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	340 (310 — 370) *1125 (1100–1200)*
P8	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	320 (290 — 350) *1050 (960–1100)*
P11	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	330 (300 — 360) *1075 (990–1100)*
P12	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	195 (180 — 210) *640 (600 — 680)*
M1	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	200 (180 — 220) *660 (600–720)*
M2	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	160 (150–170) *520 (500 — 550)*
M3	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	110 (91–120) *360 (300 — 390)*
M4	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	80 (68 — 94) *260 (230 — 300)*
M5	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	70 (57–78) *230 (190 — 250)*
K1	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	315 (270 — 350) *1025 (890–1100)*
K2	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	270 (240 — 310) *890 (790–1000)*
K3	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	230 (200 — 260) *750 (660 — 850)*
K4	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K5	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	280 (240 — 320) *920 (790–1000)*
K6	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	415 (350 — 480) *1350 (1200–1500)*
K7	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	355 (300 — 410) *1175 (990–1300)*
S1	E/M/A	0.0300 *0,0300*	0.70 *0,70*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	115 (93–130) *375 (310 — 420)*
S2	E/M/A	0.0300 *0,0300*	0.70 *0,70*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	95 (75–110) *310 (250 — 360)*
S3	E/M/A	0.0200 *0,0200*	0.50 *0,50*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.13 *0,0050*	0.14 *0,0055*	50 (40 — 59) *165 (140–190)*
S11	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	175 (160–190) *570 (530 — 620)*
S12	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	135 (120–150) *445 (400 — 490)*
S13	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	105 (90–110) *345 (300 — 360)*
TP1	A	0.150 *0,150*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.15 *0,0060*	205 (180 — 240) *670 (600–780)*
GR1	A	0.500 *0,500*	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	0.18 *0,0070*	610 (510–710) *2000 (1700 — 2300)*

For cutting data recalculations, see pages 447 - 454

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 – JH910 Slot milling

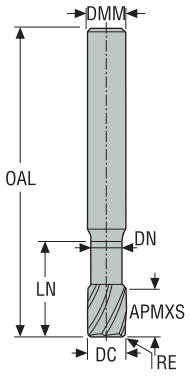
SMG		a_p/DC	f_z														v_c
			2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.30	0.010	0.015	0.020	0.025	0.030	0.036	0.040	0.046	0.050	0.055	0.060	0.065	0.080	0.085	255 (230 — 280)
		0,30	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0014*	*0,0016*	*0,0018*	*0,0020*	*0,0022*	*0,0024*	*0,0026*	*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 447 - 454

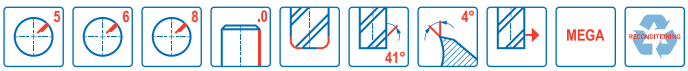
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

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 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		
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

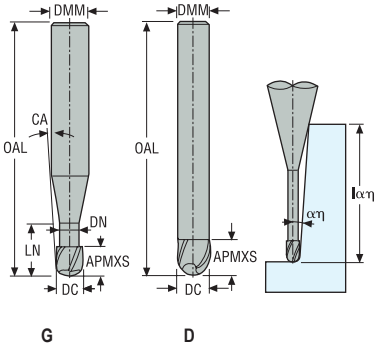
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300–1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	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)*

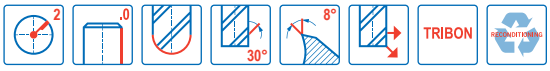
For cutting data recalculations, see pages 447 - 454

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

JH970

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





- 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	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm									
970021-TRIBON	02452881	1	G	2,0	3,0	3,0	50,0	10,0	1,9	2,5	2	10,0	11,0	11,5	12,1	12,8	–	■
970031-TRIBON	02452882	1	D	3,0	3,0	4,5	50,0	–	–	–	2	4,5	–	–	–	–	–	■
970041-TRIBON	02452883	1	D	4,0	4,0	6,0	60,0	–	–	–	2	6,0	–	–	–	–	–	■
970051-TRIBON	02452884	1	D	5,0	5,0	7,5	60,0	–	–	–	2	7,5	–	–	–	–	–	■
970061-TRIBON	02452885	1	D	6,0	6,0	9,0	75,0	–	–	–	2	9,0	–	–	–	–	–	■
970020-TRIBON	02452886	2	G	2,0	6,0	3,0	60,0	4,0	1,9	8,0	2	4,0	4,7	4,9	5,1	5,4	6,0	■
970025-TRIBON	02452887	2	G	2,5	6,0	4,0	60,0	5,0	2,4	7,5	2	5,0	5,7	6,0	6,2	6,5	7,3	■
970030-TRIBON	02452888	2	G	3,0	6,0	4,5	60,0	6,0	2,8	5,5	2	6,0	7,4	7,8	8,3	9,0	10,6	■
970035-TRIBON	02452889	2	G	3,5	6,0	5,0	60,0	7,0	3,2	4,5	2	7,0	8,8	9,4	10,0	10,7	12,8	■
970040-TRIBON	02452890	2	G	4,0	6,0	6,0	60,0	8,0	3,7	3,0	2	8,0	10,8	11,9	13,3	15,2	–	■
970050-TRIBON	02452891	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,0	2	10,0	13,6	15,0	16,8	–	–	■
970060-TRIBON	02452892	2	G	6,0	8,0	9,0	75,0	12,0	5,6	2,5	2	12,0	15,8	17,4	19,4	22,2	–	■
970080-TRIBON	02452893	2	D	8,0	8,0	12,0	75,0	–	–	–	2	12,0	–	–	–	–	–	■
970100-TRIBON	02452894	2	D	10,0	10,0	15,0	80,0	–	–	–	2	15,0	–	–	–	–	–	■
970120-TRIBON	02452895	2	D	12,0	12,0	18,0	90,0	–	–	–	2	18,0	–	–	–	–	–	■
970160-TRIBON	02452896	2	D	16,0	16,0	24,0	100,0	–	–	–	2	24,0	–	–	–	–	–	■
970L020-TRIBON	02452899	3	G	2,0	6,0	3,0	80,0	4,0	1,9	8,0	2	4,0	4,7	4,9	5,1	5,4	6,0	■
970L030-TRIBON	02452900	3	G	3,0	6,0	4,5	80,0	6,0	2,8	5,5	2	6,0	7,4	7,8	8,3	9,0	10,6	■
970L040-TRIBON	02452901	3	G	4,0	6,0	6,0	80,0	8,0	3,7	3,0	2	8,0	10,8	11,9	13,3	15,2	–	■
970L050-TRIBON	02452902	3	G	5,0	6,0	7,5	100,0	10,0	4,6	2,0	2	10,0	13,6	15,0	16,8	–	–	■
970L060-TRIBON	02452903	3	G	6,0	8,0	9,0	100,0	12,0	5,6	2,5	2	12,0	15,8	17,4	19,4	22,2	–	■
970L080-TRIBON	02452904	3	D	8,0	8,0	12,0	110,0	–	–	–	2	12,0	–	–	–	–	–	■
970L100-TRIBON	02452905	3	D	10,0	10,0	15,0	125,0	–	–	–	2	15,0	–	–	–	–	–	■
970L120-TRIBON	02452906	3	D	12,0	12,0	18,0	125,0	–	–	–	2	18,0	–	–	–	–	–	■
970L160-TRIBON	02452907	3	D	16,0	16,0	24,0	150,0	–	–	–	2	24,0	–	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

Cutting data – JH970 Copy milling roughing

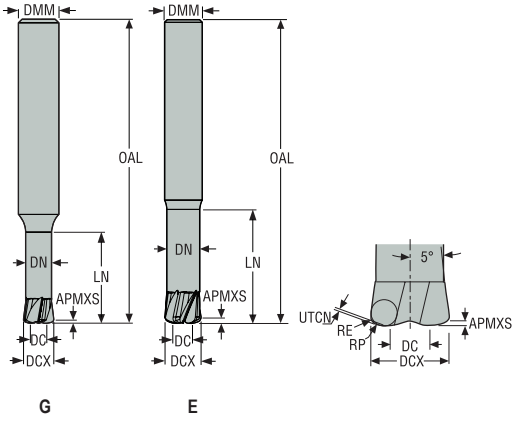
SMG		a_e/DC	a_p/DC	f_z									v_c
				2	3	4	5	6	8	10	12	16	
P1	M	0.350 *0,350*	0.070 *0,070*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	245 (220 — 270) *800 (730 — 880)*
P2	M	0.350 *0,350*	0.070 *0,070*	0.040 *0,0016*	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*	240 (210 — 270) *790 (690 — 880)*
P3	M	0.350 *0,350*	0.070 *0,070*	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*	205 (180 — 230) *670 (600–750)*
P4	M	0.350 *0,350*	0.070 *0,070*	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*	180 (160 — 200) *590 (530 — 650)*
P5	M	0.350 *0,350*	0.070 *0,070*	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*	170 (150–190) *560 (500 — 620)*
P6	M	0.350 *0,350*	0.070 *0,070*	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*	195 (170 — 210) *640 (560 — 680)*
P7	M	0.350 *0,350*	0.070 *0,070*	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*	185 (160 — 200) *610 (530 — 650)*
P8	M	0.350 *0,350*	0.070 *0,070*	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*	170 (150–190) *560 (500 — 620)*
P11	M	0.350 *0,350*	0.070 *0,070*	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*	180 (160 — 200) *590 (530 — 650)*
P12	M	0.350 *0,350*	0.070 *0,070*	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*	105 (91–110) *345 (300 — 360)*
M1	M	0.170 *0,170*	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*	95 (85–110) *310 (280 — 360)*
M2	M	0.170 *0,170*	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*	0.15 *0,0060*	80 (69 — 89) *260 (230 — 290)*
M3	M	0.130 *0,130*	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*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (57–76) *215 (190 — 240)*
M4	M	0.130 *0,130*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	50 (44 — 59) *165 (150–190)*
M5	M	0.130 *0,130*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	43 (37 — 49) *140 (130–160)*
S1	E	0.150 *0,150*	0.065 *0,065*	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*	50 (42 — 62) *165 (140 — 200)*
S2	E	0.150 *0,150*	0.065 *0,065*	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*	42 (34 — 50) *140 (120–160)*
S3	E	0.120 *0,120*	0.060 *0,060*	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*	31 (21 — 41) *100 (69–130)*
S11	E	0.350 *0,350*	0.15 *0,15*	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*	105 (89–110) *345 (300 — 360)*
S12	E	0.350 *0,350*	0.15 *0,15*	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*	80 (69 — 91) *260 (230 — 290)*
S13	E	0.350 *0,350*	0.15 *0,15*	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*	60 (54–70) *195 (180 — 220)*

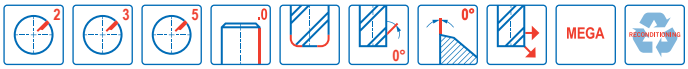
For cutting data recalculations, see pages 447 - 454

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





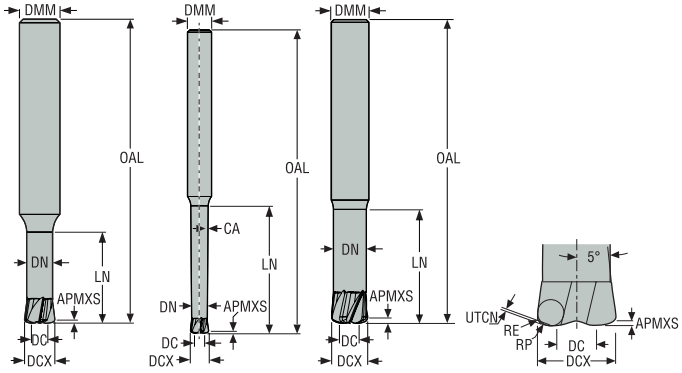
- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- CA= collision angle
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CEDC	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	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	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	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	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	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	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	■
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	■
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	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	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	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/-0,04 mm
- RE= ±0,05 mm
- CA= collision angle
- 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	CEDC	Cylindrical
				mm	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 447 - 454

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 – JHF980 Slot milling

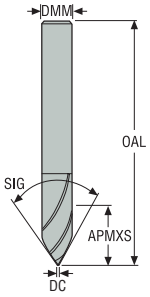
SMG		a_p/DCX	f_z										v_c
			1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	340 (310 — 370) *1125 (1100–1200)*
P2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *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 447 - 454

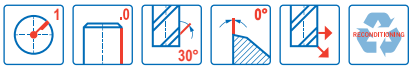
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (sf/min)
f_z = mm/tooth (*in*/tooth)
a_p = mm/DC (*in*/DC) = factor
a_e = mm/DC (*in*/DC) = factor
All cutting data are target values

J29

General purpose – Universal – Engraving – 1 Flute – Cylindrical



D



- Tolerances:
- DMM=h5
- Regrind possible if DC 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 447 - 454

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

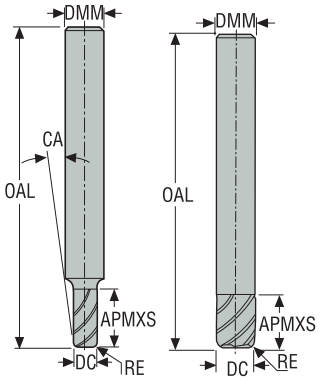
SMG		a_p/DC	f_z			v_c
			3	4	6	
N1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
N2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	19 (15 — 29) *60 (50 — 95)*
N3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	13 (9.8–19) *43 (33 — 62)*
N11	E	0.50 *0,50*	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)*

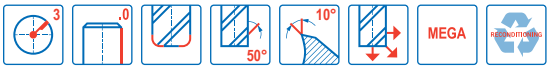
For cutting data recalculations, see pages 447 - 454

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	■
36140-MEGA	00025684	2	D	14,0	14,0	30,0	90,0	0,5	–	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	14	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*	0.085 *0,0034*	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*	0.090 *0,0036*	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*	0.085 *0,0034*	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*	0.080 *0,0032*	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*	0.080 *0,0032*	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*	0.080 *0,0032*	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*	0.080 *0,0032*	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*	0.085 *0,0034*	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*	0.080 *0,0032*	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*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	90 (79–100) *295 (260 — 320)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.014 *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*	120 (93–140) *395 (310 — 450)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	95 (77–110) *310 (260 — 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*	0.065 *0,0026*	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*	0.060 *0,0024*	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*	0.060 *0,0024*	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*	0.080 *0,0032*	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*	0.075 *0,0030*	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*	0.075 *0,0030*	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*	0.075 *0,0030*	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*	0.065 *0,0026*	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*	0.075 *0,0030*	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*	0.065 *0,0026*	0.070 *0,0028*	0.085 *0,0034*	80 (67 — 89) *260 (220 — 290)*

For cutting data recalculations, see pages 447 - 454

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

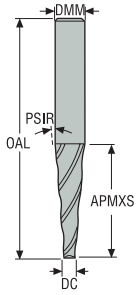
SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	620 (520–710) *2025 (1800 — 2300)*
N2	E	0.400 *0,400*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	395 (340 — 460) *1300 (1200–1500)*
N3	E	0.400 *0,400*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.300 *0,300*	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*	305 (260 — 350) *1000 (860–1100)*
S1	E	0.100 *0,100*	1.0 *0,90*	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*	0.040 *0,0016*	0.044 *0,0017*	0.050 *0,0020*	75 (62 — 85) *245 (210 — 270)*
S2	E	0.100 *0,100*	1.0 *0,90*	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*	0.040 *0,0016*	0.044 *0,0017*	0.050 *0,0020*	60 (50 — 68) *195 (170 — 220)*
S3	E	0.100 *0,100*	1.0 *0,90*	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*	0.026 *0,0010*	0.030 *0,0012*	0.034 *0,0013*	40 (30 — 49) *130 (99–160)*
S11	E	0.250 *0,250*	1.1 *1,1*	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*	105 (91–110) *345 (300 — 360)*
S12	E	0.250 *0,250*	1.1 *1,1*	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*	80 (70 — 89) *260 (230 — 290)*
S13	E	0.250 *0,250*	1.1 *1,1*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	65 (56–71) *215 (190 — 230)*
TS1	A	0.400 *0,400*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600–1800)*
TP1	A	0.400 *0,400*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600–1800)*

For cutting data recalculations, see pages 447 - 454

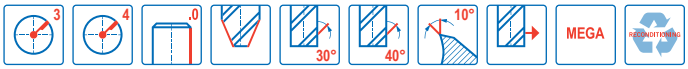
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

HK

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



N



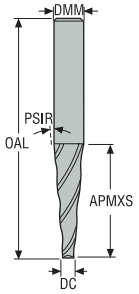
- Tolerances:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DMM is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm			
HK010-040-MEGA	00028431	2	N	4,0	5,0	20,0	60,0	1,0	3	■
HK010-060-MEGA	00028441	2	N	6,0	8,0	30,0	75,0	1,0	3	■
HK010-080-MEGA	00028445	2	N	8,0	10,0	30,0	80,0	1,0	4	■
HK010-100-MEGA	00028451	2	N	10,0	12,0	30,0	80,0	1,0	4	■

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

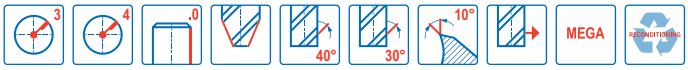
HK

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



N

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

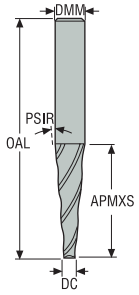


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm	–		
HK020-040-MEGA	00028666	2	N	4,0	6,0	20,0	65,0	2,0	3	■
HK020-050-MEGA	00028669	2	N	5,0	8,0	30,0	75,0	2,0	3	■
HK020-100-MEGA	00028694	2	N	10,0	12,0	28,0	80,0	2,0	4	■

■ 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

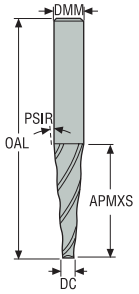
- Tolerances:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DMM is ≥Ø6

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

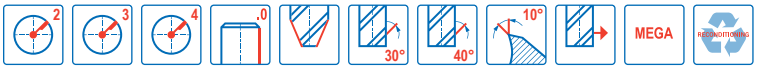
HKM-HK

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 DMM is ≥Ø6

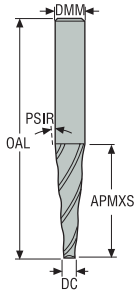


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm	–		
HKM050-010-MEGA	00028947	2	N	1,0	3,0	4,0	40,0	5,0	2	■
HKM050-015-MEGA	00028952	2	N	1,5	3,0	6,0	40,0	5,0	2	■
HKM050-020-MEGA	00028954	2	N	2,0	4,0	10,0	50,0	5,0	2	■
HKM050-025-MEGA	00028958	2	N	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	■

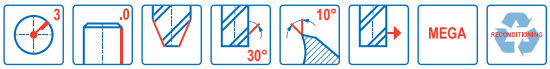
■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

HK

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



N



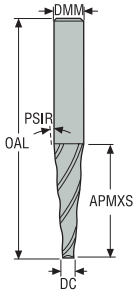
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DMM is ≥Ø6

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

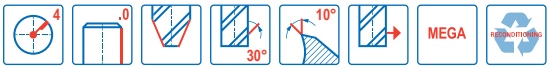
HK

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



N

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

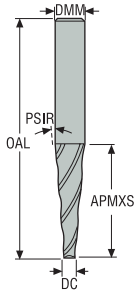


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm	–		
HK080-083-MEGA	00029041	2	N	8,0	18,0	35,0	90,0	8,0	4	■

■ 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

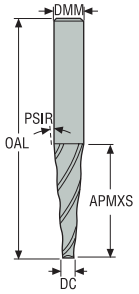
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DMM is ≥Ø6

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

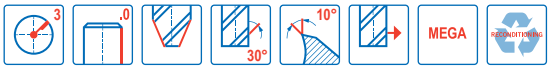
HK

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



N

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

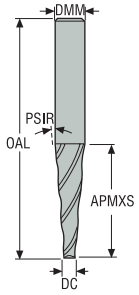


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Cylindrical
				mm	mm	mm	mm	–		
HK110-020-MEGA	00029110	2	N	2,0	10,0	20,0	75,0	11,0	3	■
HK110-050-MEGA	00029117	2	N	5,0	14,0	20,0	80,0	11,0	3	■

■ 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



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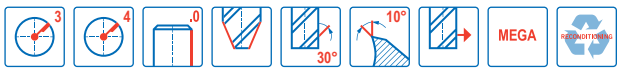


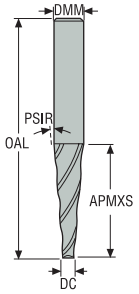
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DMM is ≥Ø6

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	■
HK150-0652	00029138	2	N	6,5	20,0	25,0	90,0	15,0	3	■
HK150-0651-MEGA	00029160	2	N	6,5	12,0	10,0	65,0	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

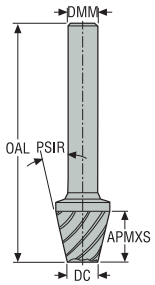
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DMM is ≥Ø6

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

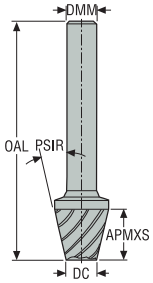
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DMM is ≥Ø6

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

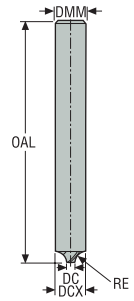
- Tolerances:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Regrind possible if DMM is ≥Ø6

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	■

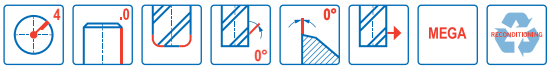
■ Stocked standard.
For cutting data, please see My Pages – Suggest on www.secotools.com

V31

General purpose – Universal – Concave – 4 Flutes – Cylindrical



D



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

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/D_c	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 page 447-454

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min
f_z = mm
a_p/D_c = mm
All cutting data are target values

Cutting data – V31 Side milling roughing

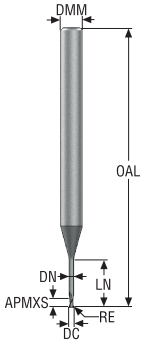
SMG		a_p/D_c	f_z								v_c
			6	8	10	12	16	20	25	28	
N1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	315 (215 — 340) *1025 (710–1125)*
N2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *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 page 447-454

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min
f_z = mm
a_p/D_c = mm
All cutting data are target values

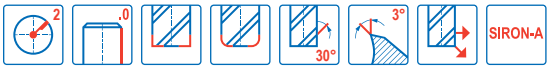
JME542

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	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	–	2	14,41	0,56	0,63	0,69	0,75	0,81	0,91	■
JME542003G1S.0Z2-SIRA	03171096	1	G	0,3	4,0	0,45	45,0	0,6	0,28	–	2	14,0	0,76	0,85	0,92	0,99	1,06	1,17	■
JME542004G1S.0Z2-SIRA	03171128	1	G	0,4	4,0	0,6	45,0	0,8	0,37	–	2	13,5	1,12	1,19	1,26	1,32	1,38	1,49	■
JME542005G1R005.0Z2-SIRA	03171097	1	G	0,5	4,0	0,8	45,0	1,0	0,46	0,05	2	13,17	1,32	1,4	1,47	1,54	1,61	1,73	■
JME542006G1R005.0Z2-SIRA	03171098	1	G	0,6	4,0	0,9	45,0	1,2	0,56	0,05	2	12,76	1,52	1,61	1,69	1,77	1,84	1,97	■
JME542008G1R005.0Z2-SIRA	03171129	1	G	0,8	4,0	1,2	45,0	1,6	0,76	0,05	2	11,96	1,92	2,03	2,13	2,22	2,3	2,46	■
JME542010G1R010.0Z2-SIRA	03171099	1	G	1,0	4,0	1,5	50,0	2,0	0,95	0,1	2	11,22	2,32	2,45	2,56	2,65	2,74	2,94	■
JME542012G1R010.0Z2-SIRA	03171100	1	G	1,2	4,0	1,8	50,0	2,4	1,15	0,1	2	10,43	2,77	2,87	2,99	3,1	3,2	3,43	■
JME542015G1R015.0Z2-SIRA	03171130	1	G	1,5	4,0	2,3	50,0	3,0	1,45	0,15	2	9,2	3,47	3,61	3,73	3,85	3,98	4,26	■
JME542005G3R005.0Z2-SIRA	03171102	3	G	0,5	4,0	0,8	45,0	2,5	0,46	0,05	2	11,03	2,82	2,98	3,1	3,21	3,32	3,56	■
JME542006G3R005.0Z2-SIRA	03171103	3	G	0,6	4,0	0,9	45,0	3,0	0,56	0,05	2	10,36	3,32	3,5	3,64	3,76	3,89	4,18	■
JME542008G3R005.0Z2-SIRA	03171131	3	G	0,8	4,0	1,2	45,0	4,0	0,76	0,05	2	9,14	4,32	4,54	4,7	4,86	5,03	5,4	■
JME542010G3R010.0Z2-SIRA	03171104	3	G	1,0	4,0	1,5	50,0	5,0	0,95	0,1	2	8,09	5,32	5,58	5,77	5,96	6,16	6,61	■
JME542012G3R010.0Z2-SIRA	03171105	3	G	1,2	4,0	1,8	50,0	6,0	1,15	0,1	2	7,13	6,32	6,62	6,83	7,06	7,3	7,84	■
JME542015G3R015.0Z2-SIRA	03171132	3	G	1,5	4,0	2,3	50,0	7,5	1,45	0,15	2	5,89	7,82	8,16	8,43	8,7	9,0	9,66	■
JME542020G3R015.0Z2-SIRA	03171106	3	G	2,0	4,0	3,0	50,0	10,0	1,94	0,15	2	4,14	10,47	10,83	11,18	11,55	11,95	12,83	■
JME542025G3R015.0Z2-SIRA	03171108	3	G	2,5	4,0	3,8	50,0	12,5	2,4	0,15	2	2,79	12,97	13,41	13,84	14,3	14,79	–	■
JME542030G3R015.0Z2-SIRA	03171134	3	G	3,0	4,0	4,5	60,0	15,0	2,85	0,15	2	1,67	15,68	16,17	16,69	17,24	–	–	■
JME542005G4R005.0Z2-SIRA	03171109	4	G	0,5	4,0	0,8	45,0	4,0	0,46	0,05	2	9,49	4,32	4,54	4,7	4,86	5,03	5,4	■
JME542006G4R005.0Z2-SIRA	03171110	4	G	0,6	4,0	0,9	45,0	5,0	0,56	0,05	2	8,56	5,32	5,58	5,77	5,96	6,17	6,62	■
JME542008G4R005.0Z2-SIRA	03171135	4	G	0,8	4,0	1,2	45,0	7,0	0,76	0,05	2	7,05	7,32	7,65	7,9	8,16	8,44	9,07	■
JME542010G4R010.0Z2-SIRA	03171111	4	G	1,0	4,0	1,5	50,0	8,5	0,95	0,1	2	6,1	8,82	9,2	9,49	9,81	10,15	10,9	■
JME542012G4R010.0Z2-SIRA	03171112	4	G	1,2	4,0	1,8	50,0	10,0	1,15	0,1	2	5,27	10,32	10,75	11,09	11,46	11,85	12,73	■
JME542015G4R015.0Z2-SIRA	03171136	4	G	1,5	4,0	2,3	50,0	12,0	1,45	0,15	2	4,29	12,47	12,9	13,31	13,75	14,22	15,27	■
JME542020G4R015.0Z2-SIRA	03171113	4	G	2,0	4,0	3,0	60,0	16,0	1,94	0,15	2	2,9	16,47	17,02	17,57	18,15	18,78	–	■
JME542025G4R015.0Z2-SIRA	03171114	4	G	2,5	4,0	3,8	60,0	20,0	2,4	0,15	2	1,88	20,47	21,15	21,83	22,55	–	–	■
JME542030G4R015.0Z2-SIRA	03171137	4	G	3,0	4,0	4,5	70,0	24,0	2,85	0,15	2	1,1	24,68	25,45	26,27	–	–	–	■
JME542015G5R015.0Z2-SIRA	03171115	5	G	1,5	4,0	2,3	60,0	15,0	1,45	0,15	2	3,64	15,47	15,99	16,5	17,05	17,64	18,95	■
JME542020G5R015.0Z2-SIRA	03171116	5	G	2,0	4,0	3,0	60,0	20,0	1,94	0,15	2	2,41	20,47	21,15	21,83	22,55	23,33	–	■
JME542025G5R015.0Z2-SIRA	03171138	5	G	2,5	4,0	3,8	70,0	25,0	2,4	0,15	2	1,54	25,47	26,3	27,15	28,06	–	–	■
JME542030G5R015.0Z2-SIRA	03171117	5	G	3,0	4,0	4,5	70,0	30,0	2,85	0,15	2	0,9	30,68	31,64	–	–	–	–	■
JME542015G6R015.0Z2-SIRA	03171118	6	G	1,5	4,0	2,3	70,0	22,5	1,45	0,15	2	2,64	22,97	23,73	24,49	25,29	26,18	–	■
JME542020G6R015.0Z2-SIRA	03171139	6	G	2,0	4,0	3,0	70,0	30,0	1,94	0,15	2	1,7	30,47	31,46	32,48	33,56	–	–	■
JME542025G6R015.0Z2-SIRA	03171119	6	G	2,5	4,0	3,8	80,0	37,5	2,4	0,15	2	1,07	37,97	39,2	40,46	–	–	–	■
JME542030G6R015.0Z2-SIRA	03171120	6	G	3,0	4,0	4,5	90,0	45,0	2,85	0,15	2	0,61	45,68	47,11	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

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

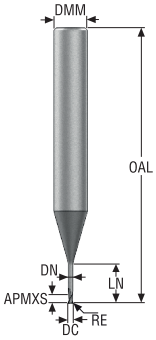
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255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

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

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

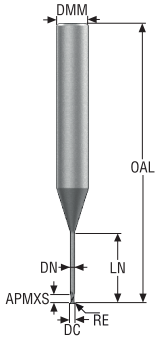
- Tolerances:
- Run-out= <0,007 mm
- DMM= h5
- DC= Ø0,5-Ø3,0= 0,-0,013 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	13,48	1,82	1,93	2,02	2,1	2,18	2,34	■
JME562006G2R005.0Z2-SIRA	03171146	2	G	0,6	6,0	0,9	50,0	2,0	0,56	0,05	2	12,9	2,32	2,45	2,56	2,66	2,75	2,95	■
JME562008G2R005.0Z2-SIRA	03171147	2	G	0,8	6,0	1,2	50,0	2,5	0,76	0,05	2	12,28	2,82	2,98	3,1	3,21	3,32	3,56	■
JME562010G2R010.0Z2-SIRA	03171148	2	G	1,0	6,0	1,5	50,0	4,0	0,95	0,1	2	10,85	4,32	4,54	4,7	4,86	5,02	5,39	■
JME562012G2R010.0Z2-SIRA	03171150	2	G	1,2	6,0	1,8	50,0	4,5	1,15	0,1	2	10,31	4,82	5,06	5,23	5,41	5,59	6,0	■
JME562015G2R015.0Z2-SIRA	03171151	2	G	1,5	6,0	2,3	50,0	5,0	1,45	0,15	2	9,67	5,47	5,68	5,86	6,05	6,25	6,71	■
JME562018G2R015.0Z2-SIRA	03171152	2	G	1,8	6,0	2,7	50,0	5,4	1,75	0,15	2	9,12	5,87	6,09	6,28	6,49	6,71	7,2	■
JME562020G2R015.0Z2-SIRA	03171153	2	G	2,0	6,0	3,0	50,0	6,0	1,94	0,15	2	8,53	6,47	6,71	6,92	7,15	7,39	7,93	■
JME562025G2R015.0Z2-SIRA	03171154	2	G	2,5	6,0	3,8	60,0	7,5	2,4	0,15	2	7,15	7,97	8,26	8,52	8,8	9,1	9,77	■
JME562030G2R015.0Z2-SIRA	03171155	2	G	3,0	6,0	4,5	60,0	9,0	2,85	0,15	2	5,81	9,68	9,98	10,3	10,64	11,01	11,82	■
JME562005G4R005.0Z2-SIRA	03171156	4	G	0,5	6,0	0,8	50,0	3,5	0,46	0,05	2	11,54	3,82	4,02	4,17	4,31	4,46	4,79	■
JME562006G4R005.0Z2-SIRA	03171157	4	G	0,6	6,0	0,9	50,0	4,2	0,56	0,05	2	10,93	4,52	4,75	4,92	5,08	5,26	5,64	■
JME562008G4R005.0Z2-SIRA	03171158	4	G	0,8	6,0	1,2	50,0	5,6	0,76	0,05	2	9,81	5,92	6,2	6,41	6,62	6,85	7,36	■
JME562010G4R010.0Z2-SIRA	03171159	4	G	1,0	6,0	1,5	50,0	7,0	0,95	0,1	2	8,86	7,32	7,65	7,9	8,16	8,44	9,06	■
JME562012G4R010.0Z2-SIRA	03171160	4	G	1,2	6,0	1,8	50,0	8,4	1,15	0,1	2	8,0	8,72	9,1	9,39	9,7	10,03	10,77	■
JME562015G4R015.0Z2-SIRA	03171162	4	G	1,5	6,0	2,3	50,0	10,5	1,45	0,15	2	6,86	10,97	11,35	11,71	12,1	12,52	13,44	■
JME562020G4R015.0Z2-SIRA	03171163	4	G	2,0	6,0	3,0	60,0	14,0	1,94	0,15	2	5,36	14,47	14,96	15,44	15,95	16,5	17,72	■
JME562025G4R015.0Z2-SIRA	03171164	4	G	2,5	6,0	3,8	65,0	17,5	2,4	0,15	2	4,18	17,97	18,57	19,17	19,8	20,49	22,0	■
JME562030G4R015.0Z2-SIRA	03171165	4	G	3,0	6,0	4,5	70,0	21,0	2,85	0,15	2	3,22	21,68	22,36	23,08	23,85	24,67	26,5	■
JME562005G5R005.0Z2-SIRA	03171166	5	G	0,5	6,0	0,8	50,0	5,0	0,46	0,05	2	10,42	5,32	5,58	5,77	5,96	6,17	6,62	■
JME562006G5R005.0Z2-SIRA	03171167	5	G	0,6	6,0	0,9	50,0	6,0	0,56	0,05	2	9,71	6,32	6,62	6,83	7,06	7,31	7,85	■
JME562008G5R005.0Z2-SIRA	03171168	5	G	0,8	6,0	1,2	50,0	8,0	0,76	0,05	2	8,48	8,32	8,68	8,96	9,26	9,58	10,29	■
JME562010G5R010.0Z2-SIRA	03171169	5	G	1,0	6,0	1,5	50,0	10,0	0,95	0,1	2	7,48	10,32	10,75	11,09	11,46	11,85	12,73	■
JME562012G5R010.0Z2-SIRA	03171170	5	G	1,2	6,0	1,8	50,0	12,0	1,15	0,1	2	6,62	12,32	12,81	13,22	13,66	14,13	15,18	■
JME562015G5R015.0Z2-SIRA	03171171	5	G	1,5	6,0	2,3	60,0	15,0	1,45	0,15	2	5,54	15,47	15,99	16,5	17,05	17,64	18,95	■
JME562020G5R015.0Z2-SIRA	03171172	5	G	2,0	6,0	3,0	60,0	20,0	1,94	0,15	2	4,19	20,47	21,15	21,83	22,55	23,33	25,06	■
JME562025G5R015.0Z2-SIRA	03171173	5	G	2,5	6,0	3,8	70,0	25,0	2,4	0,15	2	3,19	25,47	26,3	27,15	28,06	29,03	31,18	■
JME562030G5R015.0Z2-SIRA	03171174	5	G	3,0	6,0	4,5	70,0	30,0	2,85	0,15	2	2,41	30,68	31,64	32,66	33,75	34,92	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

JME562

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



G

- Tolerances:
- Run-out= <0,007 mm
- DMM= h5
- DC= Ø1,0-Ø3,0= 0,-0,013 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	5,94	15,32	15,9	16,41	16,96	17,55	18,85	■
JME562012G6R010.0Z2-SIRA	03171176	6	G	1,2	6,0	1,8	60,0	18,0	1,15	0,1	2	5,14	18,32	19,0	19,61	20,26	20,96	22,52	■
JME562015G6R015.0Z2-SIRA	03171177	6	G	1,5	6,0	2,3	70,0	22,5	1,45	0,15	2	4,2	22,97	23,73	24,49	25,31	26,18	28,12	■
JME562020G6R015.0Z2-SIRA	03171178	6	G	2,0	6,0	3,0	80,0	30,0	1,94	0,15	2	3,07	30,47	31,46	32,48	33,56	34,72	37,3	■
JME562025G6R015.0Z2-SIRA	03171179	6	G	2,5	6,0	3,8	80,0	37,5	2,4	0,15	2	2,28	37,97	39,2	40,46	41,81	43,26	–	■
JME562030G6R015.0Z2-SIRA	03171180	6	G	3,0	6,0	4,5	90,0	45,0	2,85	0,15	2	1,7	45,68	47,11	48,63	50,26	–	–	■
JME562010G7R010.0Z2-SIRA	03171181	7	G	1,0	6,0	1,5	60,0	20,0	0,95	0,1	2	4,93	20,32	21,06	21,74	22,46	23,24	24,97	■
JME562012G7R010.0Z2-SIRA	03171182	7	G	1,2	6,0	1,8	80,0	24,0	1,15	0,1	2	4,2	24,32	25,18	26,0	26,87	27,79	29,86	■
JME562015G7R015.0Z2-SIRA	03171183	7	G	1,5	6,0	2,3	80,0	30,0	1,45	0,15	2	3,38	30,47	31,46	32,48	33,56	34,72	37,3	■
JME562020G7R015.0Z2-SIRA	03171184	7	G	2,0	6,0	3,0	80,0	40,0	1,94	0,15	2	2,42	40,47	41,78	43,12	44,56	46,11	–	■
JME562025G7R015.0Z2-SIRA	03171185	7	G	2,5	6,0	3,8	90,0	50,0	2,4	0,15	2	1,78	50,47	52,09	53,77	55,57	–	–	■
JME562030G7R015.0Z2-SIRA	03171186	7	G	3,0	6,0	4,5	100,0	60,0	2,85	0,15	2	1,31	60,68	62,58	64,61	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

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

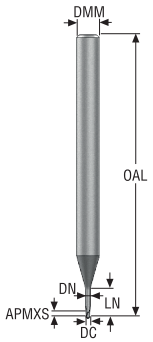
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255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

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

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= Ø0,-0,01 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	14,57	0,56	0,62	0,67	0,73	0,78	0,88	■
JMB542003G1B.0Z2-SIRA	03171222	1	G	0,3	4,0	0,3	45,0	0,6	0,28	0,15	2	14,24	0,76	0,83	0,9	0,96	1,02	1,13	■
JMB542004G1B.0Z2-SIRA	03171223	1	G	0,4	4,0	0,4	45,0	0,8	0,37	0,2	2	13,81	1,12	1,18	1,24	1,29	1,35	1,45	■
JMB542005G1B.0Z2-SIRA	03171224	1	G	0,5	4,0	0,5	45,0	1,0	0,46	0,25	2	13,47	1,32	1,39	1,45	1,51	1,57	1,68	■
JMB542006G1B.0Z2-SIRA	03171225	1	G	0,6	4,0	0,6	45,0	1,2	0,56	0,3	2	13,14	1,52	1,59	1,67	1,73	1,8	1,92	■
JMB542008G1B.0Z2-SIRA	03171226	1	G	0,8	4,0	0,8	45,0	1,6	0,76	0,4	2	12,46	1,92	2,01	2,1	2,17	2,25	2,39	■
JMB542010G1B.0Z2-SIRA	03171228	1	G	1,0	4,0	1,0	50,0	2,0	0,95	0,5	2	11,77	2,23	2,43	2,52	2,61	2,69	2,85	■
JMB542012G1B.0Z2-SIRA	03171229	1	G	1,2	4,0	1,2	50,0	2,4	1,15	0,6	2	11,07	2,72	2,84	2,95	3,04	3,13	3,32	■
JMB542015G1B.0Z2-SIRA	03171230	1	G	1,5	4,0	1,5	50,0	3,0	1,45	0,75	2	9,88	3,47	3,59	3,69	3,79	3,89	4,13	■
JMB542005G3B.0Z2-SIRA	03171231	3	G	0,5	4,0	0,5	45,0	2,5	0,46	0,25	2	11,25	2,82	2,97	3,09	3,19	3,29	3,52	■
JMB542006G3B.0Z2-SIRA	03171233	3	G	0,6	4,0	0,6	45,0	3,0	0,56	0,3	2	10,61	3,32	3,49	3,62	3,74	3,86	4,12	■
JMB542008G3B.0Z2-SIRA	03171234	3	G	0,8	4,0	0,8	45,0	4,0	0,76	0,4	2	9,44	4,32	4,53	4,68	4,83	4,98	5,32	■
JMB542010G3B.0Z2-SIRA	03171235	3	G	1,0	4,0	1,0	50,0	5,0	0,95	0,5	2	8,38	5,32	5,56	5,74	5,92	6,11	6,53	■
JMB542012G3B.0Z2-SIRA	03171236	3	G	1,2	4,0	1,2	50,0	6,0	1,15	0,6	2	7,44	6,32	6,6	6,8	7,01	7,23	7,73	■
JMB542015G3B.0Z2-SIRA	03171237	3	G	1,5	4,0	1,5	50,0	7,5	1,45	0,75	2	6,13	7,97	8,24	8,48	8,74	9,02	9,64	■
JMB542020G3B.0Z2-SIRA	03171238	3	G	2,0	4,0	2,0	50,0	10,0	1,94	1,0	2	4,4	10,47	10,81	11,13	11,47	11,83	12,64	■
JMB542025G3B.0Z2-SIRA	03171239	3	G	2,5	4,0	2,5	50,0	12,5	2,4	1,25	2	3,0	12,97	13,38	13,77	14,19	14,64	–	■
JMB542030G3B.0Z2-SIRA	03171240	3	G	3,0	4,0	3,0	60,0	15,0	2,85	1,5	2	1,81	15,68	16,13	16,6	17,11	–	–	■
JMB542005G4B.0Z2-SIRA	03171241	4	G	0,5	4,0	0,5	45,0	4,0	0,46	0,25	2	9,65	4,32	4,53	4,69	4,84	5,0	5,36	■
JMB542006G4B.0Z2-SIRA	03171242	4	G	0,6	4,0	0,6	45,0	5,0	0,56	0,3	2	8,74	5,32	5,57	5,75	5,94	6,13	6,57	■
JMB542008G4B.0Z2-SIRA	03171243	4	G	0,8	4,0	0,8	45,0	7,0	0,76	0,4	2	7,23	7,32	7,64	7,88	8,13	8,4	8,99	■
JMB542010G4B.0Z2-SIRA	03171244	4	G	1,0	4,0	1,0	50,0	8,5	0,95	0,5	2	6,27	8,82	9,19	9,47	9,77	10,09	10,81	■
JMB542012G4B.0Z2-SIRA	03171245	4	G	1,2	4,0	1,2	50,0	10,0	1,15	0,6	2	5,44	10,32	10,73	11,06	11,41	11,79	12,62	■
JMB542015G4B.0Z2-SIRA	03171246	4	G	1,5	4,0	1,5	50,0	12,0	1,45	0,75	2	4,44	12,47	12,88	13,27	13,69	14,14	15,14	■
JMB542020G4B.0Z2-SIRA	03171247	4	G	2,0	4,0	2,0	60,0	16,0	1,94	1,0	2	3,02	16,47	17,0	17,51	18,07	18,66	19,98	■
JMB542025G4B.0Z2-SIRA	03171248	4	G	2,5	4,0	2,5	60,0	20,0	2,4	1,25	2	1,97	20,47	21,11	21,76	22,45	–	–	■
JMB542030G4B.0Z2-SIRA	03171249	4	G	3,0	4,0	3,0	70,0	24,0	2,85	1,5	2	1,16	24,68	25,41	26,19	–	–	–	■
JMB542015G5B.0Z2-SIRA	03171250	5	G	1,5	4,0	1,5	60,0	15,0	1,45	0,75	2	3,75	15,47	15,97	16,47	16,99	17,56	18,81	■
JMB542020G5B.0Z2-SIRA	03171251	5	G	2,0	4,0	2,0	60,0	20,0	1,94	1,0	2	2,5	20,47	21,12	21,77	22,47	23,22	–	■
JMB542025G5B.0Z2-SIRA	03171252	5	G	2,5	4,0	2,5	70,0	25,0	2,4	1,25	2	1,61	25,47	26,27	27,08	27,95	–	–	■
JMB542030G5B.0Z2-SIRA	03171253	5	G	3,0	4,0	3,0	70,0	30,0	2,85	1,5	2	0,93	30,68	31,6	–	–	–	–	■
JMB542015G6B.0Z2-SIRA	03171254	6	G	1,5	4,0	1,5	70,0	22,5	1,45	0,75	2	2,7	22,97	23,71	24,45	25,25	26,1	–	■
JMB542020G6B.0Z2-SIRA	03171255	6	G	2,0	4,0	2,0	70,0	30,0	1,94	1,0	2	1,74	30,47	31,43	32,42	33,48	–	–	■
JMB542025G6B.0Z2-SIRA	03171256	6	G	2,5	4,0	2,5	80,0	37,5	2,4	1,25	2	1,1	37,97	39,16	40,39	–	–	–	■
JMB542030G6B.0Z2-SIRA	03171257	6	G	3,0	4,0	3,0	90,0	45,0	2,85	1,5	2	0,63	45,68	47,07	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

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

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

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

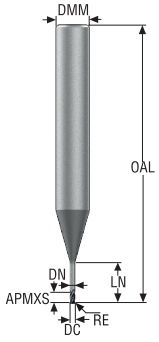
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255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

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

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= 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	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	4	13,48	1,82	1,93	2,02	2,1	2,18	2,34	■
JME564006G2R005.0Z4-SIRA	03227271	2	G	0,6	6,0	1,2	50,0	2,0	0,56	0,05	4	12,9	2,32	2,45	2,56	2,66	2,75	2,95	■
JME564008G2R005.0Z4-SIRA	03171194	2	G	0,8	6,0	1,6	50,0	2,5	0,76	0,05	4	12,28	2,82	2,98	3,1	3,21	3,32	3,56	■
JME564010G2R010.0Z4-SIRA	03171195	2	G	1,0	6,0	2,0	50,0	4,0	0,95	0,1	4	10,85	4,32	4,54	4,7	4,86	5,02	5,39	■
JME564012G2R010.0Z4-SIRA	03171196	2	G	1,2	6,0	2,4	50,0	4,5	1,15	0,1	4	10,31	4,82	5,06	5,23	5,41	5,59	6,0	■
JME564015G2R015.0Z4-SIRA	03171197	2	G	1,5	6,0	3,0	50,0	5,0	1,45	0,15	4	9,67	5,47	5,68	5,86	6,05	6,25	6,71	■
JME564020G2R015.0Z4-SIRA	03171198	2	G	2,0	6,0	4,0	50,0	6,0	1,94	0,15	4	8,53	6,47	6,71	6,92	7,15	7,39	7,93	■
JME564025G2R015.0Z4-SIRA	03171199	2	G	2,5	6,0	5,0	60,0	7,5	2,4	0,15	4	7,15	7,97	8,26	8,52	8,8	9,1	9,77	■
JME564030G2R015.0Z4-SIRA	03171200	2	G	3,0	6,0	6,0	60,0	9,0	2,85	0,15	4	5,81	9,68	9,98	10,3	10,64	11,01	11,82	■
JME564005G4R005.0Z4-SIRA	03171201	4	G	0,5	6,0	1,0	50,0	3,5	0,46	0,05	4	11,54	3,82	4,02	4,17	4,32	4,46	4,79	■
JME564006G4R005.0Z4-SIRA	03171202	4	G	0,6	6,0	1,2	50,0	4,2	0,56	0,05	4	10,93	4,52	4,75	4,92	5,08	5,26	5,64	■
JME564008G4R005.0Z4-SIRA	03171203	4	G	0,8	6,0	1,6	50,0	5,6	0,76	0,05	4	9,81	5,92	6,2	6,41	6,62	6,85	7,36	■
JME564010G4R010.0Z4-SIRA	03171204	4	G	1,0	6,0	2,0	50,0	7,0	0,95	0,1	4	8,86	7,32	7,65	7,9	8,16	8,44	9,06	■
JME564012G4R010.0Z4-SIRA	03171205	4	G	1,2	6,0	2,4	50,0	8,4	1,15	0,1	4	8,0	8,72	9,1	9,39	9,7	10,03	10,77	■
JME564015G4R015.0Z4-SIRA	03171206	4	G	1,5	6,0	3,0	50,0	10,5	1,45	0,15	4	6,86	10,97	11,35	11,71	12,1	12,52	13,44	■
JME564020G4R015.0Z4-SIRA	03171207	4	G	2,0	6,0	4,0	60,0	14,0	1,94	0,15	4	5,36	14,47	14,96	15,44	15,95	16,5	17,72	■
JME564025G4R015.0Z4-SIRA	03171208	4	G	2,5	6,0	5,0	60,0	17,5	2,4	0,15	4	4,18	17,97	18,57	19,17	19,8	20,49	22,0	■
JME564030G4R015.0Z4-SIRA	03171209	4	G	3,0	6,0	6,0	70,0	21,0	2,85	0,15	4	3,22	21,68	22,36	23,08	23,85	24,67	26,5	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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) 447 - 454

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 – JME564 Slot milling

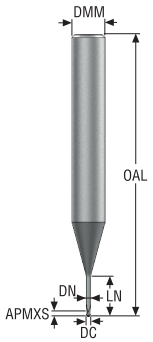
SMG		a_p/DC	f_z									v_c
			0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P2	M/E/A	0.038 *0,038*	0.0065 *0,00026*	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) 447 - 454

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 – DMM6 – Cylindrical



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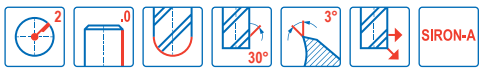


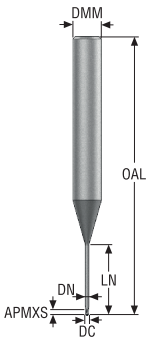
- Tolerances:
- Run-out=<0,007 mm
- DMM= h5
- DC= Ø0,-0,01 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	13,69	1,82	1,91	2,0	2,08	2,15	2,3	■
JMB562006G2B.0Z2-SIRA	03171262	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	2	13,13	2,32	2,44	2,54	2,63	2,72	2,9	■
JMB562008G2B.0Z2-SIRA	03171263	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	2	12,6	2,82	2,96	3,07	3,18	3,27	3,49	■
JMB562010G2B.0Z2-SIRA	03171264	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	2	11,15	4,32	4,52	4,68	4,68	4,97	5,3	■
JMB562012G2B.0Z2-SIRA	03171265	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	2	10,67	4,82	5,04	5,2	5,36	5,52	5,89	■
JMB562015G2B.0Z2-SIRA	03171266	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	2	10,07	5,47	5,66	5,82	5,99	6,17	6,58	■
JMB562018G2B.0Z2-SIRA	03171267	2	G	1,8	6,0	1,8	50,0	5,4	1,75	0,9	2	9,61	5,87	6,07	6,23	6,41	6,61	7,03	■
JMB562020G2B.0Z2-SIRA	03171268	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	2	9,05	6,47	6,68	6,87	7,06	7,28	7,75	■
JMB562025G2B.0Z2-SIRA	03171269	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	2	7,71	7,97	8,22	8,45	8,69	8,95	9,53	■
JMB562030G2B.0Z2-SIRA	03171270	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	2	6,35	9,68	9,94	10,21	10,51	10,82	11,52	■
JMB562005G4B.0Z2-SIRA	03171271	4	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	2	11,7	3,82	4,01	4,16	4,29	4,43	4,74	■
JMB562006G4B.0Z2-SIRA	03171272	4	G	0,6	6,0	0,6	50,0	4,2	0,56	0,3	2	11,1	4,52	4,74	4,9	5,06	5,22	5,59	■
JMB562008G4B.0Z2-SIRA	03171273	4	G	0,8	6,0	0,8	50,0	5,6	0,76	0,4	2	10,02	5,92	6,19	6,39	6,59	6,8	7,28	■
JMB562010G4B.0Z2-SIRA	03171274	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	2	9,06	7,32	7,64	7,87	8,12	8,38	8,97	■
JMB562012G4B.0Z2-SIRA	03171275	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	2	8,22	8,72	9,08	9,35	9,65	9,96	10,66	■
JMB562015G4B.0Z2-SIRA	03171276	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	2	7,07	10,97	11,33	11,67	12,04	12,43	13,31	■
JMB562020G4B.0Z2-SIRA	03171277	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	2	5,57	14,47	14,93	15,38	15,87	16,38	17,54	■
JMB562025G4B.0Z2-SIRA	03171278	4	G	2,5	6,0	2,5	65,0	17,5	2,4	1,25	2	4,38	17,97	18,53	19,1	19,69	20,34	21,76	■
JMB562030G4B.0Z2-SIRA	03171279	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	2	3,38	21,68	22,32	22,99	23,71	24,49	26,21	■
JMB562005G5B.0Z2-SIRA	03171280	5	G	0,5	6,0	0,5	50,0	5,0	0,46	0,25	2	10,54	5,32	5,57	5,76	5,94	6,14	6,58	■
JMB562006G5B.0Z2-SIRA	03171281	5	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	2	9,85	6,32	6,61	6,82	7,04	7,27	7,79	■
JMB562008G5B.0Z2-SIRA	03171282	5	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	2	8,64	8,32	8,67	8,94	9,23	9,54	10,22	■
JMB562010G5B.0Z2-SIRA	03171283	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	2	7,63	10,32	10,73	11,06	11,42	11,8	12,64	■
JMB562012G5B.0Z2-SIRA	03171284	5	G	1,2	6,0	1,2	50,0	12,0	1,15	0,6	2	6,77	12,32	12,79	13,19	13,61	14,06	15,07	■
JMB562015G5B.0Z2-SIRA	03171285	5	G	1,5	6,0	1,5	60,0	15,0	1,45	0,75	2	5,68	15,47	15,97	16,47	16,99	17,56	18,81	■
JMB562020G5B.0Z2-SIRA	03171287	5	G	2,0	6,0	2,0	60,0	20,0	1,94	1,0	2	4,32	20,47	21,12	21,77	22,47	23,22	24,88	■
JMB562025G5B.0Z2-SIRA	03171288	5	G	2,5	6,0	2,5	70,0	25,0	2,4	1,25	2	3,3	25,47	26,27	27,08	27,95	28,88	30,94	■
JMB562030G5B.0Z2-SIRA	03171289	5	G	3,0	6,0	3,0	70,0	30,0	2,85	1,5	2	2,5	30,68	31,6	32,58	33,62	34,73	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

JMB562

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



G

- Tolerances:
- Run-out=<0,007 mm
- DMM= h5
- DC= Ø0,-0,01 mm
- RE= ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	6,04	15,32	15,89	16,39	16,92	17,49	18,76	■
JMB562012G6B.0Z2-SIRA	03171291	6	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	2	5,24	18,32	18,98	19,58	20,21	20,89	22,41	■
JMB562015G6B.0Z2-SIRA	03171292	6	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	2	4,28	22,97	23,71	24,45	25,25	26,1	27,99	■
JMB562020G6B.0Z2-SIRA	03171293	6	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	2	3,14	30,47	31,43	32,42	33,48	34,6	37,11	■
JMB562025G6B.0Z2-SIRA	03171294	6	G	2,5	6,0	2,5	80,0	37,5	2,4	1,25	2	2,34	37,97	39,16	40,39	41,7	43,11	–	■
JMB562030G6B.0Z2-SIRA	03171295	6	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	2	1,74	45,68	47,07	48,55	50,13	–	–	■
JMB562010G7B.0Z2-SIRA	03171296	7	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	2	4,99	20,32	21,05	21,71	22,42	23,19	24,88	■
JMB562012G7B.0Z2-SIRA	03171297	7	G	1,2	6,0	1,2	80,0	24,0	1,15	0,6	2	4,27	24,32	25,17	25,97	26,82	27,73	29,75	■
JMB562015G7B.0Z2-SIRA	03171298	7	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	2	3,43	30,47	31,44	32,44	33,5	34,64	37,17	■
JMB562020G7B.0Z2-SIRA	03171299	7	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2	2,47	40,47	41,75	43,07	44,48	45,99	–	■
JMB562025G7B.0Z2-SIRA	03171300	7	G	2,5	6,0	2,5	90,0	50,0	2,4	1,25	2	1,81	50,47	52,05	53,7	55,46	–	–	■
JMB562030G7B.0Z2-SIRA	03171301	7	G	3,0	6,0	3,0	100,0	60,0	2,85	1,5	2	1,34	60,68	62,54	64,52	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

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

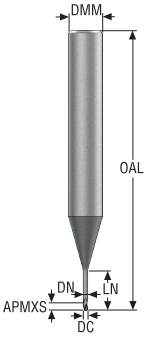
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255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

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

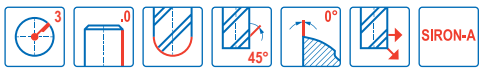
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JMB563

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



G



- Tolerances:
- Run-out=<0,007 mm
- DMM= h5
- DC= Ø0,-0,02 mm
- RE= ±0,01 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	3	11,15	4,32	4,52	4,68	4,68	4,97	5,3	■
JMB563012G2B.0Z3-SIRA	03171308	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	3	10,67	4,82	5,04	5,2	5,36	5,52	5,89	■
JMB563015G2B.0Z3-SIRA	03171309	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	3	10,07	5,47	5,66	5,82	5,99	6,17	6,58	■
JMB563020G2B.0Z3-SIRA	03171310	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	3	9,05	6,47	6,68	6,87	7,06	7,28	7,75	■
JMB563025G2B.0Z3-SIRA	03171311	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	3	7,71	7,97	8,22	8,45	8,69	8,95	9,53	■
JMB563030G2B.0Z3-SIRA	03171312	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	3	6,35	9,68	9,94	10,21	10,51	10,83	11,52	■
JMB563010G4B.0Z3-SIRA	03171316	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	3	9,06	7,32	7,64	7,87	8,12	8,38	8,97	■
JMB563012G4B.0Z3-SIRA	03171317	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	3	8,22	8,72	9,08	9,35	9,65	9,96	10,66	■
JMB563015G4B.0Z3-SIRA	03171318	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	3	7,07	10,97	11,33	11,67	12,04	12,43	13,31	■
JMB563020G4B.0Z3-SIRA	03171319	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	3	5,57	14,47	14,93	15,38	15,87	16,38	17,54	■
JMB563025G4B.0Z3-SIRA	03171320	4	G	2,5	6,0	2,5	60,0	17,5	2,4	1,25	3	4,38	17,97	18,53	19,1	19,69	20,34	21,76	■
JMB563030G4B.0Z3-SIRA	03171321	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3	3,38	21,68	22,32	22,99	23,71	24,49	26,21	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	370 (340 — 410) *1225 (1200–1300)*
P2	M/E/A	0.0500 *0,0500*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	360 (330 — 400) *1175 (1100–1300)*
P3	M/E/A	0.0500 *0,0500*	0.11 *0,11*	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)*
P4	M/E/A	0.0500 *0,0500*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (250 — 300) *900 (830 — 980)*
P5	M/E/A	0.0500 *0,0500*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	260 (240 — 290) *850 (790 — 950)*
P6	M/E/A	0.0500 *0,0500*	0.11 *0,11*	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)*
P7	M/E/A	0.0500 *0,0500*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (250 — 300) *900 (830 — 980)*
P8	M/E/A	0.0500 *0,0500*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	260 (240 — 290) *850 (790 — 950)*
P11	M/E/A	0.0500 *0,0500*	0.11 *0,11*	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 (240 — 290) *890 (790 — 950)*
P12	M/E/A	0.0500 *0,0500*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (150–170) *520 (500 — 550)*
M1	E/M/A	0.0250 *0,0250*	0.11 *0,11*	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)*
M2	E/M/A	0.0250 *0,0250*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M3	E/M/A	0.0250 *0,0250*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M4	E/M/A	0.0250 *0,0250*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (110–150) *425 (370 — 490)*
M5	E/M/A	0.0250 *0,0250*	0.11 *0,11*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (90–120) *360 (300 — 390)*
N1	E/M/A	0.100 *0,100*	0.50 *0,50*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.036 *0,0014*	0.040 *0,0016*	500 (440 — 560) *1650 (1500–1800)*
N2	E/M/A	0.100 *0,100*	0.50 *0,50*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	500 (440 — 560) *1650 (1500–1800)*
N3	E/M/A	0.100 *0,100*	0.50 *0,50*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	335 (300 — 370) *1100 (990–1200)*
N11	E/M/A	0.100 *0,100*	0.50 *0,50*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	440 (380 — 500) *1450 (1300–1600)*
S11	E/M/A	0.0250 *0,0250*	0.26 *0,26*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (260 — 340) *980 (860–1100)*
S12	E/M/A	0.0250 *0,0250*	0.26 *0,26*	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 (200 — 260) *750 (660 — 850)*
S13	E/M/A	0.0250 *0,0250*	0.26 *0,26*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (160 — 200) *590 (530 — 650)*
H3	M/A	0.0250 *0,0250*	0.028 *0,028*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	125 (93–150) *410 (310 — 490)*
H5	M/A	0.0500 *0,0500*	0.070 *0,070*	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 (210 — 260) *750 (690 — 850)*
H7	M/A	0.0250 *0,0250*	0.028 *0,028*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	125 (93–150) *410 (310 — 490)*
H8	M/A	0.0500 *0,0500*	0.070 *0,070*	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 (210 — 260) *750 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.070 *0,070*	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)*
H12	M/A	0.0500 *0,0500*	0.070 *0,070*	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 (240 — 300) *890 (790 — 980)*
H21	M/A	0.0500 *0,0500*	0.070 *0,070*	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 (210 — 260) *750 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.070 *0,070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160–190) *570 (530 — 620)*
GR1	A	0.500 *0,500*	0.24 *0,24*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	385 (330 — 430) *1275 (1100–1400)*

Table based on LV1, please recalc based on length version chosen. See page(s) 447 - 454

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.
- JH970, JH112, JH150, JH160 for ball-nose type.

Tool selection Steel and cast iron

					
Name		JHP993	JHP951	JH142	JH970
Page(s)		186	194	196, 357	199
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

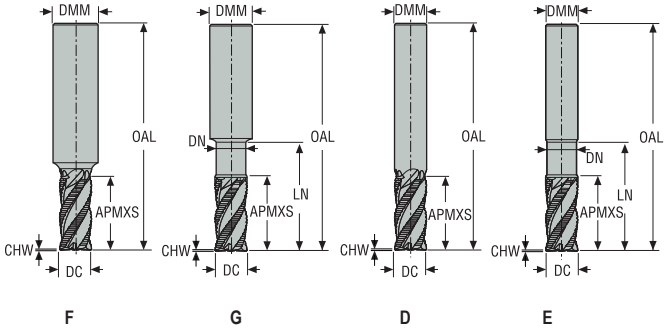
Tool selection Steel and cast iron

				
Name		JH112	JH150	JH160
Page(s)		201, 360	363	365
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		●	●	

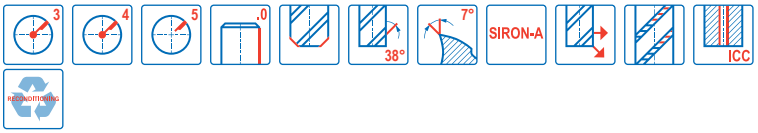
■ Stock standard □ Weldon available, delivery time is 3 days.
● Preferred choice ○ Alternative choice

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

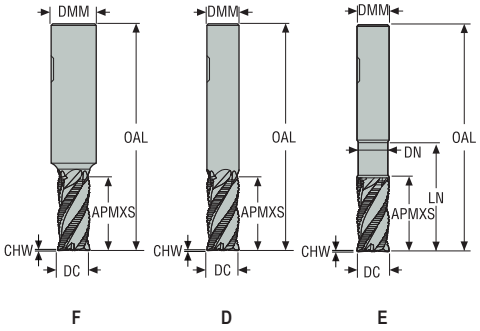


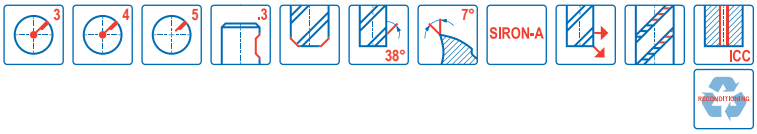
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JHP993040F2C.0Z3-SIRA	02826806	2	F	–	4,0	6,0	10,0	50,0	12,56	4,0	0,15	3	■
JHP993050F2C.0Z4-SIRA	02826808	2	F	–	5,0	6,0	12,0	55,0	14,75	5,0	0,15	4	■
JHP993060D2C.0Z4-SIRA	02826809	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	–	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	–	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	–	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. ICC = Internal Coolant Channel

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	–	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	–	9,5	0,2	4	■
JHP993100D2C.3Z4A-SIRA	02828247	2	D	■	10,0	10,0	20,0	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.
ICC = Internal Coolant Channel

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 447 - 454

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 and PCEDC=6

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 page 447-454

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min
f_z = mm
a_p/D_c = mm
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 447 - 454

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 and PCEDC=6

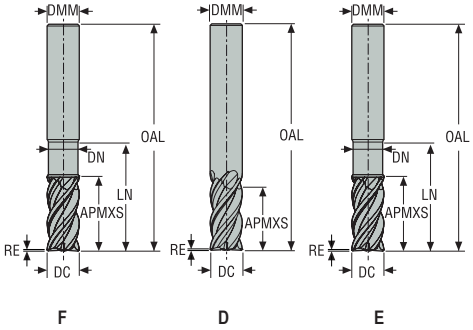
SMG		a_p/DC	f_z		v_c
			16	20	
P1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.20 *0,0080*	160 (140–180) *520 (460 — 590)*
P2	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	155 (140–170) *510 (460 — 550)*
P3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	135 (120–150) *445 (400 — 490)*
P4	E/M/A	0.44 *0,44*	0.16 *0,0065*	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 page 447-454

SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min
f_z = mm
a_p/D_c = mm
All cutting data are target values

JHP951

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



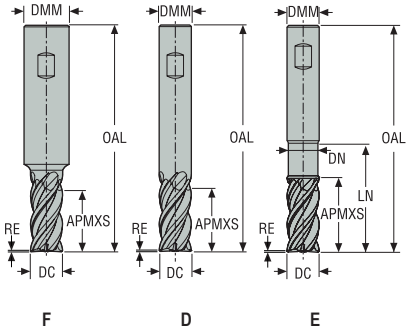
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

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	■
JHP951160E2R050.0Z4-SIRA	02927875	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	■
JHP951160E2R100.0Z4-SIRA	02927876	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	■
JHP951160E2C.0Z5-SIRA	02828232	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	■
JHP951160E2R050.0Z5-SIRA	02828230	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	■
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	■
JHP951160E2R050.3Z4-SIRA	02927879	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	□
JHP951160E2R100.3Z4-SIRA	02927880	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	□
JHP951160E2C.3Z5-SIRA	02828233	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	■
JHP951160E2R050.3Z5-SIRA	02828275	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	□
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	■
JHP951200E2R100.3Z4-SIRA	02927878	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	1,0	4	■
JHP951200E2R050.3Z5-SIRA	02828235	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	0,5	5	■
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 447 - 454

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

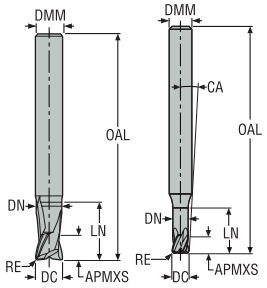
SMG		a_p/DC	f_z									v_c
			3	4	5	6	8	10	12	16	20	
P1	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560–720)*
P2	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*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

For cutting data recalculations, see pages 447 - 454

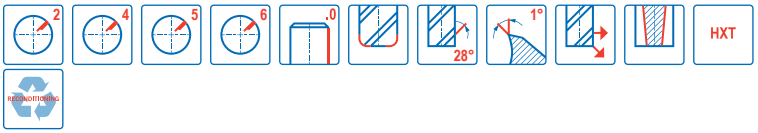
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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

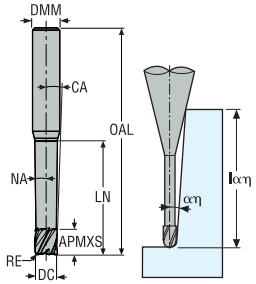


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm	mm									
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	6,63	6,96	7,21	7,43	7,62	7,96	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	6,63	6,96	7,21	7,43	7,62	7,96	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	6,63	6,95	7,2	7,41	7,6	7,93	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	6,63	6,95	7,2	7,41	7,6	7,93	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	8,92	9,23	9,48	9,71	9,91	10,26	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	8,92	9,23	9,48	9,71	9,91	10,26	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	8,92	9,21	9,46	9,67	9,87	10,21	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	8,92	9,21	9,46	9,67	9,87	10,21	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	9,13	9,4	9,64	9,84	10,03	10,37	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	9,13	9,4	9,64	9,84	10,03	10,37	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	9,13	9,4	9,63	9,83	10,02	10,35	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	9,13	9,38	9,6	9,8	9,98	10,3	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	12,0	–	–	–	–	–	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	12,0	–	–	–	–	–	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	12,0	–	–	–	–	–	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	12,0	–	–	–	–	–	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	12,0	–	–	–	–	–	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	16,0	–	–	–	–	–	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	16,0	–	–	–	–	–	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	16,0	–	–	–	–	–	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	16,0	–	–	–	–	–	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	16,0	–	–	–	–	–	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	20,0	–	–	–	–	–	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	20,0	–	–	–	–	–	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	20,0	–	–	–	–	–	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	20,0	–	–	–	–	–	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	24,0	–	–	–	–	–	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	24,0	–	–	–	–	–	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	24,0	–	–	–	–	–	■

■ Stocked standard. For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

JH142

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



J

- 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	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	5,23	10,27	10,95	11,31	11,69	12,54	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	4	5,23	10,27	10,95	11,31	11,69	12,54	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	2	5,23	10,24	10,94	11,29	11,66	12,5	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	4	5,23	10,24	10,94	11,29	11,66	12,5	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	2	9,57	15,58	16,22	16,75	17,32	18,57	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	4	9,57	15,58	16,22	16,75	17,32	18,57	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	2	9,57	15,54	16,19	16,7	17,25	18,46	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	4	9,57	15,54	16,19	16,7	17,25	18,46	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	4	13,87	20,79	21,52	22,23	22,99	–	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	2	13,87	20,79	21,52	22,23	22,99	–	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	4	13,87	20,78	21,51	22,21	22,97	–	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	2	13,87	20,78	21,51	22,21	22,97	–	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	2	13,87	20,76	21,48	22,16	22,9	–	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	4	13,87	20,76	21,48	22,16	22,9	–	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	4	19,15	30,85	31,88	32,93	–	–	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	5	19,15	30,85	31,88	32,93	–	–	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	4	19,15	30,83	31,85	32,88	–	–	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	5	19,15	30,83	31,85	32,88	–	–	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	5	19,15	30,8	31,82	32,83	–	–	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	5	19,15	30,78	31,78	32,78	–	–	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	5	27,67	41,12	42,44	–	–	–	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	5	27,67	41,11	42,41	–	–	–	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	5	27,67	41,09	42,38	–	–	–	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	5	27,67	41,08	42,35	–	–	–	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	5	29,67	50,97	52,62	–	–	–	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	5	29,67	50,95	52,59	–	–	–	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	5	29,67	50,91	52,53	–	–	–	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	4	5,23	11,4	21,0	21,71	22,45	24,11	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	4	5,23	11,14	20,99	21,69	22,43	24,06	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	4	9,57	20,92	31,32	32,35	33,46	–	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	4	9,57	20,3	31,29	32,31	33,39	–	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	4	13,87	30,85	41,65	–	–	–	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	4	13,87	30,6	41,65	–	–	–	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	4	13,87	29,98	41,6	–	–	–	■

■ Stocked standard. For WDX values: Max. cut depth rel. to αη (lαη, ref)*

Cutting data – JH142 Copy milling roughing

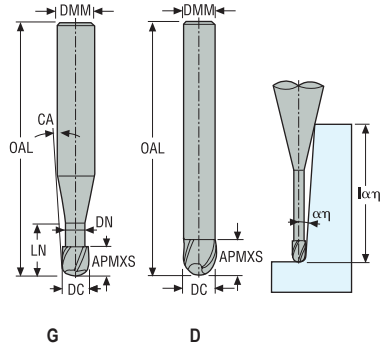
SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600–1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	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)*

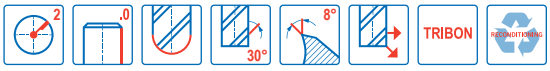
For cutting data recalculations, see pages 447 - 454

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

JH970

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	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm									
970021-TRIBON	02452881	1	G	2,0	3,0	3,0	50,0	10,0	1,9	2,5	2	10,0	11,0	11,5	12,1	12,8	–	■
970031-TRIBON	02452882	1	D	3,0	3,0	4,5	50,0	–	–	–	2	4,5	–	–	–	–	–	■
970041-TRIBON	02452883	1	D	4,0	4,0	6,0	60,0	–	–	–	2	6,0	–	–	–	–	–	■
970051-TRIBON	02452884	1	D	5,0	5,0	7,5	60,0	–	–	–	2	7,5	–	–	–	–	–	■
970061-TRIBON	02452885	1	D	6,0	6,0	9,0	75,0	–	–	–	2	9,0	–	–	–	–	–	■
970020-TRIBON	02452886	2	G	2,0	6,0	3,0	60,0	4,0	1,9	8,0	2	4,0	4,7	4,9	5,1	5,4	6,0	■
970025-TRIBON	02452887	2	G	2,5	6,0	4,0	60,0	5,0	2,4	7,5	2	5,0	5,7	6,0	6,2	6,5	7,3	■
970030-TRIBON	02452888	2	G	3,0	6,0	4,5	60,0	6,0	2,8	5,5	2	6,0	7,4	7,8	8,3	9,0	10,6	■
970035-TRIBON	02452889	2	G	3,5	6,0	5,0	60,0	7,0	3,2	4,5	2	7,0	8,8	9,4	10,0	10,7	12,8	■
970040-TRIBON	02452890	2	G	4,0	6,0	6,0	60,0	8,0	3,7	3,0	2	8,0	10,8	11,9	13,3	15,2	–	■
970050-TRIBON	02452891	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,0	2	10,0	13,6	15,0	16,8	–	–	■
970060-TRIBON	02452892	2	G	6,0	8,0	9,0	75,0	12,0	5,6	2,5	2	12,0	15,8	17,4	19,4	22,2	–	■
970080-TRIBON	02452893	2	D	8,0	8,0	12,0	75,0	–	–	–	2	12,0	–	–	–	–	–	■
970100-TRIBON	02452894	2	D	10,0	10,0	15,0	80,0	–	–	–	2	15,0	–	–	–	–	–	■
970120-TRIBON	02452895	2	D	12,0	12,0	18,0	90,0	–	–	–	2	18,0	–	–	–	–	–	■
970160-TRIBON	02452896	2	D	16,0	16,0	24,0	100,0	–	–	–	2	24,0	–	–	–	–	–	■
970L020-TRIBON	02452899	3	G	2,0	6,0	3,0	80,0	4,0	1,9	8,0	2	4,0	4,7	4,9	5,1	5,4	6,0	■
970L030-TRIBON	02452900	3	G	3,0	6,0	4,5	80,0	6,0	2,8	5,5	2	6,0	7,4	7,8	8,3	9,0	10,6	■
970L040-TRIBON	02452901	3	G	4,0	6,0	6,0	80,0	8,0	3,7	3,0	2	8,0	10,8	11,9	13,3	15,2	–	■
970L050-TRIBON	02452902	3	G	5,0	6,0	7,5	100,0	10,0	4,6	2,0	2	10,0	13,6	15,0	16,8	–	–	■
970L060-TRIBON	02452903	3	G	6,0	8,0	9,0	100,0	12,0	5,6	2,5	2	12,0	15,8	17,4	19,4	22,2	–	■
970L080-TRIBON	02452904	3	D	8,0	8,0	12,0	110,0	–	–	–	2	12,0	–	–	–	–	–	■
970L100-TRIBON	02452905	3	D	10,0	10,0	15,0	125,0	–	–	–	2	15,0	–	–	–	–	–	■
970L120-TRIBON	02452906	3	D	12,0	12,0	18,0	125,0	–	–	–	2	18,0	–	–	–	–	–	■
970L160-TRIBON	02452907	3	D	16,0	16,0	24,0	150,0	–	–	–	2	24,0	–	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

Cutting data – JH970 Copy milling roughing

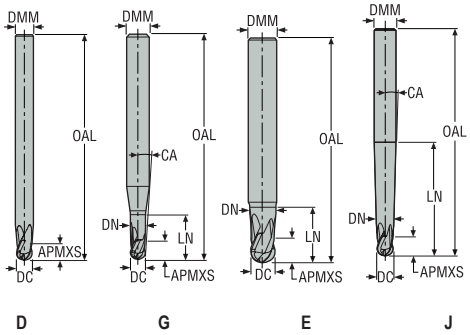
SMG		a_e/DC	a_p/DC	f_z									v_c
				2	3	4	5	6	8	10	12	16	
P1	M	0.350 *0,350*	0.070 *0,070*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	245 (220 — 270) *800 (730 — 880)*
P2	M	0.350 *0,350*	0.070 *0,070*	0.040 *0,0016*	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*	240 (210 — 270) *790 (690 — 880)*
P3	M	0.350 *0,350*	0.070 *0,070*	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*	205 (180 — 230) *670 (600–750)*
P4	M	0.350 *0,350*	0.070 *0,070*	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*	180 (160 — 200) *590 (530 — 650)*
P5	M	0.350 *0,350*	0.070 *0,070*	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*	170 (150–190) *560 (500 — 620)*
P6	M	0.350 *0,350*	0.070 *0,070*	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*	195 (170 — 210) *640 (560 — 680)*
P7	M	0.350 *0,350*	0.070 *0,070*	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*	185 (160 — 200) *610 (530 — 650)*
P8	M	0.350 *0,350*	0.070 *0,070*	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*	170 (150–190) *560 (500 — 620)*
P11	M	0.350 *0,350*	0.070 *0,070*	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*	180 (160 — 200) *590 (530 — 650)*
P12	M	0.350 *0,350*	0.070 *0,070*	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*	105 (91–110) *345 (300 — 360)*
M1	M	0.170 *0,170*	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*	95 (85–110) *310 (280 — 360)*
M2	M	0.170 *0,170*	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*	0.15 *0,0060*	80 (69 — 89) *260 (230 — 290)*
M3	M	0.130 *0,130*	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*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (57–76) *215 (190 — 240)*
M4	M	0.130 *0,130*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	50 (44 — 59) *165 (150–190)*
M5	M	0.130 *0,130*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	43 (37 — 49) *140 (130–160)*
S1	E	0.150 *0,150*	0.065 *0,065*	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*	50 (42 — 62) *165 (140 — 200)*
S2	E	0.150 *0,150*	0.065 *0,065*	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*	42 (34 — 50) *140 (120–160)*
S3	E	0.120 *0,120*	0.060 *0,060*	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*	31 (21 — 41) *100 (69–130)*
S11	E	0.350 *0,350*	0.15 *0,15*	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*	105 (89–110) *345 (300 — 360)*
S12	E	0.350 *0,350*	0.15 *0,15*	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*	80 (69 — 91) *260 (230 — 290)*
S13	E	0.350 *0,350*	0.15 *0,15*	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*	60 (54–70) *195 (180 — 220)*

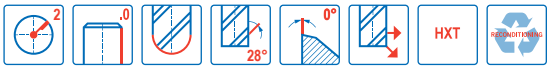
For cutting data recalculations, see pages 447 - 454

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





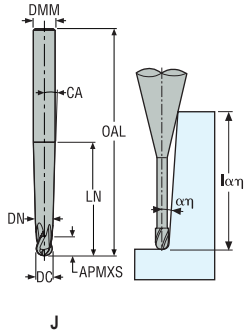
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	4,66	4,84	5,03	5,24	5,47	6,03	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	3,3	2	6,96	7,29	7,66	8,08	8,56	9,78	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	–	2	4,0	–	–	–	–	–	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,0	2	12,09	12,96	14,01	15,29	16,89	–	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	–	2	6,0	–	–	–	–	–	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	–	2	8,0	–	–	–	–	–	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	–	2	10,0	–	–	–	–	–	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	2,5	2	10,79	11,1	11,42	11,77	–	–	■
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	4,0	–	–	–	–	–	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	–	2	5,0	–	–	–	–	–	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	–	2	6,0	–	–	–	–	–	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	8,12	2	4,66	4,84	5,03	5,24	5,47	6,03	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	7,39	2	5,66	5,87	6,1	6,36	6,64	7,31	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	5,5	2	6,97	7,31	7,7	8,14	8,65	9,95	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	3,81	2	8,62	9,24	9,99	10,9	12,05	15,49	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	3,34	2	9,62	10,31	11,14	12,15	13,42	17,25	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,0	2	12,09	12,96	14,01	15,29	16,89	–	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	2,78	2	14,09	15,1	16,31	17,79	19,64	25,2	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	–	2	16,0	–	–	–	–	–	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	–	2	20,0	–	–	–	–	–	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	–	2	24,0	–	–	–	–	–	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	3,82	2	20,66	21,59	22,61	23,73	24,98	27,94	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	2,91	2	20,97	22,18	23,55	25,11	26,92	31,51	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	1,97	2	21,62	23,39	25,53	28,13	–	–	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	0,53	2	52,09	56,58	–	–	–	–	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	5,6	–	2	6,0	–	–	–	–	–	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	7,4	–	2	8,0	–	–	–	–	–	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	9,4	–	2	10,0	–	–	–	–	–	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	11,4	–	2	12,0	–	–	–	–	–	■

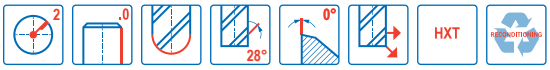
■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm									
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	–	1,9	3,3	2	3,09	3,43	3,91	4,63	5,81	14,63	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	–	2,8	2,2	2	5,7	6,75	8,51	12,03	22,61	–	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	–	3,7	1,2	2	10,58	15,35	32,07	–	–	–	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	–	4,6	1,6	2	11,47	14,56	20,93	41,46	–	–	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	–	5,6	1,1	2	14,72	21,24	44,08	–	–	–	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	–	7,4	1,0	2	20,71	29,7	59,65	–	–	–	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	–	9,4	1,0	2	22,16	30,75	56,56	–	–	–	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	–	5,6	2,0	2	11,59	13,99	18,22	27,78	69,22	–	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	–	7,4	1,8	2	16,24	19,64	25,68	39,27	98,24	–	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	–	9,4	0,8	2	26,26	43,99	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

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 447 - 454

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

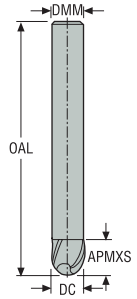
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100–1400)*
K2	E	0.250 *0,250*	0.15 *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 447 - 454

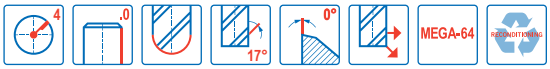
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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 if DC is ≥Ø6

Designation	Ordering No.	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

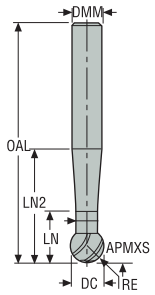
SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100–1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890–1000)*
K3	A	0.300 *0,300*	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 447 - 454

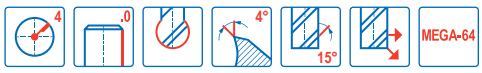
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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 447 - 454

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, JHP750, JHP760, JHP770, JHP780, JCG790, JH770, JH740, JH710, JH790, JH730, JHP994 and JCO710 for chamfer or radius type.
- JS730, JH780, JH720, JH721 and JH722 for ball-nose type.

Tool selection Stainless and S-materials

								
Name		JS754	JS755	JS720	JS730	JHP750	JHP760	JHP770
Page(s)		213	230	241	251	255	258	262
Family name		JS²	JS²	JS²	JS²	HPM	HPM	HPM
Type of mill								
Shank	Cylindrical	■	■	■	■	■	■	■
	Weldon	■	■	■	□	■	■	■
	Safelock	□	□	□	□			□
Number of Flutes		4	5	6-9	6	2,3,4	2,4	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	2,4	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		JHP780	JCG790	JH770	JH740	JH710	JH790	JH730
Page(s)		269	274	276	278	280	282	284
Family name		HPM	Ceramic	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Type of mill								
Shank	Cylindrical	■	■	■	■	■	■	■
	Weldon	■						
	Safelock	□						
Number of Flutes		4	5-6	3,4,5,6	4-5	5	6	6-7
ICC		■						
Diameter range	Metric	6-25	6-25	3-10	6-10	6-8	9,5	8-10
	Inch							
Length availability								
		2	2	2	2	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

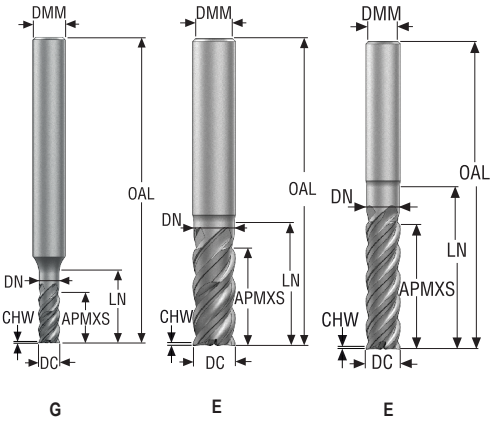
Tool selection Stainless and S-materials

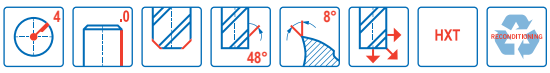
							
Name		JHP994	JH780	JH720	JH721	JH722	JCO710
Page(s)		286	288	290	292	294	296
Family name		HPM	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSS-Co
Type of mill							
Shank	Cylindrical	■	■	■	■	■	
	Weldon						■
	Safelock						
Number of Flutes		4	4	3	6	6	4-6
ICC							
Diameter range	Metric	6-10	1,83-4,89	2-16	6-8	10	16-40
	Inch						
Length availability							
		3	2	2	2	2	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





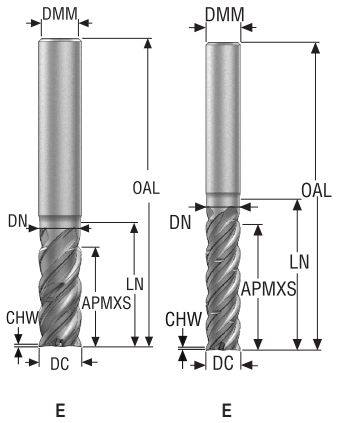
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
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



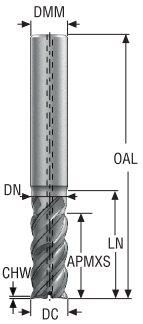
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible if DC is ≥Ø6

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



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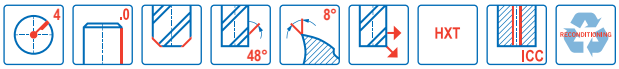


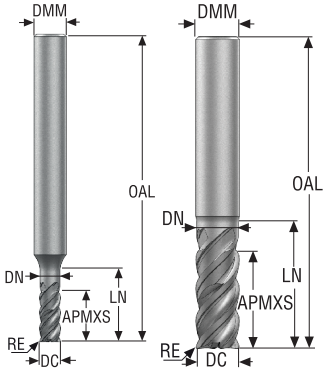
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

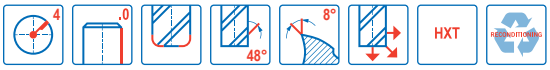
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.0Z4A-HXT	03186834	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.0Z4A-HXT	03186835	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.0Z4A-HXT	03186836	2	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. ICC = Internal Coolant Channel

JS754

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





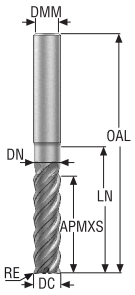
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
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	■
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	■

■ Stocked standard.

JS754

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



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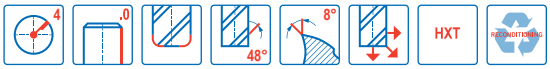


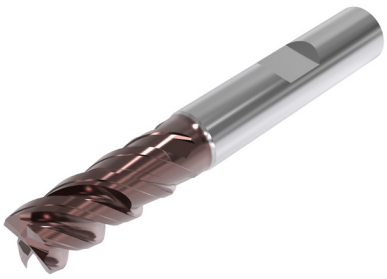
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

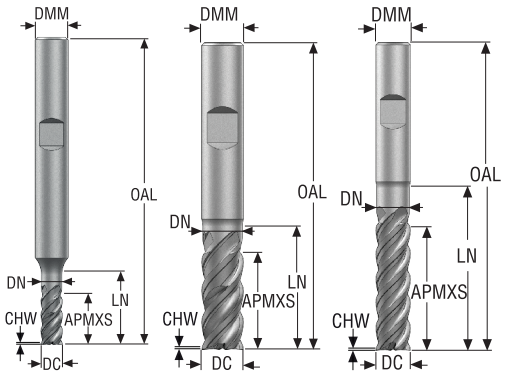
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS754060E3R020.0Z4-HXT	03186873	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	■
JS754060E3R050.0Z4-HXT	03186874	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	■
JS754060E3R100.0Z4-HXT	03186875	3	E	6,0	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	■

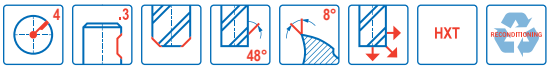
■ Stocked standard.

JS754

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







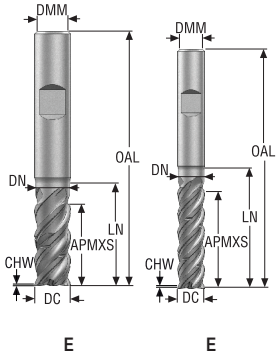
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

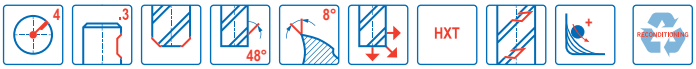
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754030G2C.3Z4-HXT	03186975	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	4	□
JS754040G2C.3Z4-HXT	03186976	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4	□
JS754050G2C.3Z4-HXT	03186977	2	G	5,0	6,0	10,0	57,0	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





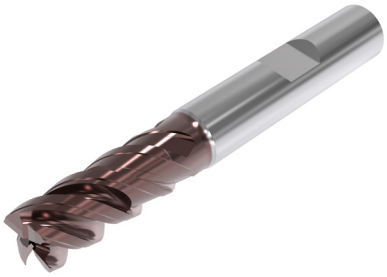
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible if DC is ≥Ø6

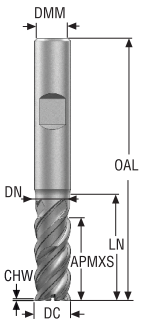
Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.3Z4C-HXT	03186985	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4C-HXT	03186986	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754060E3C.3Z4C-HXT	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

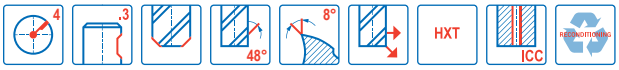
High performance – Square – ISO– M and ISO– S – 4 Flutes – Weldon – Chamfer – ICC





E

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

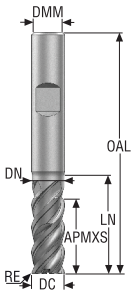


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.3Z4A-HXT	03187001	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.3Z4A-HXT	03187002	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.3Z4A-HXT	03187003	2	E	■	10,0	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	■

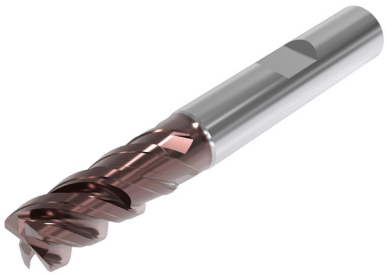
■ Stocked standard. ICC = Internal Coolant Channel

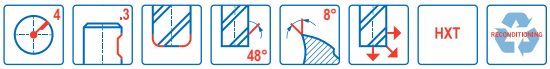
JS754

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



E





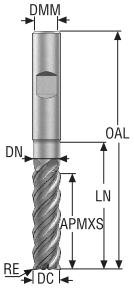
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
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	■
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	■

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

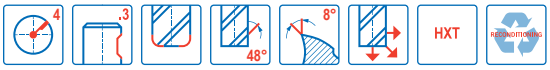
JS754

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



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

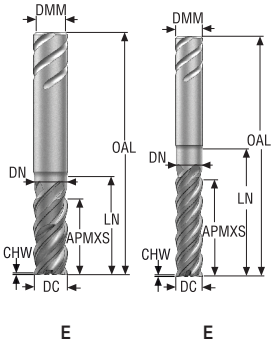


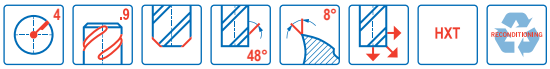
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754060E3R020.3Z4-HXT	03187040	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	☐
JS754060E3R050.3Z4-HXT	03187041	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	☐
JS754060E3R100.3Z4-HXT	03187042	3	E	6,0	6,0	21,0	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





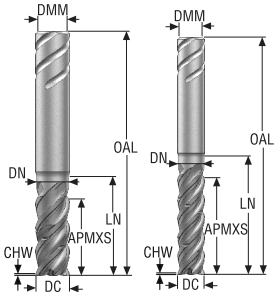
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	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	☐

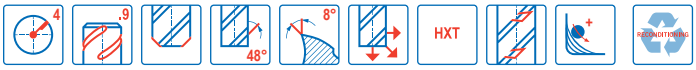
☐ Safelock available. Delivery time is 6 days.

JS754

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



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

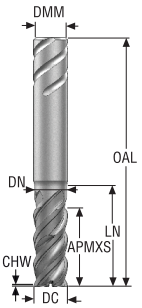


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.9Z4C-HXT	03187151	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	□
JS754120E2C.9Z4C-HXT	03187152	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	□
JS754060E3C.9Z4C-HXT	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	□

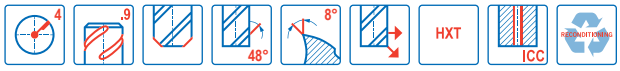
□ Safelock available. Delivery time is 6 days.

JS754

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



E



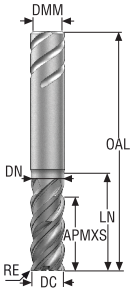
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

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.
ICC = Internal Coolant Channel

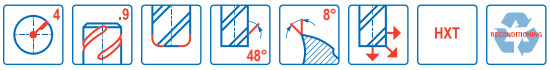
JS754

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



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

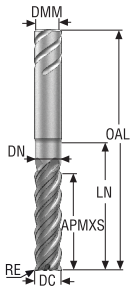


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E2R020.9Z4-HXT	03187170	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	☐
JS754060E2R050.9Z4-HXT	03187171	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	☐
JS754060E2R100.9Z4-HXT	03187172	2	E	6,0	6,0	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	☐

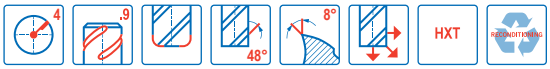
☐ Safelock available. Delivery time is 6 days.

JS754

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



E



- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

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 447 - 454

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)*

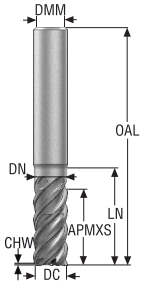
If radius exeeds 15% of value DC please reduce fz with 20%

For cutting data recalculations, see pages 447 - 454

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

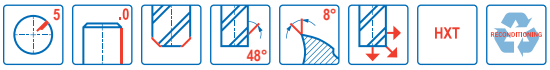
JS755

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



E

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

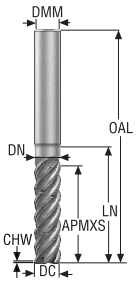


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.0Z5-HXT	03186907	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	■
JS755080E2C.0Z5-HXT	03186908	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	■
JS755100E2C.0Z5-HXT	03186909	2	E	10,0	10,0	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	■

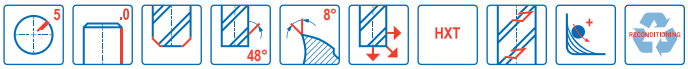
■ Stocked standard.

JS755

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



E



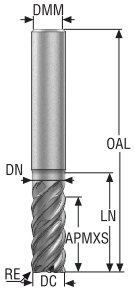
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible if DC is ≥Ø6

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.

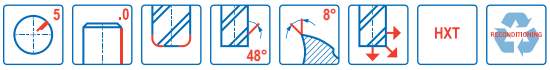
JS755

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



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

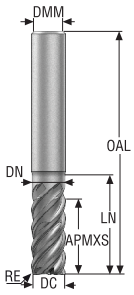


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.0Z5-HXT	03186925	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	■
JS755060E2R050.0Z5-HXT	03186926	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	■
JS755060E2R100.0Z5-HXT	03186927	2	E	6,0	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	■

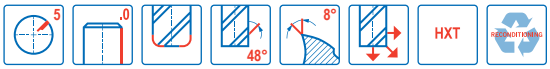
■ Stocked standard.

JS755

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



E



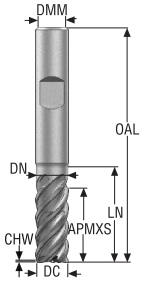
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
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.

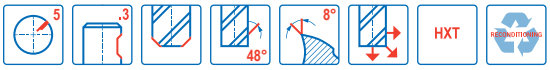
JS755

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



E

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

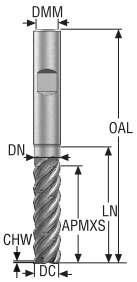


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.3Z5-HXT	03187083	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	■
JS755080E2C.3Z5-HXT	03187084	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	■
JS755100E2C.3Z5-HXT	03187085	2	E	10,0	10,0	20,0	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	■

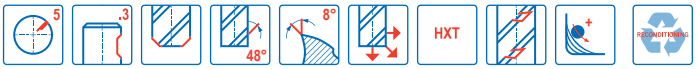
■ Stocked standard.

JS755

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



E



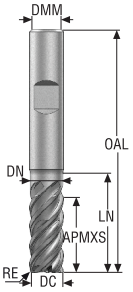
- Tolerances:
- DMM= h5
- DC= e7
- Chip splitters
- Regrind possible if DC is ≥Ø6

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.

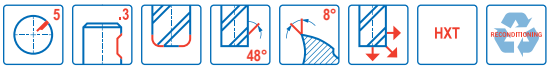
JS755

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



E

- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

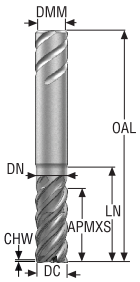


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.3Z5-HXT	03187101	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	■
JS755060E2R050.3Z5-HXT	03187102	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	■
JS755060E2R100.3Z5-HXT	03187103	2	E	6,0	6,0	12,0	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	□

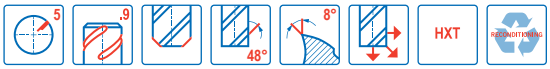
■ Stocked standard. □ Weldon available. Delivery time is 3 days.

JS755

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



E



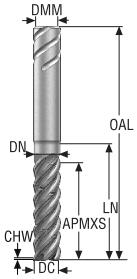
- Tolerances:
- DMM= h5
- DC= e7
- Regrind possible if DC is ≥Ø6

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.

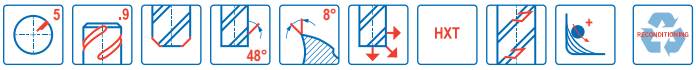
JS755

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



E

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

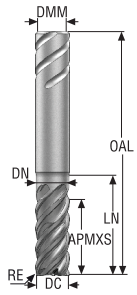


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.9Z5C-HXT	03187249	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	☐
JS755120E3C.9Z5C-HXT	03187250	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	☐
JS755160E3C.9Z5C-HXT	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	☐

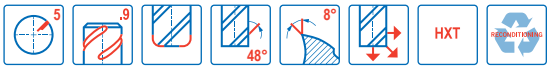
☐ Safelock available. Delivery time is 6 days.

JS755

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



E



- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6

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)*

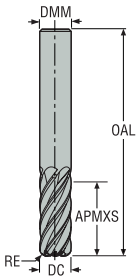
If radius exeeds 15% of value DC please reduce fz with 20%

For cutting data recalculations, see pages 447 - 454

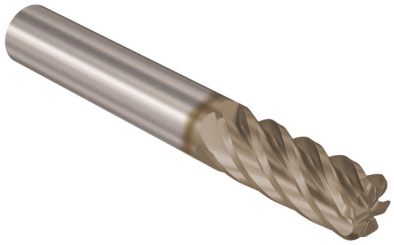
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS720

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



D



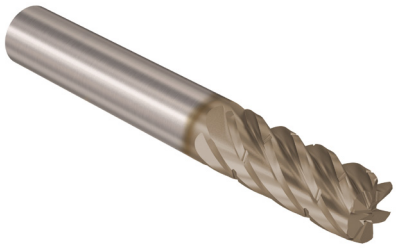
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

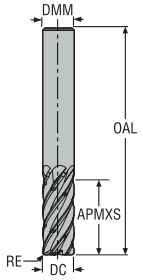
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS720060D2R050.0Z6-HXT	03060293	2	D	6,0	6,0	17,0	57,0	0,5	6	■
JS720060D2R100.0Z6-HXT	03060294	2	D	6,0	6,0	17,0	57,0	1,0	6	■
JS720080D2R050.0Z6-HXT	03060295	2	D	8,0	8,0	23,0	63,0	0,5	6	■
JS720080D2R100.0Z6-HXT	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	■
JS720250D2R300.0Z6-HXT	03169498	2	D	25,0	25,0	50,0	125,0	3,0	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

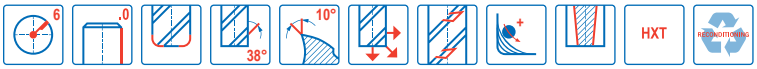
High performance – Titanium – Square – 6 Flutes – Cylindrical – Corner radius – Chip splitters





D

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

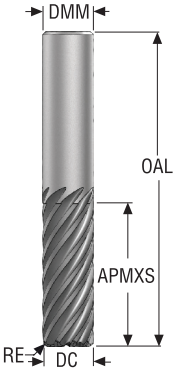


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm		
JS720100D2R050.0Z6C-HXT	03060297	2	D	■	10,0	10,0	26,0	72,0	0,5	6	■
JS720120D2R050.0Z6C-HXT	03060302	2	D	■	12,0	12,0	30,0	83,0	0,5	6	■
JS720120D2R100.0Z6C-HXT	03298280	2	D	■	12,0	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	■
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

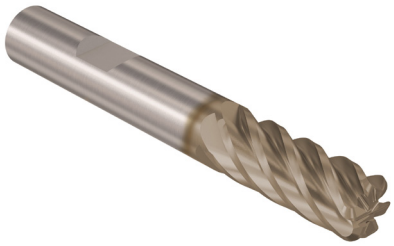
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

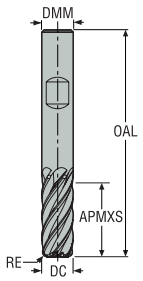
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JS720160D2R100.0Z9-HXT	10008152	2	D	16,0	16,0	44,0	99,0	1,0	9	■
JS720160D2R200.0Z9-HXT	10008153	2	D	16,0	16,0	44,0	99,0	2,0	9	■
JS720160D2R300.0Z9-HXT	10008154	2	D	16,0	16,0	44,0	99,0	3,0	9	■
JS720250D2R100.0Z9-HXT	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	■
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

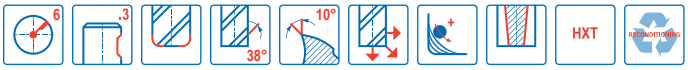
High performance – Titanium – Square – 6 Flutes – Weldon – Corner radius





D

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

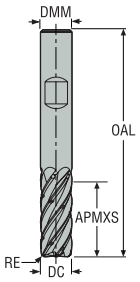


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720060D2R050.3Z6-HXT	03060339	2	D	6,0	6,0	17,0	57,0	0,5	6	□
JS720060D2R100.3Z6-HXT	03060340	2	D	6,0	6,0	17,0	57,0	1,0	6	□
JS720080D2R050.3Z6-HXT	03060341	2	D	8,0	8,0	23,0	63,0	0,5	6	□
JS720080D2R100.3Z6-HXT	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	□
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

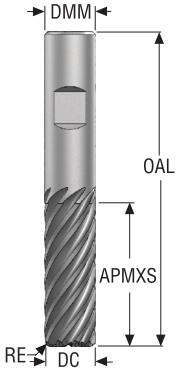
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Chip splitters
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720100D2R050.3Z6C-HXT	03060343	2	D	■	10,0	10,0	26,0	72,0	0,5	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	■
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

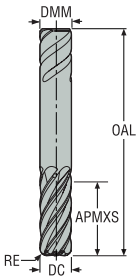
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
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	☐
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	☐
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	☐

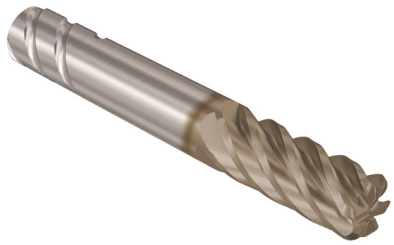
☐ Weldon available. Delivery time is 3 days.

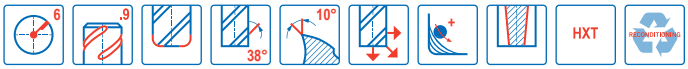
JS720

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



D





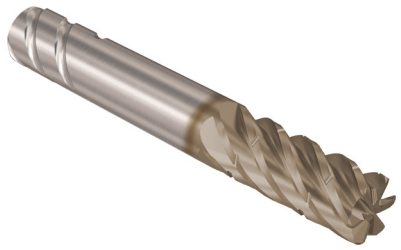
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

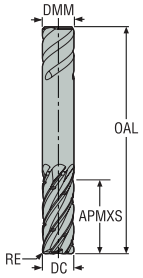
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm		
JS720060D2R050.9Z6-HXT	03060374	2	D	6,0	6,0	17,0	57,0	0,5	6	☐
JS720060D2R100.9Z6-HXT	03060375	2	D	6,0	6,0	17,0	57,0	1,0	6	☐
JS720080D2R050.9Z6-HXT	03060376	2	D	8,0	8,0	23,0	63,0	0,5	6	☐
JS720080D2R100.9Z6-HXT	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	☐
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

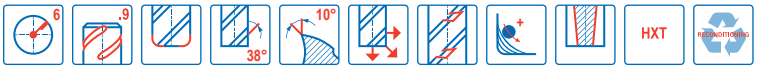
High performance – Titanium – Square – 6 Flutes – Safelock – Corner radius – Chip splitters





D

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

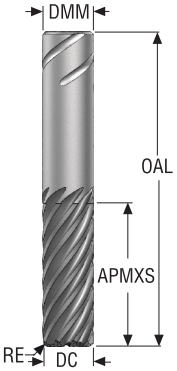


Designation	Item number	Length index	Tool shape	Chip splitters	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm		
JS720100D2R050.9Z6C-HXT	03060378	2	D	■	10,0	10,0	26,0	72,0	0,5	6	■
JS720120D2R050.9Z6C-HXT	03060383	2	D	■	12,0	12,0	30,0	83,0	0,5	6	■
JS720120D2R100.9Z6C-HXT	03298334	2	D	■	12,0	12,0	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	■
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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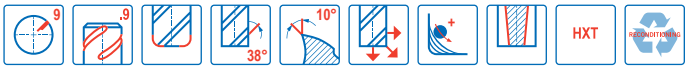


- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Safelock
				mm	mm	mm	mm	mm		
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	☐
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	☐
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.

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)*
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)*
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)*

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

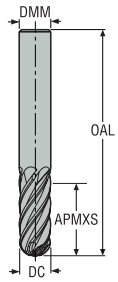
SMG		a_p/DC	f_z			v_c
			16	20	25	
M1	E	2.0 *2,0*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	125 (98–160) *410 (330 — 520)*
M2	E	2.0 *2,0*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (82–130) *345 (270 — 420)*
M3	E	2.0 *2,0*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	80 (64–110) *260 (210 — 360)*
M4	E	2.0 *2,0*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70–110) *310 (230 — 360)*
M5	E	2.0 *2,0*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	75 (59 — 96) *245 (200 — 310)*
S11	E	2.0 *2,0*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	120 (91–150) *395 (300 — 490)*
S12	E	2.0 *2,0*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70–110) *310 (230 — 360)*
S13	E	2.0 *2,0*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70–110) *310 (230 — 360)*

For cutting data recalculations, see pages 447 - 454

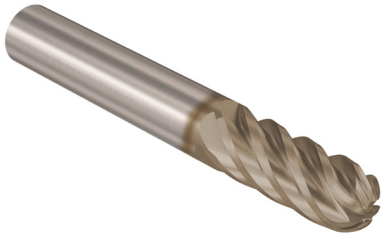
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

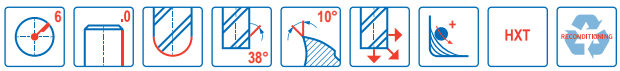
JS730

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



D





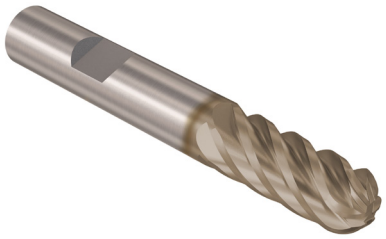
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Two flutes to centre
- Regrind possible if DC is ≥Ø6

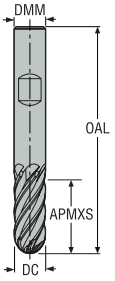
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Cylindrical
				mm	mm	mm	mm		
JS730060D2B.0Z6-HXT	03067605	2	D	6,0	6,0	17,0	57,0	6	■
JS730080D2B.0Z6-HXT	03067606	2	D	8,0	8,0	23,0	63,0	6	■
JS730100D2B.0Z6-HXT	03067607	2	D	10,0	10,0	26,0	72,0	6	■
JS730120D2B.0Z6-HXT	03067608	2	D	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

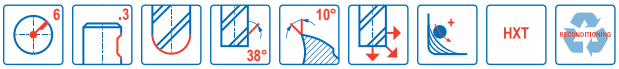
High performance – Titanium – Ball nose – 6 Flutes – Weldon





D

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

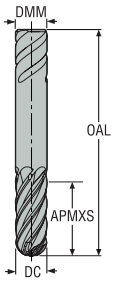


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS730060D2B.3Z6-HXT	03067778	2	D	6,0	6,0	17,0	57,0	6	☐
JS730080D2B.3Z6-HXT	03067779	2	D	8,0	8,0	23,0	63,0	6	☐
JS730100D2B.3Z6-HXT	03067780	2	D	10,0	10,0	26,0	72,0	6	☐
JS730120D2B.3Z6-HXT	03067781	2	D	12,0	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	☐

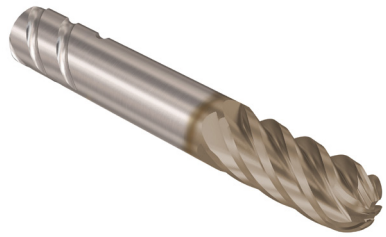
☐ Weldon available. Delivery time is 3 days.

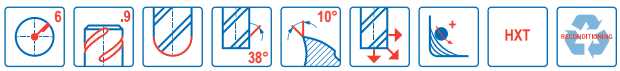
JS730

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



D





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

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*	135 (87–140) *445 (290 — 450)*
M2	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*	110 (70–110) *360 (230 — 360)*
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)*
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

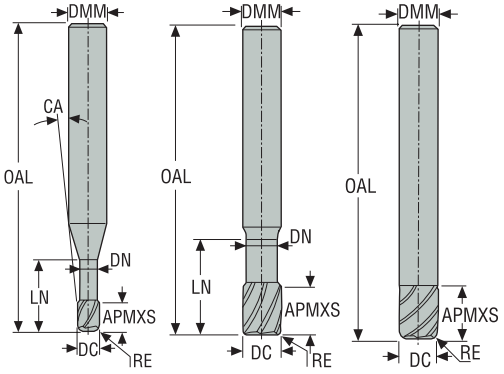
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	145 (91–150) *475 (300 — 490)*
M2	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	115 (73–120) *375 (240 — 390)*
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)*
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)*

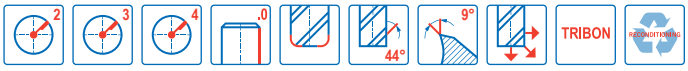
For cutting data recalculations, see pages 447 - 454

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

JHP750

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





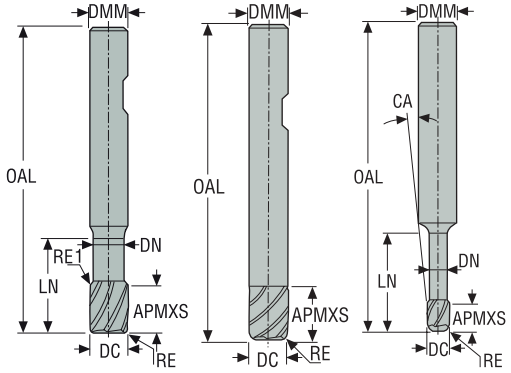
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

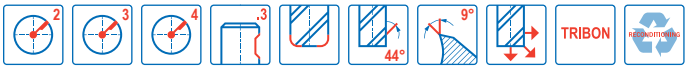
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	–		
750K080R040.0-TRIBON	02528232	1	D	8,0	8,0	16,0	55,0	–	–	0,4	–	4	■
750K100R040.0-TRIBON	02528234	1	D	10,0	10,0	20,0	65,0	–	–	0,4	–	4	■
750K100R150.0-TRIBON	02528236	1	D	10,0	10,0	20,0	65,0	–	–	1,5	–	4	■
750K120R040.0-TRIBON	02528238	1	D	12,0	12,0	24,0	75,0	–	–	0,4	–	4	■
750K120R150.0-TRIBON	02528242	1	D	12,0	12,0	24,0	75,0	–	–	1,5	–	4	■
750K160R040.0-TRIBON	02528244	1	D	16,0	16,0	32,0	90,0	–	–	0,4	–	4	■
750K160R150.0-TRIBON	02528250	1	D	16,0	16,0	32,0	90,0	–	–	1,5	–	4	■
750K200R080.0-TRIBON	02528253	1	D	20,0	20,0	40,0	100,0	–	–	0,8	–	4	■
750020R020.0-TRIBON	02510010	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	4,0	2	■
750030R020.0-TRIBON	02510012	2	E	3,0	3,0	4,5	40,0	9,0	2,8	0,2	–	2	■
750040R020.0-TRIBON	02510013	2	G	4,0	6,0	6,0	40,0	9,0	3,7	0,2	5,0	2	■
750050R030.0-TRIBON	02510043	2	G	5,0	6,0	7,5	40,0	9,0	4,6	0,3	3,0	2	■
750060R030.0-TRIBON	02510044	2	E	6,0	6,0	9,0	50,0	19,0	5,6	0,3	–	3	■
750080R040.0-TRIBON	02510045	2	E	8,0	8,0	16,0	60,0	24,0	7,4	0,4	–	4	■
750100R040.0-TRIBON	02510046	2	E	10,0	10,0	20,0	70,0	30,0	9,4	0,4	–	4	■
750100R080.0-TRIBON	02510049	2	E	10,0	10,0	20,0	70,0	30,0	9,4	0,8	–	4	■
750100R200.0-TRIBON	02510053	2	E	10,0	10,0	20,0	70,0	30,0	9,4	2,0	–	4	■
750120R040.0-TRIBON	02510057	2	E	12,0	12,0	24,0	80,0	35,0	11,4	0,4	–	4	■
750120R080.0-TRIBON	02510060	2	E	12,0	12,0	24,0	80,0	35,0	11,4	0,8	–	4	■
750120R200.0-TRIBON	02510063	2	E	12,0	12,0	24,0	80,0	35,0	11,4	2,0	–	4	■
750120R310.0-TRIBON	02510065	2	E	12,0	12,0	24,0	80,0	35,0	11,4	3,1	–	4	■
750140R080.0-TRIBON	02510067	2	E	14,0	14,0	28,0	90,0	45,0	13,4	0,8	–	4	■
750160R040.0-TRIBON	02510071	2	E	16,0	16,0	32,0	100,0	52,0	15,4	0,4	–	4	■
750160R080.0-TRIBON	02510073	2	E	16,0	16,0	32,0	100,0	52,0	15,4	0,8	–	4	■
750160R200.0-TRIBON	02510077	2	E	16,0	16,0	32,0	100,0	52,0	15,4	2,0	–	4	■
750200R080.0-TRIBON	02510085	2	E	20,0	20,0	40,0	125,0	75,0	19,4	0,8	–	4	■
750200R200.0-TRIBON	02510087	2	E	20,0	20,0	40,0	125,0	75,0	19,4	2,0	–	4	■

■ Stocked standard.

JHP750

High performance – Titanium – Square – 2-4 Flutes – Weldon – 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	DN	RE	CA	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	–		
750K080R040-TRIBON	02528231	1	D	8,0	8,0	16,0	55,0	–	–	0,4	–	4	■
750K100R040-TRIBON	02528233	1	D	10,0	10,0	20,0	65,0	–	–	0,4	–	4	■
750K100R150-TRIBON	02528235	1	D	10,0	10,0	20,0	65,0	–	–	1,5	–	4	■
750K120R040-TRIBON	02528237	1	D	12,0	12,0	24,0	75,0	–	–	0,4	–	4	■
750K120R150-TRIBON	02528240	1	D	12,0	12,0	24,0	75,0	–	–	1,5	–	4	■
750K160R040-TRIBON	02528243	1	D	16,0	16,0	32,0	90,0	–	–	0,4	–	4	■
750K160R150-TRIBON	02528249	1	D	16,0	16,0	32,0	90,0	–	–	1,5	–	4	■
750K200R080-TRIBON	02528251	1	D	20,0	20,0	40,0	100,0	–	–	0,8	–	4	■
750040R020.0-TRIBONW	02669407	2	G	4,0	6,0	6,0	40,0	9,0	3,7	0,2	5,0	2	□
750050R030.0-TRIBONW	02669408	2	G	5,0	6,0	7,5	40,0	9,0	4,6	0,3	3,0	2	□
750060R030.0-TRIBONW	02669409	2	E	6,0	6,0	9,0	50,0	19,0	5,6	0,3	–	3	□
750080R040-TRIBON	02528258	2	E	8,0	8,0	16,0	60,0	24,0	7,4	0,4	–	4	■
750100R040-TRIBON	02510047	2	E	10,0	10,0	20,0	70,0	30,0	9,4	0,4	–	4	■
750100R080-TRIBON	02510048	2	E	10,0	10,0	20,0	70,0	30,0	9,4	0,8	–	4	■
750100R200-TRIBON	02510052	2	E	10,0	10,0	20,0	70,0	30,0	9,4	2,0	–	4	■
750120R040-TRIBON	02510056	2	E	12,0	12,0	24,0	80,0	35,0	11,4	0,4	–	4	■
750120R080-TRIBON	02510058	2	E	12,0	12,0	24,0	80,0	35,0	11,4	0,8	–	4	■
750120R200-TRIBON	02510062	2	E	12,0	12,0	24,0	80,0	35,0	11,4	2,0	–	4	■
750120R310-TRIBON	02510064	2	E	12,0	12,0	24,0	80,0	35,0	11,4	3,1	–	4	■
750140R080-TRIBON	02510066	2	E	14,0	14,0	28,0	90,0	45,0	13,4	0,8	–	4	■
750160R040-TRIBON	02510070	2	E	16,0	16,0	32,0	100,0	52,0	15,4	0,4	–	4	■
750160R080-TRIBON	02510072	2	E	16,0	16,0	32,0	100,0	52,0	15,4	0,8	–	4	■
750160R200-TRIBON	02510076	2	E	16,0	16,0	32,0	100,0	52,0	15,4	2,0	–	4	■
750200R080-TRIBON	02510084	2	E	20,0	20,0	40,0	125,0	75,0	19,4	0,8	–	4	■
750200R200-TRIBON	02510086	2	E	20,0	20,0	40,0	125,0	75,0	19,4	2,0	–	4	■

■ Stocked standard. □ Weldon available. Delivery time is 3 days.
Remark: if cornerradius is >15% of DC then a_p=-30%, f_z=-20%

Cutting data – JHP750 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*	85 (75–110) *280 (250 — 360)*

Cutting data – JHP750 Slot milling

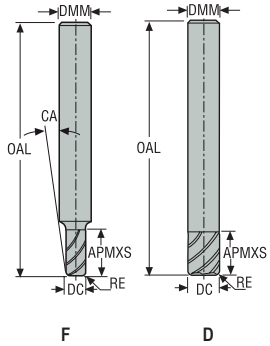
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	30 (20 — 39) *100 (66–120)*
S2	E/M/A	0.44 *0,44*	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	0.36 *0,36*	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	0.60 *0,60*	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	0.60 *0,60*	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	0.60 *0,60*	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 447 - 454

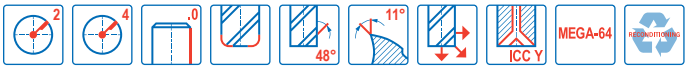
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHP760

High performance – Superalloy – 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

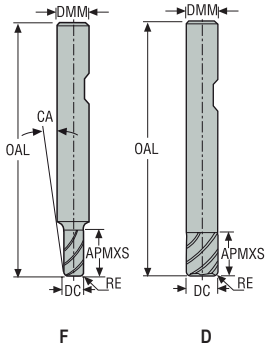


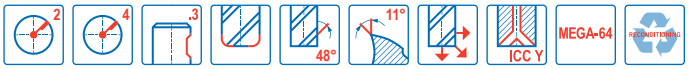
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Cylindrical
					mm	mm	mm	mm	mm			
760040R040Z2.0A-MEGA-64	02623413	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0 °	2	■
760040R020Z2.0A-MEGA-64	02734051	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0 °	2	■
760050R020Z2.0A-MEGA-64	02734052	2	F	■	5,0	6,0	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 – Superalloy – Square – 2-4 Flutes – Weldon – Corner radius – ICC





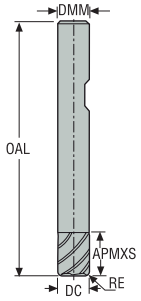
- Tolerances:
- DMM=h5
- DC=-0,02/-0,4 mm
- RE= ±0,03 mm
- Regrind possible if DC is ≥Ø6

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

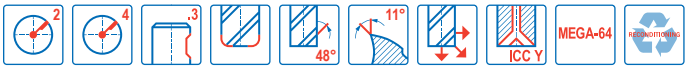
JHP760

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



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,4 mm
- RE= ±0,03 mm
- Regrind possible if DC is ≥Ø6



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

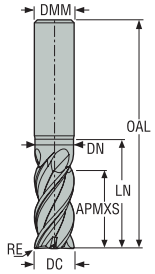
SMG		a_p/DC	f_z									v_c
			4	5	6	8	10	12	16	20	25	
M1	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	110 (92–130) *360 (310 — 420)*
M2	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	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 447 - 454

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

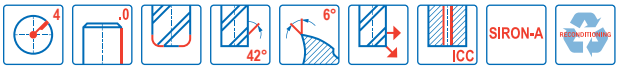
JHP770

High performance – Titanium – Square – 4-5 Flutes – Cylindrical – Corner radius – ICC



E

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

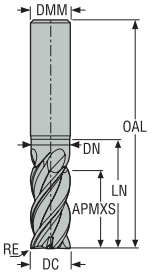


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.0Z4A-SIRA	02760645	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP770080E2R040.0Z4A-SIRA	02760653	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP770080E2R050.0Z4A-SIRA	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	■

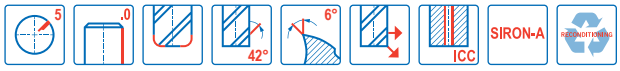
■ Stocked standard.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%
ICC = Internal Coolant Channel

JHP770

High performance – Titanium – Square –4-5 Flutes – Cylindrical – Corner radius – ICC



E



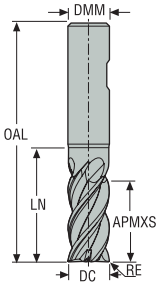
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

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	■
JHP770160E2R600.0Z5A-SIRA	03093701	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	6,0	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	■
JHP770200E2R600.0Z5A-SIRA	03093702	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	6,0	5	■
JHP770250E2R050.0Z5A-SIRA	02810139	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	■
JHP770250E2R310.0Z5A-SIRA	02810141	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	3,1	5	■

■ Stocked standard.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%
ICC = Internal Coolant Channel

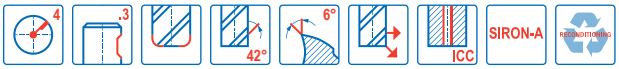
JHP770

High performance – Titanium – Square – 4-5 Flutes – Weldon – Corner radius – ICC



E

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

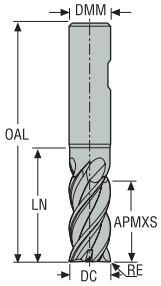


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.3Z4A-SIRA	02760796	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP770080E2R040.3Z4A-SIRA	02760799	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	□
JHP770080E2R050.3Z4A-SIRA	02823428	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%
ICC = Internal Coolant Channel

JHP770

High performance – Titanium – Square – 4-5 Flutes – Weldon – Corner radius – ICC



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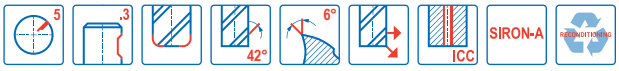


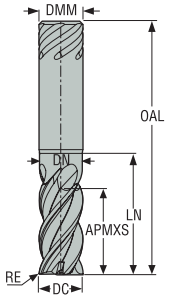
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

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	□
JHP770160E2R600.3Z5A-SIRA	03093711	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	6,0	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	■
JHP770200E2R600.3Z5A-SIRA	03093713	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	6,0	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	■
JHP770250E2R310.3Z5A-SIRA	02810155	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	3,1	5	□

■ Stocked standard. □ Weldon available. Delivery time is 3 days.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%
ICC = Internal Coolant Channel

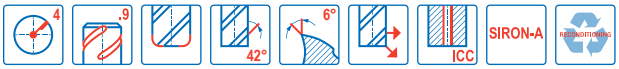
JHP770

High performance – Titanium – Square – 4-5 Flutes – Safelock – Corner radius – ICC



E

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

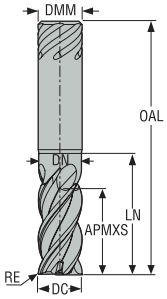


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safelock
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.9Z4A-SIRA	02927936	2	E	■	6,0	6,0	12,0	60,0	18,0	6,0	0,3	4	□
JHP770080E2R040.9Z4A-SIRA	02927937	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,4	4	□
JHP770080E2R050.9Z4A-SIRA	02927938	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	□
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	□
JHP770160E2R050.9Z4A-SIRA	02927978	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	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	□

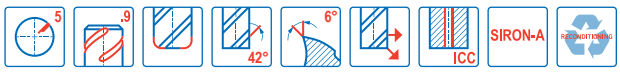
□ Safelock available. Delivery time is 6 days.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%
ICC = Internal Coolant Channel

JHP770

High performance – Titanium – Square – 4-5 Flutes – Safelock – Corner radius – ICC



E



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

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	☐
JHP770160E2R600.9Z5A-SIRA	03093712	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	6,0	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	☐
JHP770200E2R600.9Z5A-SIRA	03093714	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	6,0	5	☐
JHP770250E2R050.9Z5A-SIRA	02927971	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	0,5	5	☐
JHP770250E2R310.9Z5A-SIRA	02927974	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	3,1	5	☐

☐ Safelock available. Delivery time is 6 days.
Remark: if cornerradius is >15% of DC → a_p=-30%, f_z=-20%
ICC = Internal Coolant Channel

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

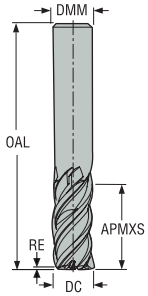
SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S11	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	105 (94–120) *345 (310 — 390)*
S12	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	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 447 - 454

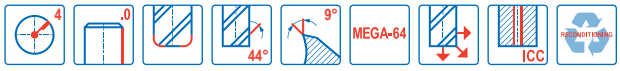
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JHP780

High performance – Superalloy – Square – 4-Flutes – Cylindrical – Corner radius – ICC



D



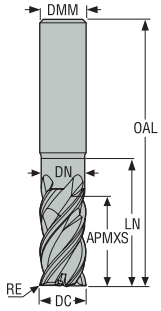
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	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	■
JHP780120D1R040.0Z4A-M64	03134990	1	D	■	12,0	12,0	15,0	65,0	–	–	0,4	4	■
JHP780120D1R080.0Z4A-M64	03134991	1	D	■	12,0	12,0	15,0	65,0	–	–	0,8	4	■

■ Stocked standard.
ICC = Internal Coolant Channel

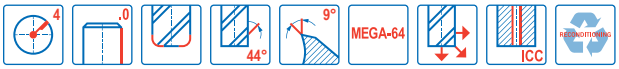
JHP780

High performance – Superalloy – Square – 4-Flutes – Cylindrical – Corner radius – ICC



E

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

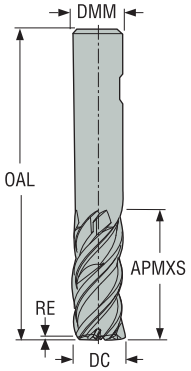


Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
JHP780060E2R030.0Z4A-M64	03134992	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780060E2R030.0Z4-M64	02760834	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780080E2R040.0Z4A-M64	03134993	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.
ICC = Internal Coolant Channel

JHP780

High performance – Superalloy – Square – 4-Flutes – Weldon – Corner radius – ICC



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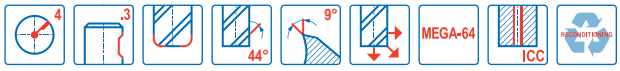


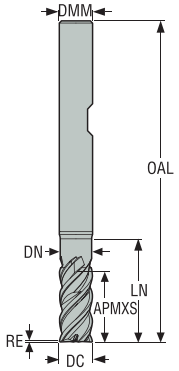
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	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	■
JHP780120D1R040.3Z4A-M64	03135452	1	D	■	12,0	12,0	15,0	65,0	–	–	0,4	4	■
JHP780120D1R080.3Z4A-M64	03135453	1	D	■	12,0	12,0	15,0	65,0	–	–	0,8	4	■

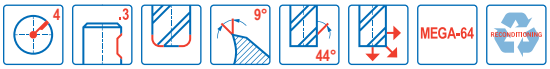
■ Stocked standard.
ICC = Internal Coolant Channel

JHP780

High performance – Superalloy – Square – 4-Flutes – Weldon – Corner radius – ICC



E



- 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		
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	■
JHP780250E2R040.3Z4-M64	02760900	2	E	25,0	25,0	50,0	130,0	65,0	24,4	0,4	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

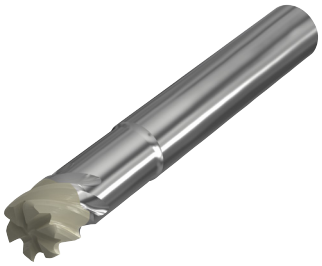
SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S1	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	43 (38 — 49) *140 (130–160)*
S2	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *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)*

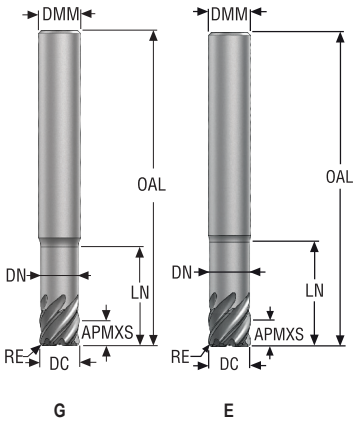
For cutting data recalculations, see pages 447 - 454

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

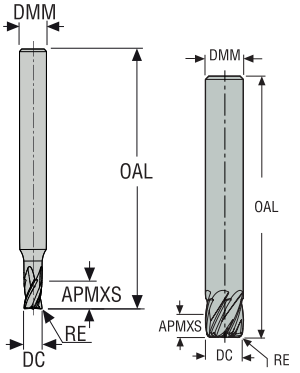
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
S1	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420–1300) *2725 (1400 — 4200)*
S2	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	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 447 - 454

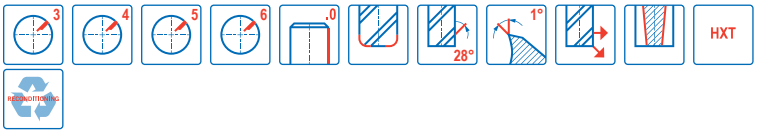
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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

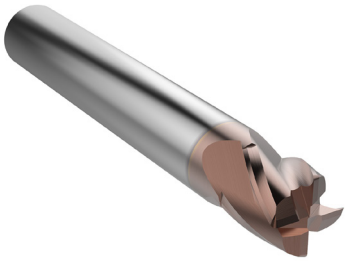
SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.750 *0,750*	0.12 *0,12*	0.050 *0,0020*	0.060 *0,0024*	55 (43 — 64) *180 (150 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	65 (54 — 93) *215 (180 — 300)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	50 (42–71) *165 (140 — 230)*

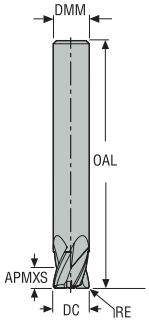
For cutting data recalculations, see pages 447 - 454

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 if DC is ≥Ø6

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)*

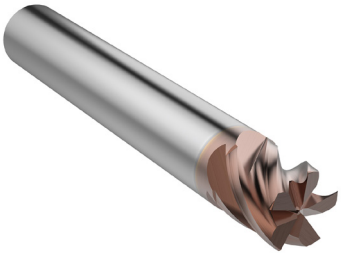
Cutting data – JH740 Face finishing PCEDC 5

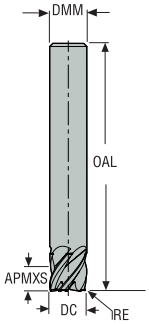
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130–190)*
S11	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	65 (51–75) *215 (170 — 240)*
S12	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130–190)*

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

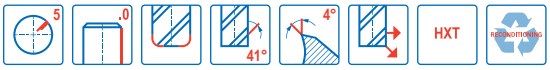
High speed – CoCr/Titanium – Square – 5 Flutes – Cylindrical – Corner radius





D

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



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.

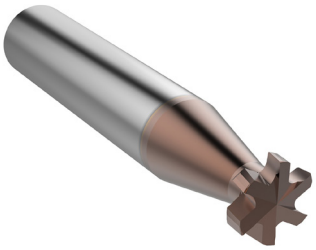
Cutting data – JH710 Side milling finishing

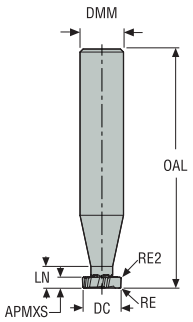
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.00810 *0,00810*	0.60 *0,60*	0.034 *0,0013*	0.044 *0,0017*	100 (79–110) *330 (260 — 360)*
S11	E	0.00810 *0,00810*	0.60 *0,60*	0.036 *0,0014*	0.046 *0,0018*	180 (160 — 200) *590 (530 — 650)*
S12	E	0.00810 *0,00810*	0.60 *0,60*	0.036 *0,0014*	0.046 *0,0018*	135 (120–150) *445 (400 — 490)*

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

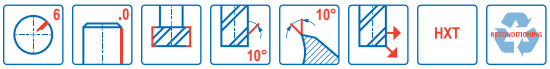
High speed – CoCr/Titanium – T Cutter – 6 Flutes – Cylindrical





G

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



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.

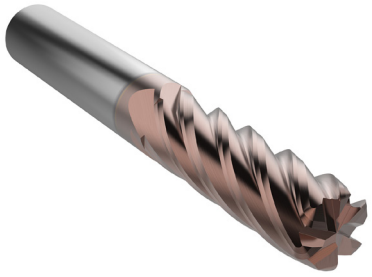
Cutting data – JH790 (T) Side milling roughing

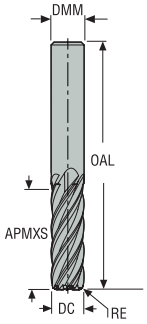
SMG		a_e/DC	a_p/DC	f_z	v_c
				9.5	
S2	E	0.189 *0,189*	0.19 *0,19*	0.030 *0,0012*	39 (31 — 50) *130 (110–160)*
S11	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	85 (66–100) *280 (220 — 320)*
S12	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	65 (51 — 80) *215 (170 — 260)*

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

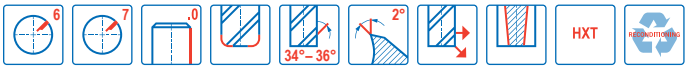
High speed – CoCr/Titanium – Square – 6-7 Flutes – Cylindrical – Corner radius





D

- 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		
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

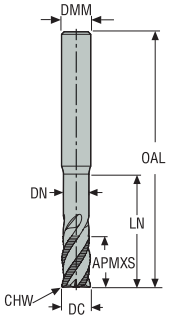
SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.0625 *0,0625*	1.8 *1,8*	0.020 *0,00080*	0.025 *0,0010*	80 (63 — 93) *260 (210 — 300)*
S11	E	0.0625 *0,0625*	1.8 *1,8*	0.016 *0,00065*	0.020 *0,00080*	135 (110–160) *445 (370 — 520)*
S12	E	0.0625 *0,0625*	1.8 *1,8*	0.016 *0,00065*	0.020 *0,00080*	105 (83–120) *345 (280 — 390)*

For cutting data recalculations, see pages 447 - 454

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

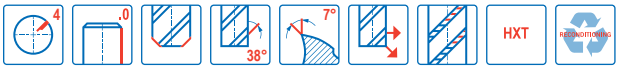
JHP994

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 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		
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)*

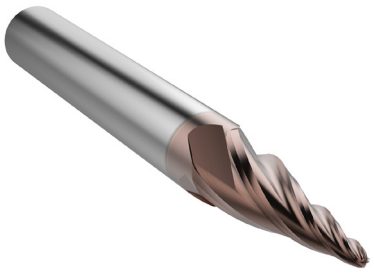
Cutting data – JHP994 Slot milling

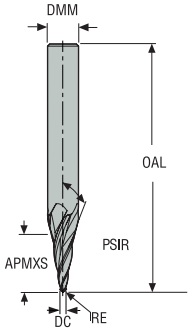
SMG		a_p/DC	f_z			v_c
			6	8	10	
S2	E	2.0 *2,0*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	33 (24 — 41) *110 (79–130)*
S11	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	42 (32 — 63) *140 (110 — 200)*
S12	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	33 (25 — 48) *110 (83–150)*

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

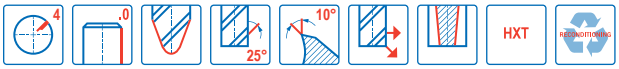
High speed – CoCr/Titanium – Tapered ball nose – 4 Flutes – Cylindrical





N

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



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 Side milling

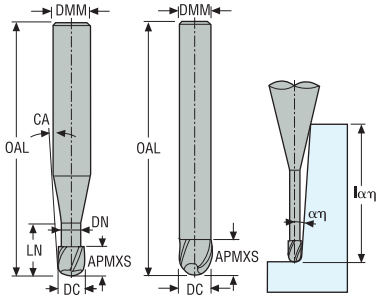
SMG		a_e/DC	a_p/DC	f_z				v_c
				1.8	2.8	3.8	4.9	
S2	E	0.0510 *0,0510*	4.2 *4,2*	0.0080 *0,00032*	0.012 *0,00048*	0.017 *0,00065*	0.022 *0,00085*	70 (54 — 86) *230 (180 — 280)*
S12	E	0.0510 *0,0510*	4.2 *4,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.013 *0,00050*	0.016 *0,00065*	95 (76–110) *310 (250 — 360)*

For cutting data recalculations, see pages 447 - 454

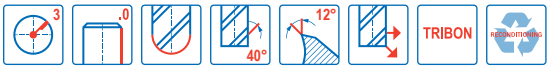
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH720

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	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	LN2	DN	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm	mm									
720020-TRIBON	00019845	2	G	2,0	6,0	3,0	60,0	6,0	18,1	1,9	7,0	3	6,5	7,0	7,4	7,7	8,2	9,2	■
720025-TRIBON	00019867	2	G	2,5	6,0	4,0	60,0	6,0	16,7	2,4	6,5	3	6,5	7,0	7,3	7,7	8,1	9,1	■
720030-TRIBON	00019906	2	G	3,0	6,0	4,5	60,0	6,5	19,1	2,8	5,0	3	7,0	8,2	8,7	9,3	10,0	11,9	■
720035-TRIBON	00019909	2	G	3,5	6,0	5,0	65,0	7,0	23,5	3,2	3,5	3	7,5	10,0	11,0	12,4	14,1	20,4	■
720040-TRIBON	00019918	2	G	4,0	6,0	6,0	65,0	8,0	21,6	3,7	3,0	3	8,5	11,1	12,2	13,7	15,6	–	■
720050-TRIBON	00019965	2	G	5,0	6,0	7,5	65,0	10,0	18,5	4,6	2,0	3	10,5	13,9	15,3	17,1	–	–	■
720060-TRIBON	00019990	2	D	6,0	6,0	9,0	75,0	–	–	–	–	3	9,0	–	–	–	–	–	■
720080-TRIBON	00020040	2	D	8,0	8,0	12,0	75,0	–	–	–	–	3	12,0	–	–	–	–	–	■
720100-TRIBON	00020043	2	D	10,0	10,0	15,0	80,0	–	–	–	–	3	15,0	–	–	–	–	–	■
720120-TRIBON	00020045	2	D	12,0	12,0	18,0	90,0	–	–	–	–	3	18,0	–	–	–	–	–	■
720160-TRIBON	00020048	2	D	16,0	16,0	24,0	100,0	–	–	–	–	3	24,0	–	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

Cutting data – JH720 Side milling roughing

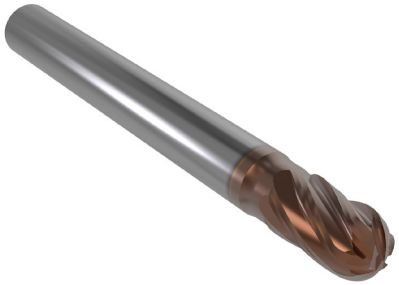
SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
M1	M/E/A	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	85 (62–110) *280 (210 — 360)*
M2	M/E/A	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	70 (51 — 91) *230 (170 — 290)*
M3	M/E/A	0.200 *0,200*	1.2 *1,2*	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*	65 (46 — 84) *215 (160 — 270)*
M4	M/E/A	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.050 *0,0020*	49 (35 — 64) *160 (120 — 200)*
M5	M/E/A	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.050 *0,0020*	41 (29 — 53) *135 (96–170)*
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	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*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	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*	500 (400 — 600) *1650 (1400–1900)*
N11	E/M/A	0.300 *0,300*	1.2 *1,2*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	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*	300 (260 — 340) *980 (860–1100)*
S1	E/M/A	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0080 *0,00032*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	43 (29 — 57) *140 (96–180)*
S2	E/M/A	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0080 *0,00032*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	35 (24 — 46) *115 (79–150)*
S3	E/M/A	0.100 *0,100*	1.2 *1,2*	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*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	30 (21 — 39) *100 (69–120)*
S11	E/M/A	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	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/M/A	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	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/M/A	0.300 *0,300*	1.2 *1,2*	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)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	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*	500 (400 — 600) *1650 (1400–1900)*
TP1	M	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	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*	500 (400 — 600) *1650 (1400–1900)*

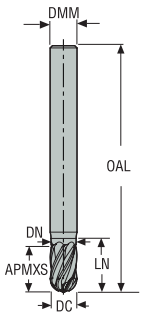
For cutting data recalculations, see pages 447 - 454

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

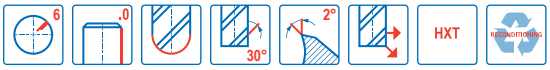
High speed – CoCr/Titanium – Ball nose – 6 Flutes – Cylindrical





E

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



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.

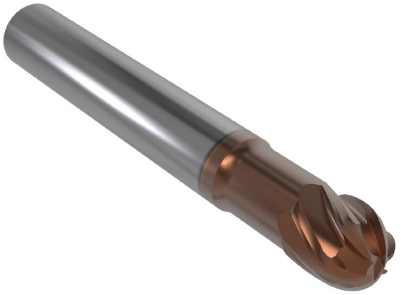
Cutting data – JH721 Copy milling finishing

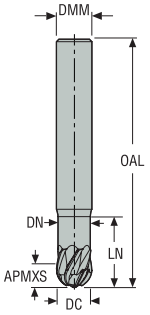
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	120 (110–140) *395 (370 — 450)*
S11	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	210 (140 — 230) *690 (460–750)*
S12	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	160 (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

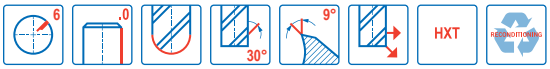
High speed – CoCr/Titanium – Ball nose – 6 Flutes – Cylindrical





E

- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,01 mm
- Regrind possible if DC is ≥Ø6



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.

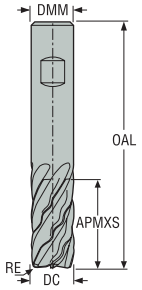
Cutting data – JH722 Copy milling finishing

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

JCO710

High performance – Titanium – Square – 4-6 Flutes – Weldon – Corner radius



D

- Tolerances:
- DMM= h6
- DC= k10
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JCO710160D2R100.3Z4	02810493	2	D	16,0	16,0	32,0	92,0	1,0	4	■
JCO710160D2R250.3Z4	02810494	2	D	16,0	16,0	32,0	92,0	2,5	4	■
JCO710160D2R400.3Z4	02810496	2	D	16,0	16,0	32,0	92,0	4,0	4	■
JCO710200D2R100.3Z4	02810497	2	D	20,0	20,0	38,0	114,0	1,0	4	■
JCO710200D2R400.3Z4	02810500	2	D	20,0	20,0	38,0	114,0	4,0	4	■
JCO710250D2R100.3Z6	02810501	2	D	25,0	25,0	45,0	121,0	1,0	6	■
JCO710320D2R100.3Z6	02810504	2	D	32,0	32,0	53,0	132,0	1,0	6	■
JCO710320D2R400.3Z6	02810505	2	D	32,0	32,0	53,0	132,0	4,0	6	■

■ Stocked standard.

Cutting data – JCO710 Side milling roughing PCEDC4 LV2

SMG		a_e/DC	a_p/DC	f_z				v_c
				16	20	25	32	
M1	E	0.500 *0,500*	1.2 *1,2*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	21 (15 — 28) *70 (50 — 91)*
M2	E	0.500 *0,500*	1.2 *1,2*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	17 (12 — 23) *55 (40–75)*
S11	E	0.500 *0,500*	1.1 *1,1*	0.0060 *0,00024*	0.0075 *0,00030*	0.0085 *0,00034*	0.010 *0,00040*	13 (9.4–18) *43 (31 — 59)*
S12	E	0.500 *0,500*	1.1 *1,1*	0.0060 *0,00024*	0.0075 *0,00030*	0.0085 *0,00034*	0.010 *0,00040*	10 (7.3–14) *33 (24 — 45)*
S13	E	0.500 *0,500*	1.1 *1,1*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	7 (5.7–11) *23 (19 — 36)*

Cutting data – JCO710 Side milling roughing PCEDC6 LV2

SMG		a_e/DC	a_p/DC	f_z				v_c
				20	25	32	40	
M1	E	0.480 *0,480*	1.2 *1,2*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	18 (13 — 24) *60 (43–78)*
M2	E	0.480 *0,480*	1.2 *1,2*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	15 (11 — 20) *49 (37 — 65)*
S11	E	0.480 *0,480*	1.2 *1,2*	0.075 *0,0030*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	11 (7.9–15) *36 (26 — 49)*
S12	E	0.480 *0,480*	1.2 *1,2*	0.075 *0,0030*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	8 (6.1–12) *26 (21 — 39)*
S13	E	0.480 *0,480*	1.2 *1,2*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	6 (4.9 — 9.6) *20 (17 — 31)*

Cutting data – JCO710 Slot milling PCEDC4 LV2

SMG		a_p/DC	f_z				v_c
			16	20	25	32	
M1	E	1.0 *1,0*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	19 (13 — 24) *60 (43–78)*
M2	E	1.0 *1,0*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	15 (10 — 20) *49 (33 — 65)*
M3	E	0.50 *0,50*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	10 (7.1–15) *33 (24 — 49)*
M4	E	0.50 *0,50*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	8 (5.4–11) *26 (18 — 36)*
M5	E	0.50 *0,50*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	6 (4.5 — 9.6) *20 (15 — 31)*
S11	E	0.75 *0,75*	0.0060 *0,00024*	0.0075 *0,00030*	0.0085 *0,00034*	0.010 *0,00040*	10 (7.8–15) *33 (26 — 49)*
S12	E	0.75 *0,75*	0.0060 *0,00024*	0.0075 *0,00030*	0.0085 *0,00034*	0.010 *0,00040*	8 (6.0–11) *26 (20 — 36)*
S13	E	0.75 *0,75*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	6 (4.7 — 9.3) *20 (16 — 30)*

When JCO + SIRA is applied: v_c table * 1.2

For cutting data recalculations, see pages 447 - 454

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,JM403/404/406, JH410 and JH440 for radius type.
- JH450, JH460 and JM413/416 for ball-nose type.

Tool selection Non ferrous

						
Name		JS412	JS413	JS452	JS453	JHP490
Page(s)		302	305	308	313	318
Family name		JS²	JS²	JS²	JS²	HPM
Type of mill						
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			●	●	●	●
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	JH410	JH421	JH440
Page(s)		322	329	325	331
Family name		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Type of mill					
Shank	Cylindrical	■	■	■	■
	Weldon				
	Safelock				
Number of Flutes		2	1	2	2
ICC				■	
Diameter range	Metric	2-20	2-17	2-25	6-8
	Inch				
Length availability					
		1,2,3	2,3	2	2
Operation					
					
SMG					
N1		•	•	•	•
N2					•
N3					•
TS1		•	•	•	•
TP1				•	•

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

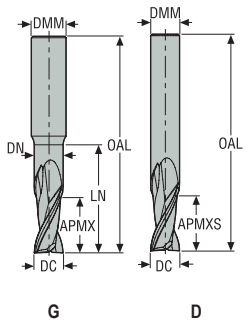
Tool selection Non ferrous

					
Name		JH450	JH460	JM403/404/406	JM413/416
Page(s)		333	335	337	339
Family name		HSM/TORNADO	HSM/TORNADO	MINI	MINI
Type of mill					
Shank	Cylindrical	■	■	■	■
	Weldon				
	Safelock				
Number of Flutes		2	2	1	2
ICC					
Diameter range	Metric	2-20	3-12	0,5-2	0,5-2
	Inch				
Length availability					
		2,3	2	2,5	2,3
Operation					
					
SMG					
N1		•	•	•	•
N2		•		•	•
N3		•		•	•
TS1		•	•		•
TP1		•	•		•

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

JS412

General purpose – Aluminium – Square – 2 Flutes – Cylindrical – Sharp



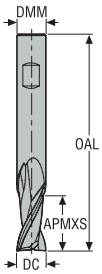
- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible if DC is ≥Ø6

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	■

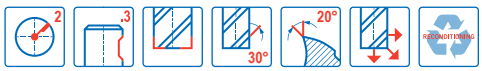
■ Stocked standard.

JS412

General purpose – Aluminium – Square – 2 Flutes – Weldon – Sharp



D



- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible if DC is ≥Ø6

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

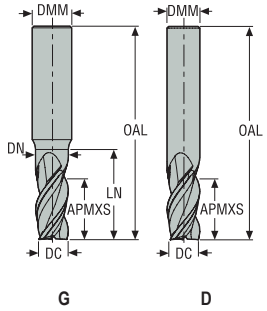
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
N2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	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 447 - 454

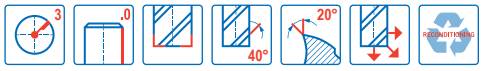
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JS413

General purpose – Aluminium – Square – 3 Flutes – Cylindrical – Sharp



G D



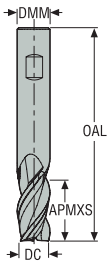
- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible if DC is ≥Ø6

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.

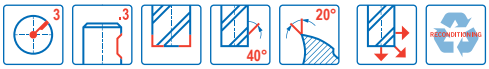
JS413

General purpose – Aluminium – Square – 3 Flutes – Weldon – Sharp



D

- Tolerances:
- DMM= h5
- DC= e8
- Regrind possible if DC is ≥Ø6



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

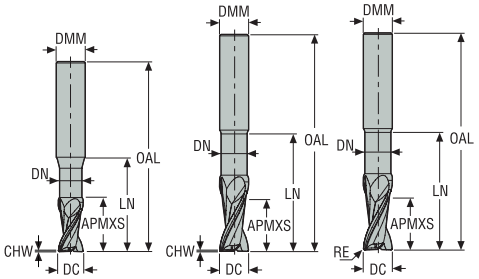
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (400 — 600) *1650 (1400–1900)*
N2	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	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 447 - 454

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



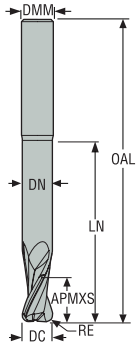
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Regrind possible if DC is ≥Ø6

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	■
JS452160E2R400Z2.0-HEMI	02881785	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	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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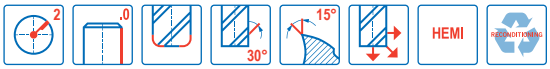


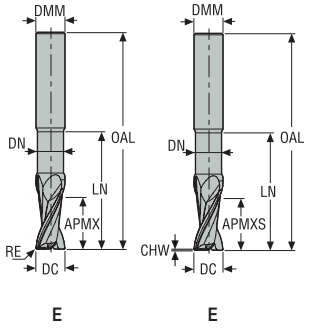
- Tolerances:
- DMM= h5
- DC= e8
- RE= ±0,02 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm		
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



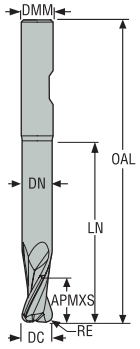
- Tolerances:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Regrind possible if DC is ≥Ø6

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		
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	☐
JS452160E2R400Z2.3-HEMI	02881952	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	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	☐

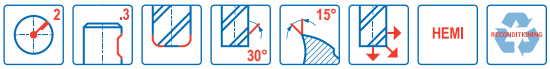
☐ Weldon available. Delivery time is 3 days.

JS452

High performance – Aluminium – Square – 2 Flutes – Weldon – Corner radius



E



- 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		
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*

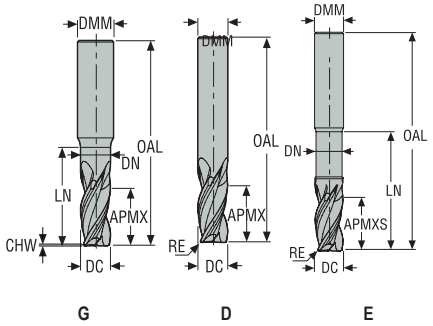
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
N2	E	1.2 *1,2*	0.016 *0,00065*	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 447 - 454

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



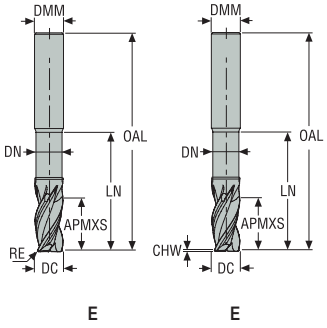
- Tolerances:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Regrind possible if DC is ≥Ø6

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	■
JS453200E2R400.0Z3-HEMI	02905292	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	4,0	3	■

■ Stocked standard.

JS453

High performance – Aluminium – Square – 3 Flutes – Cylindrical – Corner radius or chamfer



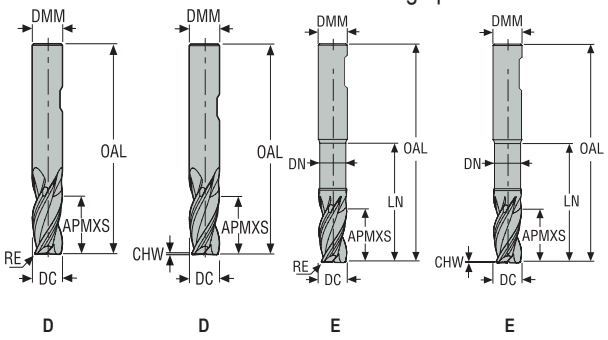
- Tolerances:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Regrind possible if DC is ≥Ø6

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		
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	■
JS453200E3R400.0Z3-HEMI	02905306	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	4,0	3	■

■ Stocked standard.

JS453

High performance – Aluminium – Square – 3 Flutes – Weldon – Corner radius or chamfer



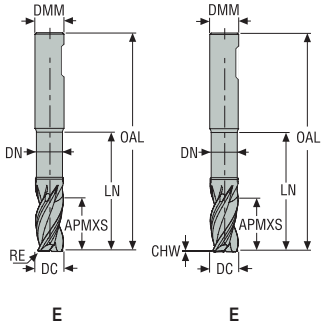
- Tolerances:
- DMM=h5
- DC=e7
- CHW= ±0,02 mm
- Regrind possible if DC is ≥Ø6

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		
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	☐
JS453200E2R400.3Z3-HEMI	02905320	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	4,0	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 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		
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	☐
JS453200E3R400.3Z3-HEMI	02905334	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	4,0	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

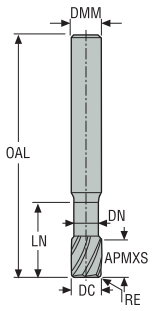
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
N2	E	1.2 *1,2*	0.016 *0,00065*	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 447 - 454

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

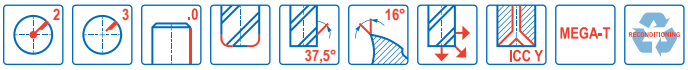
JHP490

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 if DC is ≥Ø6

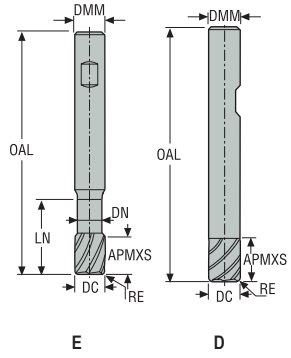


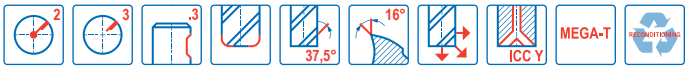
Designation	Item number	Length index	Tool shape	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Cylindrical
					mm	mm	mm	mm	mm	mm	mm		
490V100R050Z2.0A-MEGA-T	02623870	2	E	■	10,0	10,0	12,0	65,0	20,0	9,0	0,5	2	■
490V120R200Z2.0A-MEGA-T	02623883	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	■
490V160R050Z3.0A-MEGA-T	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.
ICC = Internal Coolant Channel

JHP490

High performance – Aluminium – Square – 2-3 Flutes – Weldon – Corner radius – ICC





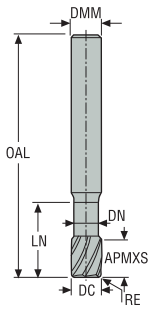
- Tolerances:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

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	□
490160R200Z3A-MEGA-T	02623898	2	D	■	16,0	16,0	34,0	95,0	–	–	2,0	3	■
490V160R050Z3A-MEGA-T	02623888	2	E	■	16,0	16,0	18,0	85,0	32,0	14,5	0,5	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.
ICC = Internal Coolant Channel

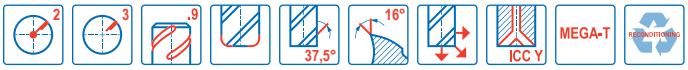
JHP490

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 if DC is ≥Ø6



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.
ICC = Internal Coolant Channel

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

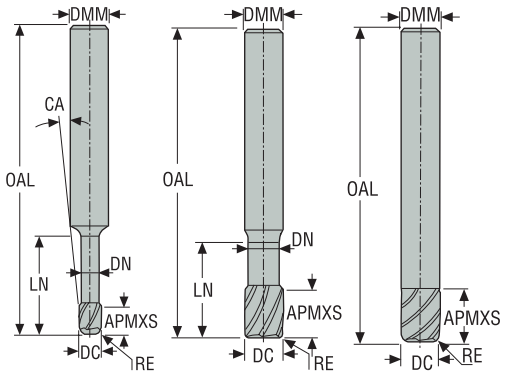
SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
N1	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	650 (500–790) *2125 (1700 — 2500)*
N2	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	420 (330 — 510) *1375 (1100–1600)*
N3	E/M/A	1.0 *1,0*	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)*

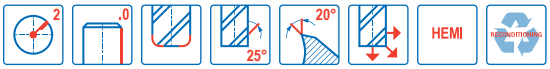
For cutting data recalculations, see pages 447 - 454

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

JH40

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius





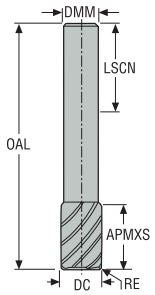
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,1 mm
- Regrind possible if DC is ≥Ø6

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

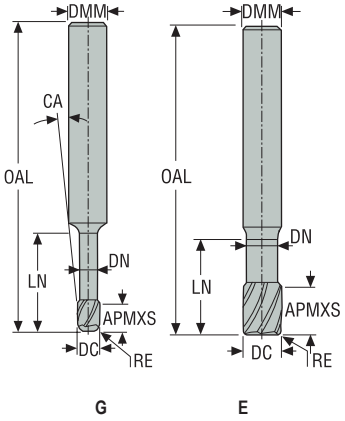
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.60 *0,60*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510–700) *1975 (1700 — 2200)*
N11	E/M/A	0.40 *0,40*	0.016 *0,00065*	0.024 *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)*

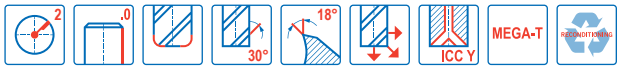
For cutting data recalculations, see pages 447 - 454

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





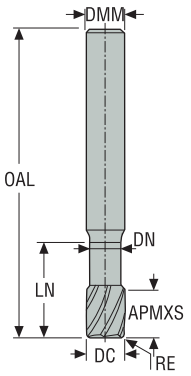
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

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	■

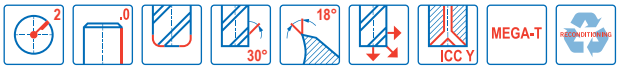
■ Stocked standard.
ICC = Internal Coolant Channel

JH421

High performance – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius – ICC



E



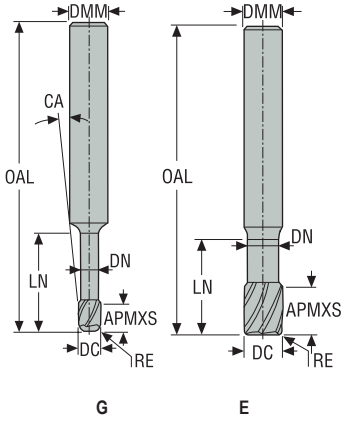
- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

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	■
421160R130Z2-MEGA-T	02435011	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	1,3	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	■
421200R600Z2-MEGA-T	02435056	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	6,0	2	■
421250R500Z2-MEGA-T	02435065	2	E	–	25,0	25,0	30,0	100,0	45,0	23,0	5,0	2	■

■ Stocked standard.
ICC = Internal Coolant Channel

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			
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	■
421L140R050Z2-MEGA-T	02462710	3	G	–	14,0	16,0	12,0	110,0	70,0	13,0	0,5	1,0	2	■
421L140R310Z2-MEGA-T	02462712	3	G	–	14,0	16,0	12,0	110,0	70,0	13,0	3,1	1,0	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.
ICC = Internal Coolant Channel

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 *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*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	0.28 *0,011*	620 (520–720) *2025 (1800 — 2300)*
N11	E/M/A	0.400 *0,400*	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*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	410 (310 — 510) *1350 (1100–1600)*
TS1	A	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*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	0.28 *0,011*	620 (520–720) *2025 (1800 — 2300)*
TP1	M	0.400 *0,400*	1.0 *1,0*	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*	0.24 *0,0095*	410 (310 — 500) *1350 (1100–1600)*

Cutting data – JH421 Slot milling

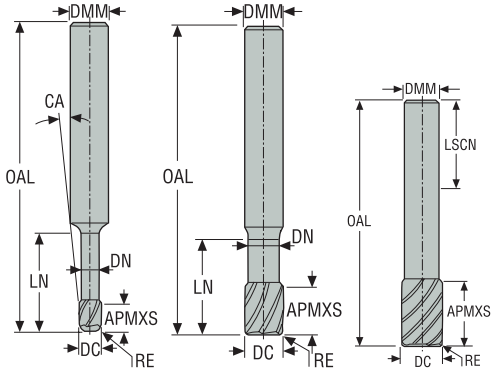
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.50 *0,50*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	610 (510–700) *2000 (1700 — 2200)*
N11	E/M/A	0.50 *0,50*	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*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	405 (310 — 500) *1325 (1100–1600)*
TS1	A	0.50 *0,50*	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*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	610 (510–700) *2000 (1700 — 2200)*
TP1	M	0.50 *0,50*	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*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	405 (310 — 500) *1325 (1100–1600)*

For cutting data recalculations, see pages 447 - 454

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= ±0,05 mm
- RE= ±0,05 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	■
410ML020R050-MEGA-T	02451577	2	G	2,0	6,0	3,0	50,0	12,0	36,0	1,7	0,5	7,5	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	■
410TL040R050-MEGA-T	02451582	2	G	4,0	6,0	5,0	60,0	21,0	36,0	3,6	0,5	2,5	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

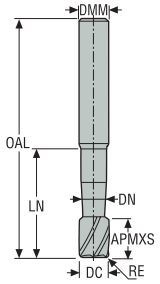
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.75 *0,75*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530–730) *2075 (1800 — 2300)*
N11	E/M/A	0.36 *0,36*	0.018 *0,00070*	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 447 - 454

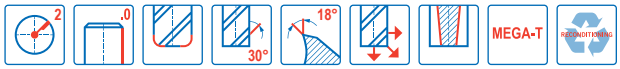
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH440

High speed – Aluminium – Square – 2 Flutes – Cylindrical – Corner radius



E



- Tolerances:
- DMM=h5
- DC=-0,02/-0,4 mm
- RE= ±0,05 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		
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

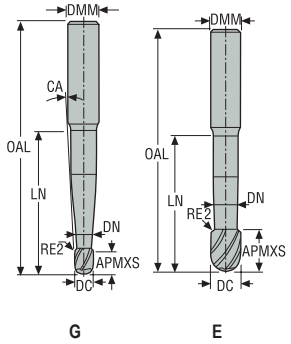
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
N1	E/M/A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
N2	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	510 (390 — 640) *1675 (1300 — 2000)*
N3	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	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 447 - 454

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

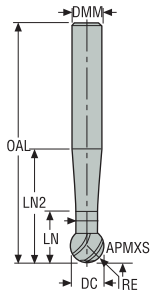
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	690 (670 — 930) *2275 (2200 — 3000)*
N2	E/M/A	0.300 *0,300*	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 447 - 454

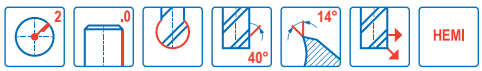
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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

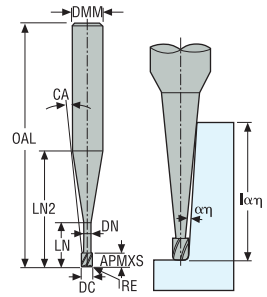
SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
N1	E/M/A	0.500 *0,500*	0.20 *0,20*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (500 — 680) *1925 (1700 — 2200)*
N11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	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 447 - 454

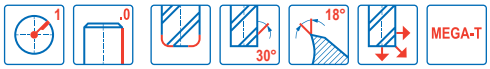
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JM403/JM404/JM406

Miniature – Aluminium – Square – 1 Flute – Cylindrical – Corner radius



G



- Tolerances:
- Run-out=<0,005 mm
- DMM= h5
- DC= Ø0,5-Ø0,6= -0,005/-0,013 mm
- DC= Ø0,8-Ø2,0= -0,005/-0,015 mm
- RE= ±0,01 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	1	11,0	1,5	1,6	1,7	1,7	1,8	1,9	■
403ML008R005-MEGA-T	02568450	2	G	0,8	3,0	0,8	40,0	2,5	7,1	0,75	0,05	1	9,0	2,5	2,6	2,7	2,8	2,9	3,2	■
403ML010R010-MEGA-T	02568456	2	G	1,0	3,0	1,0	40,0	4,0	8,3	0,95	0,1	1	7,5	4,0	4,2	4,3	4,5	4,6	5,0	■
406ML015R010-MEGA-T	02568478	5	G	1,5	6,0	1,5	50,0	5,0	14,0	1,4	0,1	1	9,5	5,1	5,3	5,5	5,7	5,9	6,4	■
404ML020R010-MEGA-T	02577246	5	G	2,0	4,0	2,0	40,0	6,0	10,4	1,9	0,1	1	6,0	6,1	6,3	6,6	6,8	7,0	7,6	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

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

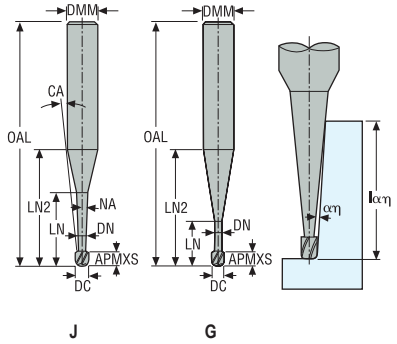
SMG		a_p/DC	f_z					v_c
			0.5	0.8	1	1.5	2	
N1	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	315 (270 — 360) *1025 (890–1100)*
N2	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	200 (170 — 230) *660 (560–750)*
N3	E	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 447 - 454

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 <0,6=-0,005/-0,013 mm, DC≥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	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	11,5	1,5	1,5	1,6	1,6	1,7	1,8	■
413L005-MEGA-T	02568711	3	G	0,5	3,0	0,375	40,0	2,5	7,7	0,45	0,25	2	10,0	2,5	2,6	2,7	2,8	2,9	3,1	■
413L008-MEGA-T	02568727	3	G	0,8	3,0	0,6	40,0	4,0	8,6	0,75	0,4	2	8,0	4,0	4,2	4,3	4,4	4,6	4,9	■
413L010-MEGA-T	02568736	3	G	1,0	3,0	0,75	40,0	5,0	9,3	0,95	0,5	2	7,0	5,0	5,2	5,4	5,5	5,7	6,2	■
416L015-MEGA-T	02568772	3	G	1,5	6,0	1,125	50,0	7,5	16,5	1,4	0,75	2	8,5	7,6	7,9	8,1	8,4	8,7	9,3	■
416L020-MEGA-T	02568779	3	G	2,0	6,0	1,5	50,0	10,0	18,1	1,9	1,0	2	7,0	10,1	10,4	10,8	11,1	11,5	12,4	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

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 447 - 454

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.

Tool selection Hard

							
Name		JHP170	JHF181	JH120	JH130	JH930	JH142
Page(s)		344	347	350	352	135, 354	196, 357
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

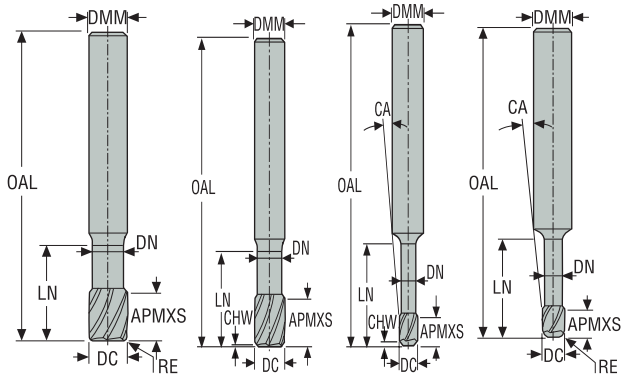
Tool selection Hard

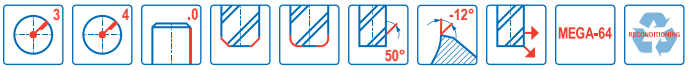
							
Name		JH112	JH150	JH160	JME142	JME144	JMB112
Page(s)		201, 360	363	365	367	372	374
Family name		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Type of mill							
Shank	Cylindrical	■	■	■	■	■	■
	Weldon						
Number of Flutes		2	4	4	2	4	2
ICC							
Diameter range	Metric	2-12	6-12	3-12	0,2- 3,0	1,0- 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





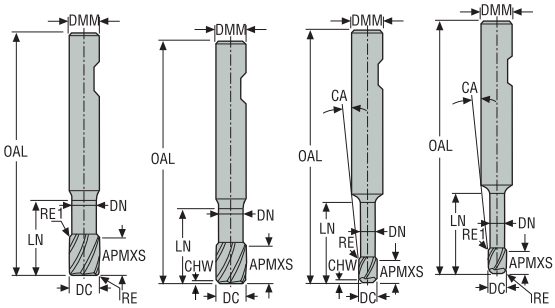
- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2- Ø4=+0,05 mm
- CHW= Ø5-Ø16=+0,1 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6

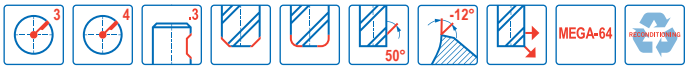
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Cylindrical
				mm	mm	mm	mm	mm	mm	mm	mm			
170020.0-MEGA-64	02462685	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	■
170020R020.0-MEGA-64	02587615	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	14,5	3	■
170020R050.0-MEGA-64	02587617	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

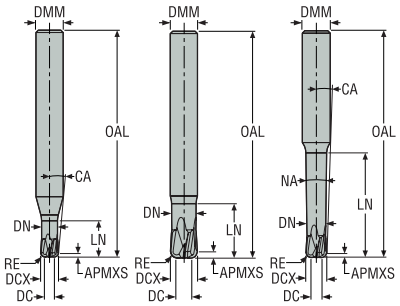
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
H3	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H5	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *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 447 - 454

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	15,0	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	15,0	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	15,0	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	15,0	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	15,0	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	15,0	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.

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 447 - 454

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

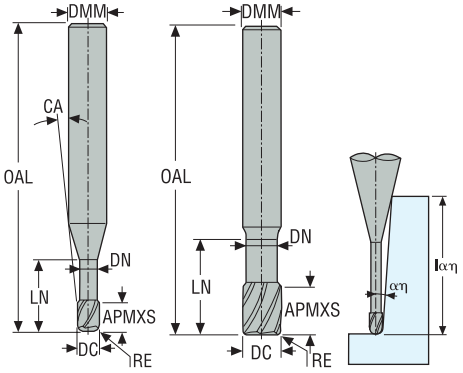
SMG		a_p/DCX	f_z								v_c
			2	3	4	6	8	10	12	16	
P6	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	270 (260 — 280) *890 (860 — 910)*
P7	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	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 447 - 454

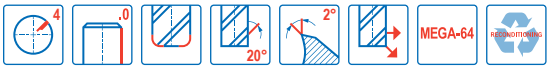
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JH120

High speed – Hardened steel – Square – 4 Flutes – Cylindrical – Corner radius



- Tolerances:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Regrind possible if DC is ≥Ø6



Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	5,0	5,4	5,6	5,7	5,9	6,2	■
120025-MEGA-64	00019448	2	G	2,5	6,0	3,0	50,0	6,0	2,4	0,25	8,5	4	6,0	6,4	6,6	6,8	7,0	7,5	■
120030-MEGA-64	00019450	2	G	3,0	6,0	4,0	50,0	7,0	2,8	0,3	7,0	4	7,0	7,7	8,0	8,2	8,5	9,2	■
120035-MEGA-64	00019460	2	G	3,5	6,0	4,5	50,0	8,0	3,2	0,35	5,5	4	8,0	9,0	9,3	9,7	10,0	10,9	■
120040-MEGA-64	00019462	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,4	4,5	4	9,0	10,0	10,4	10,8	11,2	12,2	■
120050-MEGA-64	00019476	2	G	5,0	6,0	6,0	50,0	12,0	4,6	0,5	2,5	4	12,0	13,0	13,4	13,7	14,1	14,9	■
120060-MEGA-64	00019479	2	E	6,0	6,0	7,0	55,0	14,0	5,6	0,6	–	4	14,0	–	–	–	–	–	■
120080-MEGA-64	00019481	2	E	8,0	8,0	10,0	60,0	18,0	7,4	0,8	–	4	18,0	–	–	–	–	–	■
120100-MEGA-64	00019494	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	4	25,0	–	–	–	–	–	■
120120-MEGA-64	00019501	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,2	–	4	30,0	–	–	–	–	–	■
120160-MEGA-64	00019503	2	E	16,0	16,0	18,0	90,0	35,0	15,4	1,6	–	4	35,0	–	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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

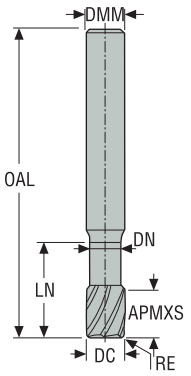
SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34–78) *180 (120 — 250)*
H5	M	0.18 *0,18*	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 447 - 454

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

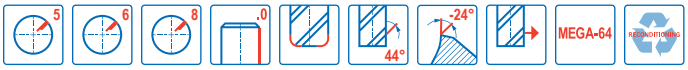
JH130

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 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		
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

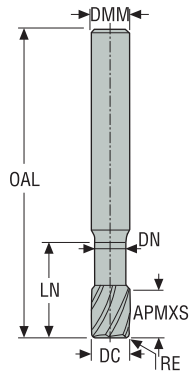
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	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 447 - 454

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 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		
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

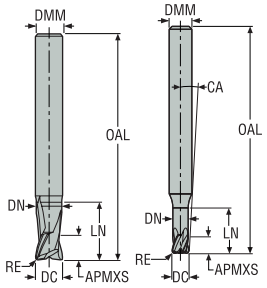
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300–1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	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 447 - 454

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



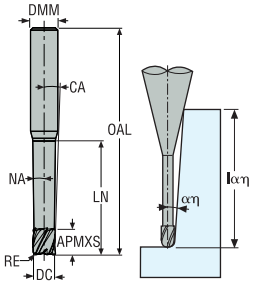
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	6,63	6,96	7,21	7,43	7,62	7,96	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	6,63	6,96	7,21	7,43	7,62	7,96	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	6,63	6,95	7,2	7,41	7,6	7,93	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	6,63	6,95	7,2	7,41	7,6	7,93	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	8,92	9,23	9,48	9,71	9,91	10,26	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	8,92	9,23	9,48	9,71	9,91	10,26	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	8,92	9,21	9,46	9,67	9,87	10,21	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	8,92	9,21	9,46	9,67	9,87	10,21	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	9,13	9,4	9,64	9,84	10,03	10,37	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	9,13	9,4	9,64	9,84	10,03	10,37	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	9,13	9,4	9,63	9,83	10,02	10,35	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	9,13	9,38	9,6	9,8	9,98	10,3	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	12,0	–	–	–	–	–	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	12,0	–	–	–	–	–	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	12,0	–	–	–	–	–	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	12,0	–	–	–	–	–	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	12,0	–	–	–	–	–	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	16,0	–	–	–	–	–	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	16,0	–	–	–	–	–	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	16,0	–	–	–	–	–	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	16,0	–	–	–	–	–	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	16,0	–	–	–	–	–	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	20,0	–	–	–	–	–	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	20,0	–	–	–	–	–	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	20,0	–	–	–	–	–	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	20,0	–	–	–	–	–	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	24,0	–	–	–	–	–	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	24,0	–	–	–	–	–	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	24,0	–	–	–	–	–	■

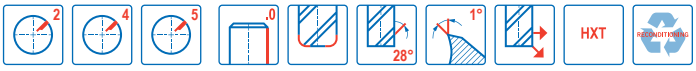
■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

JH142

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



J



- 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	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	5,23	10,27	10,95	11,31	11,69	12,54	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	4	5,23	10,27	10,95	11,31	11,69	12,54	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	2	5,23	10,24	10,94	11,29	11,66	12,5	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	4	5,23	10,24	10,94	11,29	11,66	12,5	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	2	9,57	15,58	16,22	16,75	17,32	18,57	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	4	9,57	15,58	16,22	16,75	17,32	18,57	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	2	9,57	15,54	16,19	16,7	17,25	18,46	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	4	9,57	15,54	16,19	16,7	17,25	18,46	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	4	13,87	20,79	21,52	22,23	22,99	–	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	2	13,87	20,79	21,52	22,23	22,99	–	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	4	13,87	20,78	21,51	22,21	22,97	–	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	2	13,87	20,78	21,51	22,21	22,97	–	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	2	13,87	20,76	21,48	22,16	22,9	–	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	4	13,87	20,76	21,48	22,16	22,9	–	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	4	19,15	30,85	31,88	32,93	–	–	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	5	19,15	30,85	31,88	32,93	–	–	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	4	19,15	30,83	31,85	32,88	–	–	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	5	19,15	30,83	31,85	32,88	–	–	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	5	19,15	30,8	31,82	32,83	–	–	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	5	19,15	30,78	31,78	32,78	–	–	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	5	27,67	41,12	42,44	–	–	–	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	5	27,67	41,11	42,41	–	–	–	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	5	27,67	41,09	42,38	–	–	–	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	5	27,67	41,08	42,35	–	–	–	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	5	29,67	50,97	52,62	–	–	–	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	5	29,67	50,95	52,59	–	–	–	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	5	29,67	50,91	52,53	–	–	–	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	4	5,23	11,4	21,0	21,71	22,45	24,11	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	4	5,23	11,14	20,99	21,69	22,43	24,06	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	4	9,57	20,92	31,32	32,35	33,46	–	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	4	9,57	20,3	31,29	32,31	33,39	–	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	4	13,87	30,85	41,65	–	–	–	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	4	13,87	30,6	41,65	–	–	–	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	4	13,87	29,98	41,6	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

Cutting data – JH142 Copy milling roughing

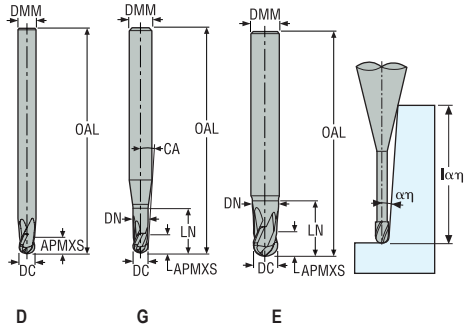
SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600–1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	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)*

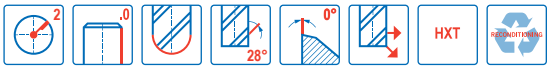
For cutting data recalculations, see pages 447 - 454

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





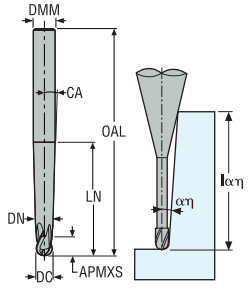
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Regrind possible if DC is ≥Ø6

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	4,66	4,84	5,03	5,24	5,47	6,03	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	3,3	2	6,96	7,29	7,66	8,08	8,56	9,78	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	–	2	4,0	–	–	–	–	–	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,0	2	12,09	12,96	14,01	15,29	16,89	–	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	–	2	6,0	–	–	–	–	–	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	–	2	8,0	–	–	–	–	–	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	–	2	10,0	–	–	–	–	–	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	2,5	2	10,79	11,1	11,42	11,77	–	–	■
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	4,0	–	–	–	–	–	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	–	2	5,0	–	–	–	–	–	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	–	2	6,0	–	–	–	–	–	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	8,12	2	4,66	4,84	5,03	5,24	5,47	6,03	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	7,39	2	5,66	5,87	6,1	6,36	6,64	7,31	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	5,5	2	6,97	7,31	7,7	8,14	8,65	9,95	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	3,81	2	8,62	9,24	9,99	10,9	12,05	15,49	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	3,34	2	9,62	10,31	11,14	12,15	13,42	17,25	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,0	2	12,09	12,96	14,01	15,29	16,89	–	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	2,78	2	14,09	15,1	16,31	17,79	19,64	25,2	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	–	2	16,0	–	–	–	–	–	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	–	2	20,0	–	–	–	–	–	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	–	2	24,0	–	–	–	–	–	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	3,82	2	20,66	21,59	22,61	23,73	24,98	27,94	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	2,91	2	20,97	22,18	23,55	25,11	26,92	31,51	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	1,97	2	21,62	23,39	25,53	28,13	–	–	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	0,53	2	52,09	56,58	–	–	–	–	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	5,6	–	2	6,0	–	–	–	–	–	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	7,4	–	2	8,0	–	–	–	–	–	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	9,4	–	2	10,0	–	–	–	–	–	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	11,4	–	2	12,0	–	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

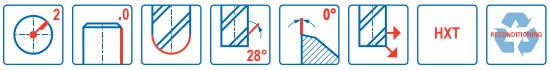
JH112

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



J

- 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	DN	NA°	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	3,09	3,43	3,91	4,63	5,81	14,63	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	2,8	2,5	2,2	2	5,7	6,75	8,51	12,03	22,61	–	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	3,7	1,4	1,2	2	10,58	15,35	32,07	–	–	–	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	4,6	1,95	1,6	2	11,47	14,56	20,93	41,46	–	–	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	5,6	1,4	1,1	2	14,72	21,24	44,08	–	–	–	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	7,4	1,43	1,0	2	20,71	29,7	59,65	–	–	–	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	9,4	1,5	1,0	2	22,16	30,75	56,56	–	–	–	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	5,6	2,3	2,0	2	11,59	13,99	18,22	27,78	69,22	–	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	7,4	2,3	1,8	2	16,24	19,64	25,68	39,27	98,24	–	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	9,4	1,1	0,8	2	26,26	43,99	–	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to αη (lαη, ref)*

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 447 - 454

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

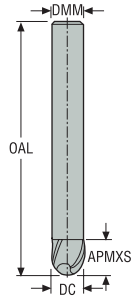
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100–1400)*
K2	E	0.250 *0,250*	0.15 *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 447 - 454

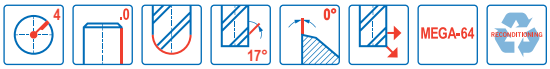
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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 if DC is ≥Ø6

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

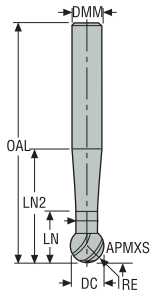
SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100–1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890–1000)*
K3	A	0.300 *0,300*	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 447 - 454

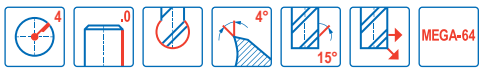
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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

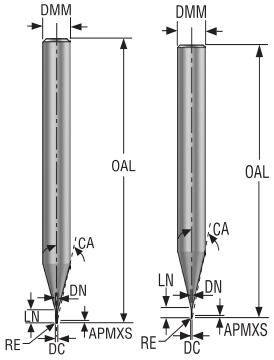
SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450–700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *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 447 - 454

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



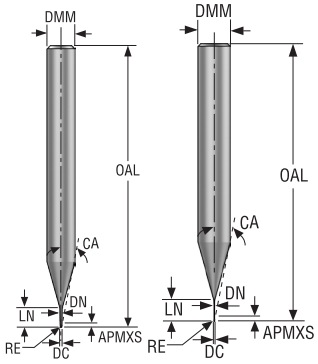
- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC <0,6 = 0-0,008 mm DC>0,6 = 0-0,01 mm
- RE = ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	15,12	2	0,48	0,5	0,51	0,53	0,55	0,58	■
JME142003G1R005Z2.0-HXT	03205082	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,05	14,77	2	0,68	0,7	0,73	0,75	0,77	0,81	■
JME142004G1R005Z2.0-HXT	03205084	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,05	14,39	2	0,9	0,93	0,95	0,98	1,01	1,07	■
JME142005G1R005Z2.0-HXT	03205086	1	G	0,5	4,0	0,375	40,0	0,75	0,46	0,05	14,01	2	1,13	1,15	1,18	1,21	1,25	1,32	■
JME142006G1R005Z2.0-HXT	03205099	1	G	0,6	4,0	0,45	40,0	0,9	0,56	0,05	13,67	2	1,32	1,35	1,39	1,43	1,47	1,55	■
JME142008G1R005Z2.0-HXT	03205121	1	G	0,8	6,0	0,6	50,0	1,2	0,76	0,05	13,98	2	1,72	1,76	1,81	1,86	1,91	2,02	■
JME142010G1R005Z2.0-HXT	03205139	1	G	1,0	6,0	0,75	50,0	1,5	0,95	0,05	13,49	2	2,14	2,19	2,25	2,31	2,37	2,51	■
JME142012G1R005Z2.0-HXT	03205151	1	G	1,2	6,0	0,9	50,0	1,8	1,15	0,05	13,02	2	2,54	2,6	2,67	2,74	2,81	2,98	■
JME142015G1R005Z2.0-HXT	03205161	1	G	1,5	6,0	1,125	50,0	2,25	1,45	0,05	12,3	2	3,14	3,22	3,3	3,38	3,47	3,68	■
JME142002J2R005Z2.0-HXT	03205081	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,05	14,23	2	0,54	0,72	0,81	0,89	0,95	1,07	■
JME142003J2R005Z2.0-HXT	03205083	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,05	13,67	2	0,61	1,0	1,13	1,23	1,31	1,44	■
JME142004J2R005Z2.0-HXT	03205085	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,05	13,1	2	1,01	1,37	1,5	1,59	1,68	1,83	■
JME142005J2R005Z2.0-HXT	03205087	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,05	12,54	2	1,41	1,72	1,85	1,95	2,04	2,2	■
JME142005G2R005Z2.0-HXT	03205088	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,05	13,5	2	1,78	1,9	2,0	2,09	2,16	2,32	■
JME142005J2R010Z2.0-HXT	03205093	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,1	12,61	2	1,41	1,72	1,84	1,95	2,03	2,19	■
JME142005G2R010Z2.0-HXT	03205094	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,1	13,55	2	1,78	1,9	1,99	2,08	2,16	2,31	■
JME142006J2R005Z2.0-HXT	03205100	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,05	11,76	2	1,42	2,18	2,36	2,48	2,59	2,78	■
JME142006G2R005Z2.0-HXT	03205101	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,05	9,48	2	2,27	2,42	2,54	2,67	2,82	3,16	■
JME142006J2R010Z2.0-HXT	03205107	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,1	11,83	2	1,42	2,18	2,35	2,48	2,58	2,77	■
JME142006G2R010Z2.0-HXT	03205108	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,1	9,51	2	2,27	2,42	2,54	2,66	2,81	3,14	■
JME142008J2R005Z2.0-HXT	03205122	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,05	10,92	2	1,56	2,67	2,88	3,02	3,14	3,37	■
JME142008G2R005Z2.0-HXT	03205123	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,05	9,15	2	2,77	2,95	3,09	3,25	3,43	3,84	■
JME142008J2R010Z2.0-HXT	03205129	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,1	10,98	2	1,57	2,66	2,87	3,01	3,13	3,36	■
JME142008G2R010Z2.0-HXT	03205130	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,1	9,17	2	2,77	2,94	3,09	3,24	3,41	3,82	■
JME142008J2R020Z2.0-HXT	03205135	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,2	11,1	2	1,57	2,65	2,86	3,0	3,12	3,34	■
JME142008G2R020Z2.0-HXT	03205136	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,2	9,22	2	2,77	2,94	3,08	3,23	3,39	3,79	■
JME142010G2R005Z2.0-HXT	03205140	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,05	8,29	2	4,32	4,55	4,77	5,01	5,29	5,93	■
JME142010G2R010Z2.0-HXT	03205145	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,1	8,31	2	4,32	4,54	4,76	5,01	5,27	5,91	■
JME142010G2R020Z2.0-HXT	03205148	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,2	8,36	2	4,32	4,54	4,75	4,99	5,25	5,88	■
JME142012G2R005Z2.0-HXT	03205152	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,05	7,97	2	4,82	5,07	5,32	5,59	5,89	6,62	■
JME142012G2R010Z2.0-HXT	03205155	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,1	7,99	2	4,82	5,07	5,31	5,58	5,88	6,6	■
JME142012G2R020Z2.0-HXT	03205158	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,2	8,04	2	4,82	5,06	5,3	5,57	5,86	6,56	■
JME142015G2R005Z2.0-HXT	03205162	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,05	7,6	2	5,32	5,59	5,87	6,17	6,5	7,3	■
JME142015G2R010Z2.0-HXT	03205167	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,1	9,7	2	5,32	5,58	5,77	5,96	6,16	6,61	■
JME142015G2R020Z2.0-HXT	03205171	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,2	9,76	2	5,32	5,57	5,76	5,95	6,15	6,59	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

JME142

Miniature – Hardened steel – Square – 2 Flutes – Cylindrical – Corner radius



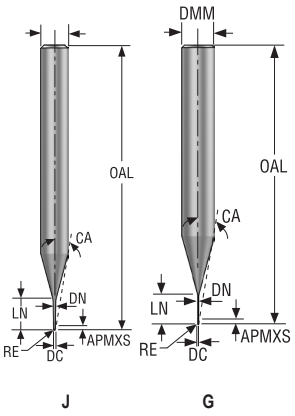
- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC <0,6 = 0-0,008 mm DC>0,6 = 0-0,01 mm
- RE = ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm	mm									
JME142018G2R005Z2.0-HXT	03205174	2	G	1,8	6,0	1,35	50,0	5,0	1,75	0,05	2	9,4	5,32	5,58	5,77	5,96	6,17	6,62	■
JME142018G2R010Z2.0-HXT	03205177	2	G	1,8	6,0	1,35	50,0	5,0	1,75	0,1	2	9,43	5,32	5,58	5,77	5,96	6,16	6,61	■
JME142020G2R005Z2.0-HXT	03205180	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,05	2	8,52	6,35	6,64	6,85	7,08	7,33	7,87	■
JME142020G2R010Z2.0-HXT	03205185	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,1	2	8,55	6,35	6,64	6,85	7,08	7,32	7,86	■
JME142020G2R020Z2.0-HXT	03205188	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,2	2	8,6	6,35	6,63	6,84	7,07	7,3	7,84	■
JME142020G2R030Z2.0-HXT	03205191	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,3	2	8,66	6,35	6,63	6,84	7,06	7,29	7,81	■
JME142025G2R005Z2.0-HXT	03205192	2	G	2,5	6,0	1,875	50,0	7,5	2,4	0,05	2	7,1	7,97	8,26	8,52	8,81	9,11	9,79	■
JME142025G2R010Z2.0-HXT	03205195	2	G	2,5	6,0	1,875	50,0	7,5	2,4	0,1	2	7,13	7,97	8,26	8,52	8,8	9,11	9,78	■
JME142025G2R020Z2.0-HXT	03205198	2	G	2,5	6,0	1,875	50,0	7,5	2,4	0,2	2	7,17	7,97	8,25	8,51	8,79	9,09	9,76	■
JME142030G2R005Z2.0-HXT	03205201	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,05	2	5,81	9,59	9,9	10,21	10,56	10,92	11,73	■
JME142030G2R010Z2.0-HXT	03205205	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,1	2	5,82	9,59	9,89	10,21	10,55	10,91	11,72	■
JME142030G2R020Z2.0-HXT	03205208	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,2	2	5,86	9,59	9,89	10,2	10,54	10,9	11,7	■
JME142030G2R030Z2.0-HXT	03205211	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,3	2	5,9	9,59	9,89	10,2	10,53	10,89	11,68	■
JME142005J3R005Z2.0-HXT	03205089	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,05	2	11,24	1,41	2,63	2,86	3,01	3,13	3,36	■
JME142005G3R005Z2.0-HXT	03205090	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,05	2	11,55	3,78	4,0	4,16	4,3	4,44	4,77	■
JME142005J3R010Z2.0-HXT	03205095	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,1	2	11,29	1,41	2,62	2,86	3,0	3,12	3,35	■
JME142005G3R010Z2.0-HXT	03205096	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,1	2	11,59	3,78	4,0	4,15	4,29	4,44	4,76	■
JME142006J3R005Z2.0-HXT	03205103	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,05	2		1,42	3,05	3,37	3,54	3,67	3,94	■
JME142006G3R005Z2.0-HXT	03205104	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,05	2	8,46	4,27	4,52	4,74	4,98	5,25	5,9	■
JME142006J3R010Z2.0-HXT	03205109	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,1	2		1,42	3,04	3,36	3,53	3,66	3,93	■
JME142006G3R010Z2.0-HXT	03205110	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,1	2	8,48	4,27	4,52	4,73	4,98	5,24	5,88	■
JME142008J3R005Z2.0-HXT	03205124	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,05	2	9,36	1,56	3,46	4,39	4,59	4,75	5,1	■
JME142008G3R005Z2.0-HXT	03205126	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,05	2	9,89	5,77	6,08	6,28	6,49	6,72	7,21	■
JME142008J3R010Z2.0-HXT	03205131	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,1	2	9,4	1,57	3,4	4,39	4,59	4,75	5,09	■
JME142008G3R010Z2.0-HXT	03205132	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,1	2	9,92	5,77	6,08	6,28	6,49	6,71	7,2	■
JME142008G3R020Z2.0-HXT	03205137	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,2	2	9,98	5,77	6,07	6,27	6,48	6,7	7,18	■
JME142010G3R005Z2.0-HXT	03205141	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,05	2	8,84	7,32	7,65	7,9	8,16	8,44	9,07	■
JME142010G3R010Z2.0-HXT	03205146	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,1	2	8,86	7,32	7,65	7,9	8,16	8,44	9,06	■
JME142010G3R020Z2.0-HXT	03205149	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,2	2	8,91	7,32	7,65	7,89	8,15	8,42	9,04	■
JME142012G3R005Z2.0-HXT	03205153	3	G	1,2	6,0	0,9	50,0	8,0	1,15	0,05	2	8,16	8,32	8,68	8,96	9,26	9,58	10,29	■
JME142012G3R010Z2.0-HXT	03205156	3	G	1,2	6,0	0,9	50,0	8,0	1,15	0,1	2	8,19	8,32	8,68	8,96	9,26	9,58	10,28	■
JME142012G3R020Z2.0-HXT	03205159	3	G	1,2	6,0	0,9	50,0	8,0	1,15	0,2	2	8,23	8,32	8,68	8,95	9,25	9,56	10,26	■
JME142015G3R005Z2.0-HXT	03205163	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,05	2	7,05	10,32	10,75	11,09	11,46	11,86	12,74	■
JME142015G3R010Z2.0-HXT	03205169	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,1	2	7,06	10,32	10,75	11,09	11,46	11,85	12,73	■
JME142015G3R020Z2.0-HXT	03205172	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,2	2	7,1	10,32	10,74	11,08	11,45	11,84	12,71	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to a_n ($l a_n$, ref)*

JME142

Miniature – Hardened steel – Square – 2 Flutes – Cylindrical – Corner radius



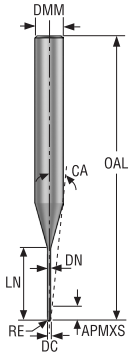
- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC <0,6 = 0-0,008 mm DC>0,6 = 0-0,01 mm
- RE = ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm	mm									
JME142018G3R005Z2.0-HXT	03205175	3	G	1,8	6,0	1,35	50,0	10,0	1,75	0,05	2	6,77	10,32	10,75	11,09	11,46	11,86	12,74	■
JME142018G3R010Z2.0-HXT	03205178	3	G	1,8	6,0	1,35	50,0	10,0	1,75	0,1	2	6,79	10,32	10,75	11,09	11,46	11,85	12,73	■
JME142020G3R005Z2.0-HXT	03205181	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,05	2	5,9	12,35	12,83	13,24	13,68	14,16	15,21	■
JME142020G3R010Z2.0-HXT	03205186	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,1	2	5,92	12,35	12,83	13,24	13,68	14,15	15,2	■
JME142020G3R020Z2.0-HXT	03205189	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,2	2	5,95	12,35	12,82	13,23	13,67	14,14	15,18	■
JME142025G3R005Z2.0-HXT	03205193	3	G	2,5	6,0	1,875	50,0	12,5	2,4	0,05	2	5,25	12,97	13,42	13,85	14,31	14,81	15,91	■
JME142025G3R010Z2.0-HXT	03205196	3	G	2,5	6,0	1,875	50,0	12,5	2,4	0,1	2	5,27	12,97	13,41	13,85	14,31	14,8	15,9	■
JME142025G3R020Z2.0-HXT	03205199	3	G	2,5	6,0	1,875	50,0	12,5	2,4	0,2	2	5,29	12,97	13,41	13,84	14,3	14,79	15,88	■
JME142030G3R005Z2.0-HXT	03205202	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,05	2	4,14	15,59	16,08	16,6	17,16	17,75	19,07	■
JME142030G3R010Z2.0-HXT	03205206	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,1	2	4,15	15,59	16,08	16,6	17,15	17,75	19,06	■
JME142030G3R020Z2.0-HXT	03205209	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,2	2	4,17	15,59	16,08	16,59	17,14	17,73	19,04	■
JME142030G3R030Z2.0-HXT	03205212	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,3	2	4,19	15,59	16,08	16,59	17,13	17,72	19,02	■
JME142005J4R005Z2.0-HXT	03205091	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,05	2	9,71	1,41	3,12	4,38	4,58	4,74	5,09	■
JME142005G4R005Z2.0-HXT	03205092	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,05	2		5,28	5,56	5,75	5,95	6,15	6,61	■
JME142005J4R010Z2.0-HXT	03205097	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,1	2	9,76	1,41	3,06	4,37	4,58	4,74	5,08	■
JME142005G4R010Z2.0-HXT	03205098	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,1	2		5,28	5,56	5,75	5,94	6,14	6,6	■
JME142006J4R005Z2.0-HXT	03205105	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,05	2	8,79	1,42	3,13	5,39	5,63	5,82	6,26	■
JME142006G4R005Z2.0-HXT	03205106	4	G	0,6	6,0	0,45	50,0	6,0	0,56	0,05	2	9,72	6,27	6,6	6,82	7,04	7,29	7,83	■
JME142006J4R010Z2.0-HXT	03205118	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,1	2	8,83	1,42	3,08	5,39	5,62	5,81	6,24	■
JME142006G4R010Z2.0-HXT	03205120	4	G	0,6	6,0	0,45	50,0	6,0	0,56	0,1	2	9,75	6,27	6,59	6,81	7,04	7,28	7,82	■
JME142008J4R005Z2.0-HXT	03205127	4	J	0,8	4,0	0,6	40,0	7,0	0,76	0,05	2	7,28	1,56	3,46	7,43	7,72	7,98	8,57	■
JME142008G4R005Z2.0-HXT	03205128	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,05	2	8,49	8,27	8,67	8,95	9,24	9,56	10,27	■
JME142008J4R010Z2.0-HXT	03205133	4	J	0,8	4,0	0,6	40,0	7,0	0,76	0,1	2	7,3	1,57	3,4	7,42	7,71	7,98	8,56	■
JME142008G4R010Z2.0-HXT	03205134	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,1	2	8,51	8,27	8,66	8,94	9,24	9,56	10,26	■
JME142008G4R020Z2.0-HXT	03205138	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,2	2	8,56	8,27	8,66	8,94	9,23	9,54	10,24	■
JME142010G4R005Z2.0-HXT	03205142	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,05	2	7,47	10,32	10,75	11,09	11,46	11,86	12,74	■
JME142010G4R010Z2.0-HXT	03205147	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,1	2	7,48	10,32	10,75	11,09	11,46	11,85	12,73	■
JME142010G4R020Z2.0-HXT	03205150	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,2	2	7,52	10,32	10,74	11,08	11,45	11,84	12,71	■
JME142012G4R005Z2.0-HXT	03205154	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,05	2	6,61	12,32	12,81	13,22	13,66	14,14	15,19	■
JME142012G4R010Z2.0-HXT	03205157	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,1	2	6,62	12,32	12,81	13,22	13,66	14,13	15,18	■
JME142012G4R020Z2.0-HXT	03205160	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,2	2	6,65	12,32	12,8	13,21	13,65	14,12	15,16	■
JME142015G4R005Z2.0-HXT	03205164	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,05	2	5,54	15,32	15,9	16,42	16,97	17,55	18,86	■
JME142015G4R010Z2.0-HXT	03205170	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,1	2	5,55	15,32	15,9	16,41	16,96	17,55	18,85	■
JME142015G4R020Z2.0-HXT	03205173	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,2	2	5,58	15,32	15,9	16,41	16,95	17,53	18,83	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

JME142

Miniature – Hardened steel – Square – 2 Flutes – Cylindrical – Corner radius



G

- Tolerances:
- Run-out= <0,005 mm
- DMM = h5
- DC <0,6 = 0-0,008 mm DC>0,6 = 0-0,01 mm
- RE = ±0,005 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm	mm									
JME142018G4R005Z2.0-HXT	03205176	4	G	1,8	6,0	1,35	60,0	18,0	1,75	0,05	2	4,68	18,32	19,0	19,61	20,27	20,97	22,53	■
JME142018G4R010Z2.0-HXT	03205179	4	G	1,8	6,0	1,35	60,0	18,0	1,75	0,1	2	4,69	18,32	19,0	19,61	20,26	20,96	22,52	■
JME142020G4R005Z2.0-HXT	03205182	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,05	2	4,19	20,35	21,08	21,76	22,49	23,27	25,0	■
JME142020G4R010Z2.0-HXT	03205187	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,1	2	4,19	20,35	21,08	21,76	22,48	23,26	24,99	■
JME142020G4R020Z2.0-HXT	03205190	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,2	2	4,21	20,35	21,07	21,75	22,47	23,25	24,97	■
JME142025G4R005Z2.0-HXT	03205194	4	G	2,5	6,0	1,875	65,0	25,0	2,4	0,05	2	3,18	25,47	26,31	27,16	28,07	29,04	31,2	■
JME142025G4R010Z2.0-HXT	03205197	4	G	2,5	6,0	1,875	65,0	25,0	2,4	0,1	2	3,19	25,47	26,31	27,16	28,06	29,03	31,19	■
JME142025G4R020Z2.0-HXT	03205200	4	G	2,5	6,0	1,875	65,0	25,0	2,4	0,2	2	3,2	25,47	26,3	27,15	28,05	29,02	31,17	■
JME142030G4R010Z2.0-HXT	03205207	4	G	3,0	6,0	2,25	80,0	30,0	2,85	0,1	2	2,41	30,59	31,55	32,57	33,66	34,83	–	■
JME142030G4R020Z2.0-HXT	03205210	4	G	3,0	6,0	2,25	80,0	30,0	2,85	0,2	2	2,42	30,59	31,55	32,57	33,65	34,81	–	■
JME142030G4R030Z2.0-HXT	03205213	4	G	3,0	6,0	2,25	80,0	30,0	2,85	0,3	2	2,42	30,59	31,55	32,56	33,64	34,8	–	■
JME142010G5R005Z2.0-HXT	03205143	5	G	1,0	6,0	0,75	60,0	15,0	0,95	0,05	2	5,93	15,32	15,9	16,42	16,97	17,55	18,86	■
JME142015G5R005Z2.0-HXT	03205165	5	G	1,5	6,0	1,125	80,0	22,5	1,45	0,05	2	4,2	22,82	23,64	24,4	25,22	26,09	28,04	■
JME142020G5R005Z2.0-HXT	03205183	5	G	2,0	6,0	1,5	80,0	30,0	1,94	0,05	2	3,07	30,35	31,39	32,41	33,49	34,65	37,24	■
JME142030G5R005Z2.0-HXT	03205203	5	G	3,0	6,0	2,25	90,0	45,0	2,85	0,05	2	1,7	45,59	47,03	48,55	50,17	–	–	■
JME142010G6R005Z2.0-HXT	03205144	6	G	1,0	6,0	0,75	60,0	20,0	0,95	0,05	2	4,92	20,32	21,06	21,74	22,47	23,25	24,98	■
JME142015G6R005Z2.0-HXT	03205166	6	G	1,5	6,0	1,125	80,0	30,0	1,45	0,05	2	3,37	30,32	31,37	32,39	33,47	34,63	37,21	■
JME142020G6R005Z2.0-HXT	03205184	6	G	2,0	6,0	1,5	80,0	40,0	1,94	0,05	2	2,42	40,35	41,71	43,06	44,5	46,04	–	■
JME142030G6R005Z2.0-HXT	03205204	6	G	3,0	6,0	2,25	90,0	60,0	2,85	0,05	2	1,31	60,59	62,5	64,52	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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

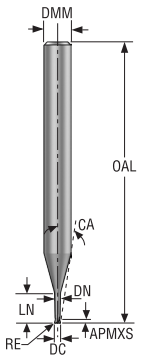
SMG		a_p/DC	f_z													v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	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 447 - 454

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	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	4	9,08	2,04	4,12	4,44	4,62	4,78	5,14	■
JME144010J2R010Z4.0-HXT	03205217	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,1	4	9,13	2,04	4,11	4,43	4,62	4,78	5,13	■
JME144010J2R020Z4.0-HXT	03205220	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,2	4	9,22	2,04	4,09	4,42	4,61	4,76	5,1	■
JME144012J2R005Z4.0-HXT	03205221	2	J	1,2	4,0	0,9	50,0	4,5	1,15	0,05	4	8,37	2,18	4,59	4,96	5,15	5,33	5,72	■
JME144012J2R010Z4.0-HXT	03205224	2	J	1,2	4,0	0,9	50,0	4,5	1,15	0,1	4	8,41	2,18	4,59	4,95	5,15	5,33	5,71	■
JME144015J2R005Z4.0-HXT	03205227	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,05	4	7,52	2,4	5,09	5,48	5,69	5,88	6,32	■
JME144015J2R010Z4.0-HXT	03205229	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,1	4	7,56	2,4	5,08	5,47	5,68	5,87	6,31	■
JME144015J2R020Z4.0-HXT	03205232	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,2	4	7,63	2,4	5,06	5,47	5,67	5,86	6,28	■
JME144020J2R005Z4.0-HXT	03205234	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,05	4	5,97	3,09	6,16	6,54	6,77	7,0	7,52	■
JME144020J2R010Z4.0-HXT	03205236	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,1	4	6,0	3,09	6,15	6,54	6,76	6,99	7,51	■
JME144020J2R020Z4.0-HXT	03205239	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,2	4	6,06	3,1	6,14	6,53	6,75	6,98	7,49	■
JME144020J2R030Z4.0-HXT	03205241	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,3	4	6,12	3,1	6,13	6,52	6,74	6,97	7,47	■
JME144030J2R010Z4.0-HXT	03205243	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,1	4	2,66	6,76	9,44	9,78	10,1	10,45	–	■
JME144030J2R020Z4.0-HXT	03205246	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,2	4	2,69	6,76	9,44	9,77	10,09	10,44	–	■
JME144010J3R005Z4.0-HXT	03205215	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,05	4	8,27	2,04	4,52	5,45	5,66	5,86	6,29	■
JME144010J3R010Z4.0-HXT	03205218	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,1	4	8,3	2,04	4,47	5,44	5,66	5,85	6,28	■
JME144012J3R005Z4.0-HXT	03205222	3	J	1,2	4,0	0,9	50,0	6,0	1,15	0,05	4	7,3	2,18	4,85	6,47	6,71	6,94	7,46	■
JME144012J3R010Z4.0-HXT	03205225	3	J	1,2	4,0	0,9	50,0	6,0	1,15	0,1	4	7,33	2,18	4,79	6,47	6,71	6,94	7,45	■
JME144015J3R005Z4.0-HXT	03205228	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,05	4	6,04	2,4	5,34	8,0	8,29	8,57	9,21	■
JME144015J3R010Z4.0-HXT	03205230	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,1	4	6,06	2,4	5,28	8,0	8,28	8,57	9,2	■
JME144020J3R005Z4.0-HXT	03205235	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,05	4	4,29	3,09	6,9	10,57	10,93	11,31	12,15	■
JME144020J3R010Z4.0-HXT	03205237	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,1	4	4,31	3,09	6,84	10,57	10,92	11,3	12,14	■
JME144030J3R005Z4.0-HXT	03205242	3	J	3,0	4,0	2,25	50,0	15,0	2,85	0,05	4	1,74	6,76	15,06	15,82	16,35	–	–	■
JME144030J3R010Z4.0-HXT	03205244	3	J	3,0	4,0	2,25	50,0	15,0	2,85	0,1	4	1,75	6,76	15,04	15,82	16,35	–	–	■
JME144010J4R005Z4.0-HXT	03205216	4	J	1,0	4,0	0,75	40,0	8,5	0,95	0,05	4	6,28	2,04	4,52	8,98	9,3	9,63	10,34	■
JME144010J4R010Z4.0-HXT	03205219	4	J	1,0	4,0	0,75	40,0	8,5	0,95	0,1	4	6,31	2,04	4,47	8,98	9,3	9,62	10,33	■
JME144012J4R005Z4.0-HXT	03205223	4	J	1,2	4,0	0,9	50,0	10,0	1,15	0,05	4	5,44	2,18	4,85	10,51	10,87	11,25	12,09	■
JME144012J4R010Z4.0-HXT	03205226	4	J	1,2	4,0	0,9	50,0	10,0	1,15	0,1	4	5,46	2,18	4,79	10,5	10,87	11,24	12,07	■
JME144015J4R010Z4.0-HXT	03205231	4	J	1,5	4,0	1,125	60,0	12,0	1,45	0,1	4	4,46	2,4	5,28	12,53	12,96	13,41	14,4	■
JME144015J4R020Z4.0-HXT	03205233	4	J	1,5	4,0	1,125	60,0	12,0	1,45	0,2	4	4,49	2,4	5,17	12,53	12,95	13,4	14,38	■
JME144020J4R010Z4.0-HXT	03205238	4	J	2,0	4,0	1,5	60,0	16,0	1,94	0,1	4	3,02	3,09	6,84	16,61	17,16	17,76	19,08	■
JME144020J4R020Z4.0-HXT	03205240	4	J	2,0	4,0	1,5	60,0	16,0	1,94	0,2	4	3,04	3,1	6,72	16,6	17,16	17,74	19,05	■
JME144030J4R010Z4.0-HXT	03205245	4	J	3,0	4,0	2,25	60,0	24,0	2,85	0,1	4	1,16	6,76	15,09	24,88	–	–	–	■
JME144030J4R020Z4.0-HXT	03205248	4	J	3,0	4,0	2,25	60,0	24,0	2,85	0,2	4	1,16	6,76	14,97	24,87	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to a_p (l_{ap}, ref)*

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

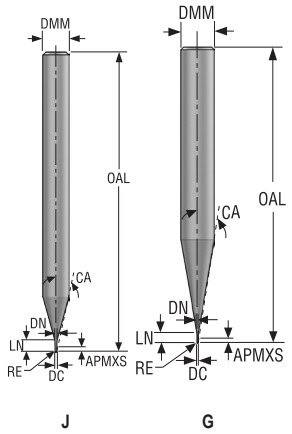
SMG		a_p/DC	f_z					v_c
			1.0	1.2	1.5	2.0	3,0	
H3	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H5	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96–130) *375 (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 447 - 454

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



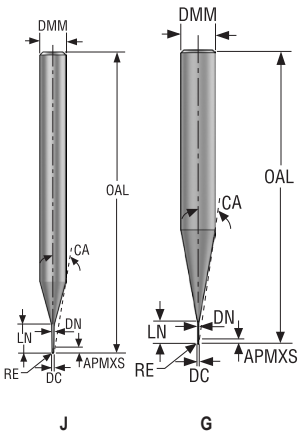
- Tolerances:
- Run-out= <0,005 mm
- DMM= h5
- DC <0,6 = 0-0,008 mm DC>0,6 = 0-0,01 mm
- RE= ±0,004 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	15,11	0,49	0,5	0,52	0,54	0,55	0,59	■
JMB112003G1BZ2.0-HXT	03204966	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,15	2		0,69	0,71	0,73	0,75	0,77	0,82	■
JMB112004G1BZ2.0-HXT	03204968	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,2	2		0,95	0,97	1,0	1,02	1,05	1,12	■
JMB112005G1BZ2.0-HXT	03204970	1	G	0,5	4,0	0,5	40,0	1,0	0,46	0,25	2		1,15	1,18	1,21	1,24	1,27	1,35	■
JMB112006G1BZ2.0-HXT	03204977	1	G	0,6	4,0	0,6	40,0	1,2	0,56	0,3	2		1,34	1,37	1,41	1,45	1,49	1,58	■
JMB112008G1BZ2.0-HXT	03204984	1	G	0,8	6,0	0,8	50,0	1,6	0,76	0,4	2		1,74	1,78	1,83	1,88	1,93	2,04	■
JMB112010G1BZ2.0-HXT	03204991	1	G	1,0	6,0	1,0	50,0	2,0	0,95	0,5	2		2,14	2,19	2,25	2,31	2,37	2,51	■
JMB112012G1BZ2.0-HXT	03205000	1	G	1,2	6,0	1,2	50,0	2,4	1,15	0,6	2		2,54	2,6	2,67	2,74	2,81	2,98	■
JMB112015G1BZ2.0-HXT	03205009	1	G	1,5	6,0	1,5	50,0	3,0	1,45	0,75	2	12,2	3,23	3,31	3,39	3,48	3,57	3,79	■
JMB112002J2BZ2.0-HXT	03204965	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,1	2		0,51	0,72	0,8	0,87	0,94	1,06	■
JMB112003J2BZ2.0-HXT	03204967	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,15	2		0,61	0,99	1,11	1,2	12,7	1,42	■
JMB112004J2BZ2.0-HXT	03204969	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,2	2	13,3	1,02	1,35	1,47	1,57	1,65	1,79	■
JMB112005J2BZ2.0-HXT	03204971	2	J	0,5	4,0	0,5	40,0	1,5	0,46	0,25	2		1,53	1,72	1,84	1,93	2,02	2,17	■
JMB112005G2BZ2.0-HXT	03204972	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	2	9,91	1,78	1,89	1,98	2,07	2,17	2,41	■
JMB112006J2BZ2.0-HXT	03204978	2	J	0,6	4,0	0,6	50,0	2,0	0,56	0,3	2		1,57	2,19	2,35	2,46	2,56	2,74	■
JMB112006G2BZ2.0-HXT	03204979	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	2	9,62	2,27	2,41	2,52	2,63	2,76	3,07	■
JMB112008J2BZ2.0-HXT	03204985	2	J	0,8	4,0	0,8	50,0	2,5	0,76	0,4	2	11,34	1,77	2,67	2,86	2,99	3,1	3,31	■
JMB112008G2BZ2.0-HXT	03204986	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	2	9,33	2,77	2,93	3,06	3,2	3,35	3,72	■
JMB112010J2BZ2.0-HXT	03204992	2	J	1,0	4,0	1,0	40,0	4,0	0,95	0,5	2	9,49	2,29	4,13	4,42	4,59	4,74	5,06	■
JMB112010G2BZ2.0-HXT	03204993	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	2	8,49	4,32	4,52	4,72	4,94	5,19	5,77	■
JMB112012J2BZ2.0-HXT	03205001	2	J	1,2	4,0	1,2	50,0	4,5	1,15	0,6	2	8,83	2,49	4,6	4,93	5,12	5,28	5,63	■
JMB112012G2BZ2.0-HXT	03205002	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	2	8,21	4,82	5,04	5,26	5,51	5,78	6,42	■
JMB112015J2BZ2.0-HXT	03205010	2	J	1,5	4,0	1,5	50,0	5,0	1,45	0,75	2	8,1	2,78	5,09	5,45	5,64	5,81	6,19	■
JMB112015G2BZ2.0-HXT	03205011	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	2		5,32	5,55	5,72	5,89	6,07	6,47	■
JMB112018G2BZ2.0-HXT	03205018	2	G	1,8	6,0	1,8	50,0	5,0	1,75	0,9	2	9,99	5,32	5,55	5,71	5,88	6,05	6,44	■
JMB112018J2BZ2.0-HXT	03205019	2	J	1,8	4,0	1,8	50,0	5,0	1,75	0,9	2	7,71	3,08	5,15	5,46	5,64	5,81	6,17	■
JMB112020J2BZ2.0-HXT	03205024	2	J	2,0	4,0	2,0	50,0	6,0	1,94	1,0	2	6,6	3,6	6,16	6,5	6,7	6,9	7,34	■
JMB112020G2BZ2.0-HXT	03205025	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	2	9,1	6,35	6,6	6,79	6,99	7,2	7,66	■
JMB112025J2BZ2.0-HXT	03205032	2	J	2,5	4,0	2,5	50,0	7,5	2,4	1,25	2	4,75	5,4	7,81	8,12	8,35	8,59	9,14	■
JMB112025G2BZ2.0-HXT	03205033	2	G	2,5	6,0	2,5	50,0	7,5	2,4	1,25	2	7,71	7,97	8,22	8,45	8,69	8,95	9,53	■
JMB112030J2BZ2.0-HXT	03205037	2	J	3,0	4,0	3,0	50,0	9,0	2,85	1,5	2	3,04	7,53	9,44	9,73	10,01	10,31	10,96	■
JMB112030G2BZ2.0-HXT	03205038	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	2	6,35	9,59	9,85	10,12	10,41	10,72	11,42	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

JMB112

Miniature – Hardened steel – Ball nose – 2 Flutes – Cylindrical



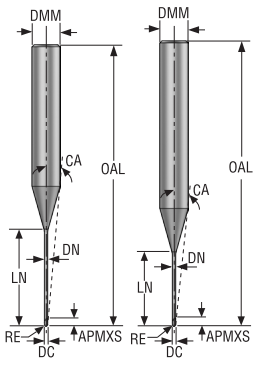
- Tolerances:
- Run-out= <0,005 mm
- DMM=h5
- DC <0,6 = 0-0,008 mm DC>0,6 = 0-0,01 mm
- RE= ±0,004 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	11,49	1,54	2,63	2,85	2,99	3,11	3,32	■
JMB112005G3BZ2.0-HXT	03204974	3	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	2	8,81	3,78	3,99	4,18	4,38	4,61	5,15	■
JMB112006J3BZ2.0-HXT	03204980	3	J	0,6	4,0	0,6	40,0	3,0	0,56	0,3	2		1,57	3,07	3,36	3,52	3,65	3,9	■
JMB112006G3BZ2.0-HXT	03204981	3	G	0,6	6,0	0,6	50,0	4,0	0,56	0,3	2	8,56	4,27	4,51	4,72	4,94	5,2	5,81	■
JMB112008J3BZ2.0-HXT	03204987	3	J	0,8	4,0	0,8	40,0	4,0	0,76	0,4	2	9,67	1,77	3,52	4,38	4,57	4,72	5,05	■
JMB112008G3BZ2.0-HXT	03204988	3	G	0,8	6,0	0,8	50,0	5,5	0,76	0,4	2	10,1	5,77	6,06	6,26	6,46	6,67	7,14	■
JMB112010J3BZ2.0-HXT	03204994	3	J	1,0	4,0	1,0	40,0	5,0	0,95	0,5	2	8,6	2,29	4,57	5,43	5,64	5,82	6,22	■
JMB112010G3BZ2.0-HXT	03204995	3	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	2	9,06	7,32	7,64	7,87	8,12	8,38	8,97	■
JMB112012J3BZ2.0-HXT	03205003	3	J	1,2	4,0	1,2	50,0	6,0	1,15	0,6	2	7,65	2,49	4,9	6,45	6,68	6,89	7,36	■
JMB112012G3BZ2.0-HXT	03205004	3	G	1,2	6,0	1,2	50,0	8,0	1,15	0,6	2	8,42	8,32	8,67	8,93	9,21	9,51	10,17	■
JMB112015J3BZ2.0-HXT	03205012	3	J	1,5	4,0	1,5	40,0	7,5	1,45	0,75	2	6,4	2,78	5,33	7,97	8,24	8,5	9,08	■
JMB112015G3BZ2.0-HXT	03205013	3	G	1,5	6,0	1,5	50,0	10,0	1,45	0,75	2	7,31	10,32	10,72	11,05	11,39	11,76	12,59	■
JMB112018J3BZ2.0-HXT	03205020	3	J	1,8	4,0	1,8	50,0	9,0	1,75	0,9	2	5,28	3,08	5,81	9,49	9,8	10,11	10,8	■
JMB112018G3BZ2.0-HXT	03205021	3	G	1,8	6,0	1,8	50,0	12,0	1,75	0,9	2	6,35	12,32	12,78	13,17	13,58	14,02	15,0	■
JMB112020J3BZ2.0-HXT	03205026	3	J	2,0	4,0	2,0	50,0	10,0	1,94	1,0	2	4,61	3,6	6,86	10,53	10,86	11,21	11,97	■
JMB112020G3BZ2.0-HXT	03205027	3	G	2,0	6,0	2,0	50,0	12,0	1,94	1,0	2	6,19	12,35	12,8	13,18	13,59	14,03	15,0	■
JMB112025J3BZ2.0-HXT	03205034	3	J	2,5	4,0	2,5	50,0	12,5	2,4	1,25	2	3,13	5,4	10,6	13,15	13,55	13,97	14,92	■
JMB112025G3BZ2.0-HXT	03205035	3	G	2,5	6,0	2,5	50,0	15,0	2,4	1,25	2	4,91	15,47	15,96	16,43	16,94	17,49	18,71	■
JMB112030J3BZ2.0-HXT	03205039	3	J	3,0	4,0	3,0	50,0	15,0	2,85	1,5	2	1,91	7,53	15,03	15,77	16,25	–	–	■
JMB112030G3BZ2.0-HXT	03205040	3	G	3,0	6,0	3,0	60,0	15,0	2,85	1,5	2	4,41	15,59	16,04	16,51	17,01	17,55	18,76	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

JMB112

Miniature – Hardened steel – Ball nose – 2 Flutes – Cylindrical



- Tolerances:
- Run-out= <0,005 mm
- DMM=h5
- DC <0,6 = 0-0,008 mm DC>0,6 = 0-0,01 mm
- RE= ±0,004 mm

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	Cylindrical
				mm	mm	mm	mm	mm	mm	mm									
JMB112005J4BZ2.0-HXT	03204975	4	J	0,5	4,0	0,5	40,0	4,0	0,46	0,25	2	9,9	1,54	3,15	4,37	4,57	4,72	5,06	■
JMB112005G4BZ2.0-HXT	03204976	4	G	0,5	6,0	0,5	50,0	5,0	0,46	0,25	2		5,28	5,55	5,74	5,93	6,12	6,56	■
JMB112006J4BZ2.0-HXT	03204982	4	J	0,6	4,0	0,6	40,0	5,0	0,56	0,3	2	8,97	1,57	3,19	5,38	5,61	5,8	6,21	■
JMB112006G4BZ2.0-HXT	03204983	4	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	2	9,86	6,27	6,59	6,8	7,02	7,25	7,77	■
JMB112008J4BZ2.0-HXT	03204989	4	J	0,8	4,0	0,8	40,0	7,0	0,76	0,4	2	7,46	1,77	3,52	7,41	7,7	7,95	8,52	■
JMB112008G4BZ2.0-HXT	03204990	4	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	2	8,65	8,27	8,65	8,92	9,21	9,52	10,2	■
JMB112010J4BZ2.0-HXT	03204996	4	J	1,0	4,0	1,0	40,0	8,5	0,95	0,5	2	6,48	2,29	4,57	8,96	9,28	9,58	10,26	■
JMB112010G4BZ2.0-HXT	03204998	4	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	2	7,63	10,32	10,73	11,06	11,42	11,8	12,64	■
JMB112012J4BZ2.0-HXT	03205005	4	J	1,2	4,0	1,2	50,0	10,0	1,15	0,6	2	5,63	2,49	4,9	10,48	10,84	11,2	11,99	■
JMB112012G4BZ2.0-HXT	03205006	4	G	1,2	6,0	1,2	50,0	12,0	1,15	0,6	2	8,77	12,32	12,79	13,19	13,61	14,06	15,07	■
JMB112015J4BZ2.0-HXT	03205014	4	J	1,5	4,0	1,5	60,0	12,0	1,45	0,75	2	4,65	2,78	5,33	12,51	12,92	13,34	14,28	■
JMB112015G4BZ2.0-HXT	03205015	4	G	1,5	6,0	1,5	70,0	15,0	1,45	0,75	2	5,7	15,32	15,88	16,37	16,9	17,46	18,71	■
JMB112018J4BZ2.0-HXT	03205022	4	J	1,8	4,0	1,8	60,0	15,0	1,75	0,9	2	3,57	3,08	5,81	15,54	16,04	16,57	17,74	■
JMB112018G4BZ2.0-HXT	03205023	4	G	1,8	6,0	1,8	60,0	18,0	1,75	0,9	2	4,83	18,32	18,97	19,56	20,18	20,85	22,35	■
JMB112020J4BZ2.0-HXT	03205028	4	J	2,0	4,0	2,0	60,0	16,0	1,94	1,0	2	3,17	3,6	6,86	16,58	17,11	17,66	18,91	■
JMB112020G4BZ2.0-HXT	03205029	4	G	2,0	6,0	2,0	60,0	18,0	1,94	1,0	2	4,68	18,35	18,99	19,57	20,19	20,86	22,35	■
JMB112025G4BZ2.0-HXT	03205036	4	G	2,5	6,0	2,5	65,0	25,0	2,4	1,25	2	3,3	25,47	26,27	27,08	27,95	28,88	30,94	■
JMB112030J4BZ2.0-HXT	03205041	4	J	3,0	4,0	3,0	60,0	24,0	2,85	1,5	2	1,22	7,53	15,07	24,83	–	–	–	■
JMB112030G4BZ2.0-HXT	03205042	4	G	3,0	6,0	3,0	80,0	30,0	2,85	1,5	2	2,51	30,59	31,51	32,48	33,52	34,63	–	■
JMB112010G5BZ2.0-HXT	03204999	5	G	1,0	6,0	1,0	60,0	15,0	0,95	0,5	2	6,04	15,32	15,89	16,39	16,92	17,49	18,76	■
JMB112012G5BZ2.0-HXT	03205007	5	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	2	5,24	18,32	18,98	19,58	20,21	20,89	22,41	■
JMB112015G5BZ2.0-HXT	03205016	5	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	2	4,29	22,82	23,62	24,36	25,15	26,0	27,88	■
JMB112020G5BZ2.0-HXT	03205030	5	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	2	3,15	30,35	31,36	32,35	33,4	34,52	37,03	■
JMB112030G5BZ2.0-HXT	03205043	5	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	2	1,75	45,59	46,98	48,45	50,03	–	–	■
JMB112010G6BZ2.0-HXT	03205054	6	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	2	4,99	20,32	21,05	21,71	22,42	23,19	24,92	■
JMB112012G6BZ2.0-HXT	03205008	6	G	1,2	6,0	1,2	70,0	24,0	1,15	0,6	2	4,27	24,32	25,17	25,97	26,82	27,73	29,75	■
JMB112015G6BZ2.0-HXT	03205017	6	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	2	3,44	30,32	31,35	32,35	33,4	34,49	37,06	■
JMB112020G6BZ2.0-HXT	03205031	6	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2	2,47	40,35	41,68	43,0	44,4	45,91	–	■
JMB112030G6BZ2.0-HXT	03205045	6	G	3,0	6,0	3,0	90,0	60,0	2,85	1,5	2	1,34	60,59	62,45	64,43	–	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

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 *0,0500*	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*	0.048 *0,0019*	150 (130–170) *490 (430 — 550)*
H5	M	0.0500 *0,0500*	0.44 *0,44*	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*	220 (200 — 240) *720 (660–780)*
H7	M	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*	0.048 *0,0019*	150 (130–170) *490 (430 — 550)*
H8	M	0.0500 *0,0500*	0.44 *0,44*	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*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660–780)*
H11	M	0.0500 *0,0500*	0.44 *0,44*	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*	280 (250 — 310) *920 (830–1000)*
H12	M	0.0500 *0,0500*	0.44 *0,44*	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*	0.048 *0,0019*	0.050 *0,0020*	255 (230 — 280) *840 (760 — 910)*
H21	M	0.0500 *0,0500*	0.44 *0,44*	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*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660–780)*
H31	M	0.0500 *0,0500*	0.44 *0,44*	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*	0.036 *0,0014*	0.042 *0,0017*	0.044 *0,0017*	165 (150–180) *540 (500 — 590)*

For cutting data recalculations, see pages 447 - 454

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)		382	384	386	388	394
Family name		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Type of mill						
Shank	Cylindrical	■	■	■	■	■
	Weldon					
Number of Flutes		3	4	5,6,8,9	2	2
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)		400	404	408	412	414	416	418
Family name		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Type of mill								
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 -1/2	1/4-1/2	1/4-1/2				3/8
Length availability								
		2	2	2	2	2	3	3,4
Operation								
								
SMG								
TS1								
TS2		●	●	●	●	●		
TS3		●	●	●	●	●		
TP1								
TP2		●	●	●	●	●		
TP3		●	●	●	●	●		
Honeycomb*								

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

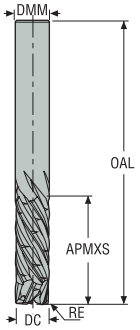
Tool selection Plastic and cfrp

						
Name		JPD850	JPD880	JPD890	J93F	J28
Page(s)		421	423	425	427	429
Family name		PCD	PCD	PCD	VHM	VHM
Type of mill						
Shank	Cylindrical	■	■	■	■	■
	Weldon					
Number of Flutes		2	3	2	2	1
ICC		■	■	■		
Diameter range	Metric	4-10	6-16	6-12	1,5-20	2-12
	Inch					
Length availability						
		2	2,3	2,3	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

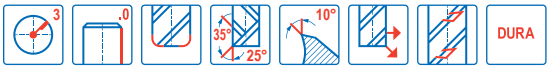
JC845

Composite – Compression – 3 Flutes – Cylindrical – Corner radius



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		
JC845060D2R050.0Z3-DURA	02843006	2	D	6,0	6,0	18,0	65,0	0,5	3	■
JC845080D2R050.0Z3-DURA	02843007	2	D	8,0	8,0	24,0	75,0	0,5	3	■

■ Stocked standard.

Cutting data – JC845 Side milling roughing

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
TS2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	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*	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*	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*	85 (62–110) *280 (210 — 360)*

Cutting data – JC845 Slot milling

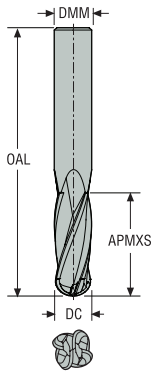
SMG		a_p/DC	f_z		v_c
			6	8	
TS2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	160 (110 — 210) *520 (370 — 680)*
TS3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	105 (76–130) *345 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	105 (75–160) *345 (250 — 520)*
TP3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	75 (54 — 96) *245 (180 — 310)*

For cutting data recalculations, see pages 447 - 454

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

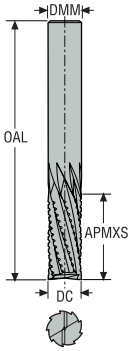
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	265 (220 — 320) *870 (730–1000)*
TS3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	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 447 - 454

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

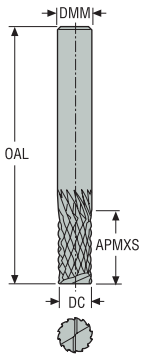
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	160 (140–180) *520 (460 — 590)*
TS3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (85–120) *345 (280 — 390)*
TP2	E/A/D	0.50 *0,50*	0.012 *0,00048*	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 447 - 454

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

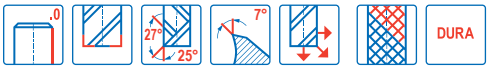
JC870

Composite – Router – Square – Cylindrical – Sharp



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,08 mm
- Router (downcut)*

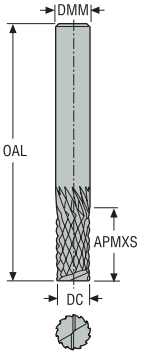


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	Cylindrical
				mm	mm	mm	mm		
870030.0-DURA	02720219	2	D	3,0	3,0	9,0	50,0	2	■
870040.0-DURA	02720226	2	D	4,0	4,0	12,0	50,0	2	■
870060.0-DURA	02720228	2	D	6,0	6,0	18,0	65,0	2	■
870080.0-DURA	02720229	2	D	8,0	8,0	24,0	75,0	2	■
870100.0-DURA	02720231	2	D	10,0	10,0	30,0	85,0	2	■
870120.0-DURA	02720232	2	D	12,0	12,0	36,0	100,0	2	■

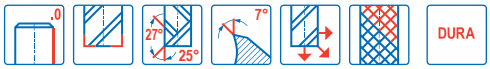
■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC870

Composite – Router – Square – Cylindrical – Sharp – *Inch*



D



- Tolerances:
- DMM= h5
- DC= -0,02/-0,08 mm
- Router (downcut)*

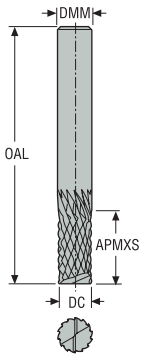
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	Cylindrical
				Inch	Inch	Inch	Inch		
8700250.0-DURA	02720784	2	D	0.250	0.250	0.750	2.250	2	■
8700375.0-DURA	02720785	2	D	0.375	0.375	1.250	3.500	2	■

■ 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.

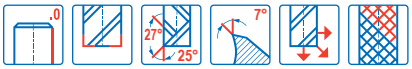
JC870

Composite – Router – Square – Cylindrical – Sharp



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,08 mm
- Router (downcut)*

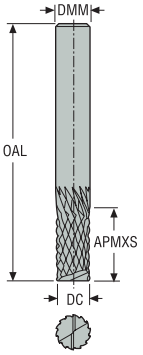


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	Cylindrical
				mm	mm	mm	mm		
870030.0	02742789	2	D	3,0	3,0	9,0	50,0	2	■
870040.0	02742792	2	D	4,0	4,0	12,0	50,0	2	■
870050.0	02742793	2	D	5,0	5,0	15,0	50,0	2	■
870060.0	02742794	2	D	6,0	6,0	18,0	65,0	2	■
870080.0	02742795	2	D	8,0	8,0	24,0	75,0	2	■
870100.0	02742796	2	D	10,0	10,0	30,0	85,0	2	■
870120.0	02742797	2	D	12,0	12,0	36,0	100,0	2	■

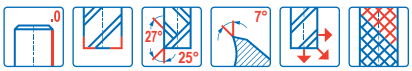
■ Stocked standard.
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC870

Composite – Router – Square – Cylindrical – Sharp – *Inch*



D



- Tolerances:
- DMM= h5
- DC=- .0008 / -.0015 *inch*
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	FCEDC	Cylindrical
				Inch	Inch	Inch	Inch		
8700250.0	02742798	2	D	0.250	0.250	0.750	2.250	2	■
8700500.0	02742800	2	D	0.500	0.500	1.500	4.250	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.

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 447 - 454

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*

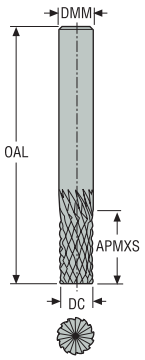
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130–170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79–110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	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 447 - 454

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

JC871

Composite – Router – Square – Cylindrical – Sharp



D

- Tolerances:
- DMM= h5
- DC= -0,02/-0,08 mm
- Router (downcut)*

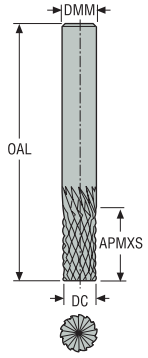
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	Cylindrical
				mm	mm	mm	mm	
871030.0-DURA	02720249	2	D	3,0	3,0	9,0	50,0	■
871040.0-DURA	02720250	2	D	4,0	4,0	12,0	50,0	■
871060.0-DURA	02720252	2	D	6,0	6,0	18,0	65,0	■
871080.0-DURA	02720253	2	D	8,0	8,0	24,0	75,0	■
871100.0-DURA	02720254	2	D	10,0	10,0	30,0	85,0	■
871120.0-DURA	02720257	2	D	12,0	12,0	36,0	100,0	■

■ Stocked standard.

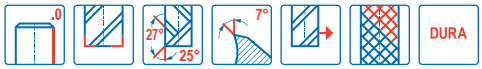
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC871

Composite – Router – Square – Cylindrical – Sharp – *Inch*



D



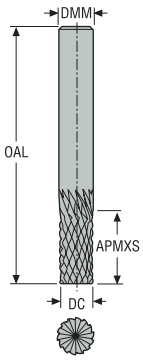
- Tolerances:
- DMM= h5
- DC= -.0008 / -.0015 *inch*
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	Cylindrical
				Inch	Inch	Inch	Inch	
8710250.0-DURA	02720788	2	D	0.250	0.250	0.750	2.250	■
8710375.0-DURA	02720789	2	D	0.375	0.375	1.250	3.500	■
8710500.0-DURA	02720790	2	D	0.500	0.500	1.500	4.250	■

■ 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.

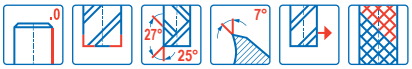
JC871

Composite – Router – Square – Cylindrical – Sharp



D

- Tolerances:
- DMM= h5
- DC= -0,02/-0,04 mm
- Router (downcut)*



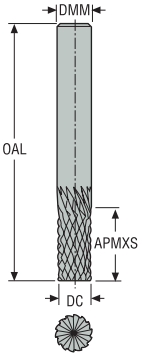
Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	Cylindrical
				mm	mm	mm	mm	
871030.0	02742801	2	D	3,0	3,0	9,0	50,0	■
871040.0	02742803	2	D	4,0	4,0	12,0	50,0	■
871060.0	02742806	2	D	6,0	6,0	18,0	65,0	■
871080.0	02742807	2	D	8,0	8,0	24,0	75,0	■
871100.0	02742808	2	D	10,0	10,0	30,0	85,0	■
871120.0	02742809	2	D	12,0	12,0	36,0	100,0	■

■ Stocked standard.

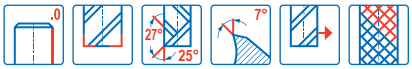
*Downcut indicates flute geometries that are combined to create small down forces that assist with maintaining component clamping, particularly where vacuum clamping is employed.

JC871

Composite – Router – Square – Cylindrical – Sharp – *Inch*



D



- Tolerances:
- DMM=h5
- DC=-0,02/-0,08 mm
- Router (downcut)*

Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	Cylindrical
				Inch	Inch	Inch	Inch	
8710500.0	02742814	2	D	0.500	0.500	1.500	4.250	■

■ 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 447 - 454

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*

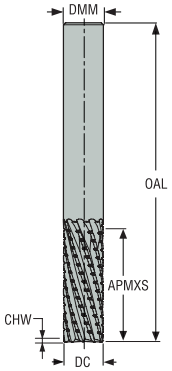
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130–170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79–110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	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 447 - 454

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

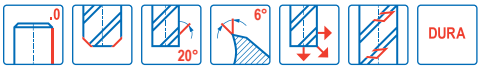
JC875

Composite – Square – 5-10 Flutes – Cylindrical – Chamfer



D

- Tolerances:
- DMM=h5
- DC=-0,02/-0,08 mm

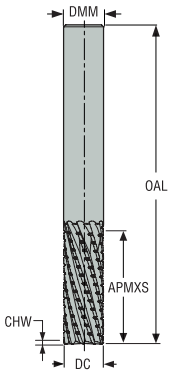


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JC875030D2.0-DURA	02968155	2	D	3,0	3,0	9,0	50,0	0,05	5	■
JC875050D2.0-DURA	02968157	2	D	5,0	5,0	15,0	50,0	0,05	6	■
JC875060D2.0-DURA	02968158	2	D	6,0	6,0	18,0	65,0	0,06	6	■
JC875080D2.0-DURA	02968159	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	■

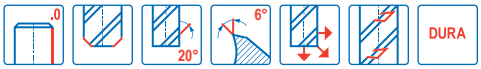
■ Stocked standard.

JC875

Composite – Square – 6-10 Flutes – Cylindrical – Chamfer – *Inch*



D



- Tolerances:
- DMM=h5
- DC=-0,02/-0,08 mm

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	PICT_Coolant	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	PICT_Coolant	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 447 - 454

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	PICT_Coolant	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*

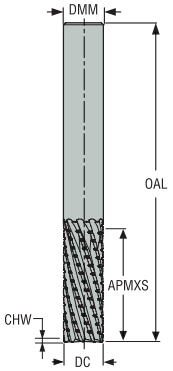
SMG	PICT_Coolant	a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140–180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (86–120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *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 447 - 454

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

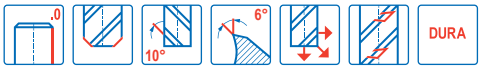
JC876

Composite – Square – 6-14 Flutes – Cylindrical – Chamfer



D

- Tolerances:
- DMM=h5
- DC=-0,02 -0,08 mm
- Left hand helix

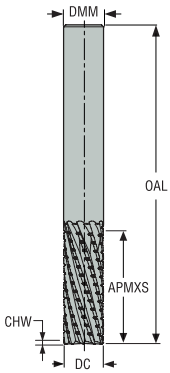


Designation	Item number	Length index	Tool shape	DC	DMM	APMXS	OAL	CHW	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
JC876030D2C.0Z6-DURA	03135004	2	D	3,0	3,0	7,5	50,0	0,035	6	■
JC876040D2C.0Z6-DURA	03135005	2	D	4,0	4,0	10,0	54,0	0,045	6	■
JC876060D2C.0Z8-DURA	03135006	2	D	6,0	6,0	15,0	62,0	0,075	8	■
JC876060D2C.0Z10-DURA	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	■

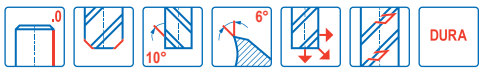
■ Stocked standard.

JC876

Composite – Square – 8-14 Flutes – Cylindrical – Chamfer – *Inch*



D



- 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
				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	PICT_Coolant	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	PICT_Coolant	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 447 - 454

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	PICT_Coolant	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*

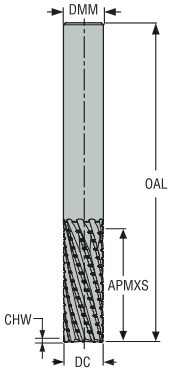
SMG	PICT_Coolant	a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (94–140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	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 447 - 454

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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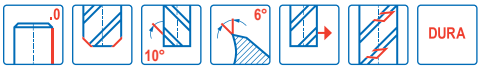


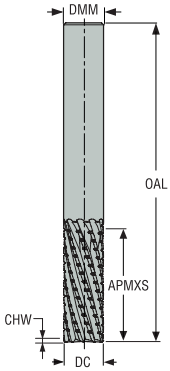
- Tolerances:
- DMM=h5
- DC=-0,02, -0,08 mm
- Left hand helix

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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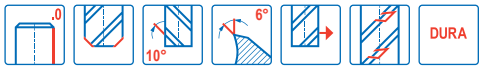


- Tolerances:
- DMM=h5
- DC=-0,02, -0,08 mm
- Left hand helix

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	PICT_Coolant	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	PICT_Coolant	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 447 - 454

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	PICT_Coolant	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*

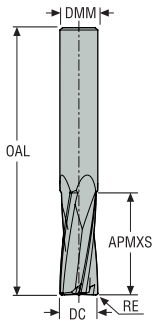
SMG	PICT_Coolant	a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140–180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (85–120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *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 447 - 454

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

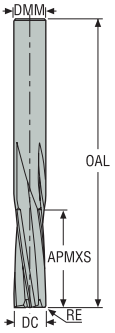
SMG		a_p/DC	f_z								v_c
			4	5	6	8	10	12	16	20	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130–170) *490 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	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 447 - 454

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

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

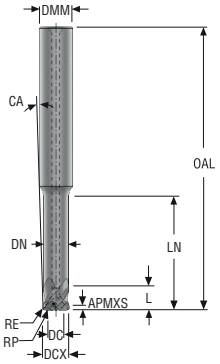
SMG		a_p/DC	f_z				v_c
			4	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	150 (130–170) *490 (430 — 550)*
TS3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	100 (76–130) *330 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *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 447 - 454

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

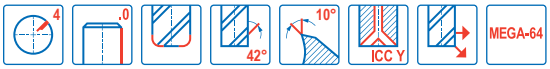
JC898

High feed – Stacked materials – Corner radius – 4 Flutes – Cylindrical – Corner radius



G

- Tolerances:
- DMM=h5
- DC= e7
- RE= ±0,1 mm
- CA= collision angle



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

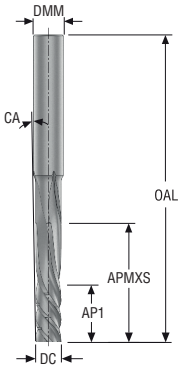
SMG		a_p/DCX	f_z		v_c	
				8	15	
S12+TP2/ TS2	D	0.020 *0.020*	0.08 *0,0032*	0.10 *0,0040*	90 (80-120) *300 (270-400)*	
N1+TP2/ TS2	D	0.034 *0.034*	0.1 *0,0040*	0.10 *0,0040*	120 (90-150) *400 (300-490)*	

For cutting data recalculations, see pages 447 - 454

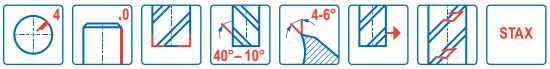
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

JC899

High performance – Stacked materials – Square – 4 Flutes – Cylindrical – Sharp



F



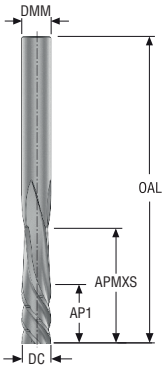
- Tolerances:
- DMM=h5
- DC= ±0,02 mm
- CA= collision angle

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	■

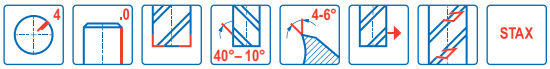
■ Stocked standard.

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*

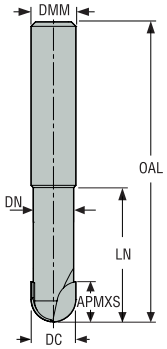
SMG		a_e/DC	a_p/DC	f_z	v_c
				3/8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,05 *0,0022*	40 (30 — 50) *140 (100–170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,07 *0,0028*	60 (50–75) *200 (170 — 250)*

For cutting data recalculations, see pages 447 - 454

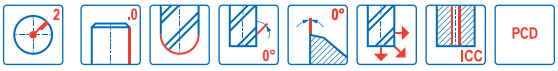
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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		
JPD850040G2B.0Z2A	02968182	2	G	■	4,0	6,0	6,0	58,0	12,0	3,8	2	■
JPD850050G2B.0Z2A	02968183	2	G	■	5,0	6,0	6,0	58,0	15,0	4,8	2	■
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.
ICC = Internal Coolant Channel

Cutting data – JPD850 Copy milling

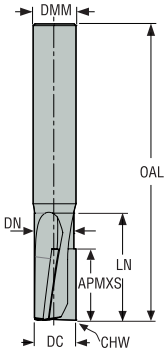
SMG	PICT_Coolant	a_e/DC	a_p/DC	f_z					v_c
				4	5	6	8	10	
TS2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	550 (470 — 820) *1800 (1600 — 2600)*
TS3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	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 447 - 454

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



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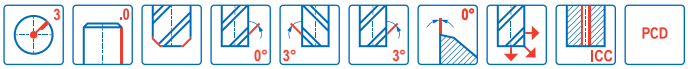


- Tolerances:
- DMM=h5
- DC=h10
- ICC=Y

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.
ICC = Internal Coolant Channel

Cutting data – JPD880 Side milling

SMG	PICT_Coolant	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

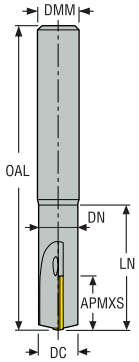
SMG	PICT_Coolant	a_p/DC	f_z					v_c
			6	8	10	12	16	
TS2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	385 (330 — 570) *1275 (1100–1800)*
TS3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	210 (180 — 310) *690 (600–1000)*
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 447 - 454

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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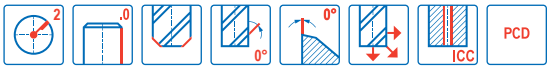


- Tolerances:
- DMM=h5
- DC=h10
- ICC=2 straight channels

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.
ICC = Internal Coolant Channel

Cutting data – JPD890 Side milling

SMG	PICT_Coolant	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

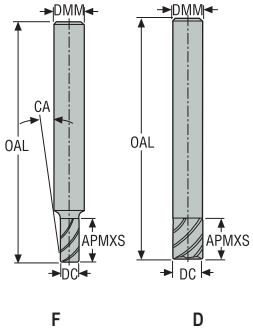
SMG	PICT_Coolant	a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	375 (320 — 550) *1225 (1100–1800)*
TS3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	225 (190 — 330) *740 (630–1000)*
TP2	E/A/D	1.0 *1,0*	0.060 *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)*

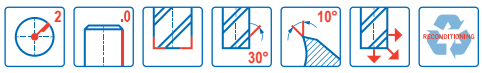
For cutting data recalculations, see pages 447 - 454

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

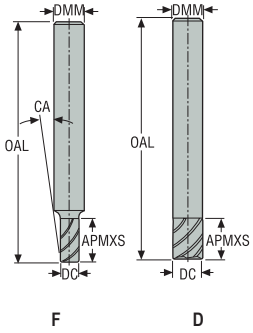
SMG		a_p/DC	f_z										v_c
			1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	500 (400 — 590) *1650 (1400–1900)*
TP1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *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 447 - 454

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



- 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	CA	PCEDC	Cylindrical
				mm	mm	mm	mm	mm		
28020	00029348	2	F	2,0	3,0	4,0	40,0	3,0	1	■
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
				2	3	4	5	6	8	10	12	
TS1	A/D	0.300 *0,300*	1.5 *1,5*	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*	490 (370 — 610) *1600 (1300 — 2000)*

Cutting data – J28 Slot milling

SMG		a_p/DC	f_z								v_c
			2	3	4	5	6	8	10	12	
TS1	A/D	1.0 *1,0*	0.018 *0,00070*	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 447 - 454

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

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 and JMB642 for ball-nose type.

Tool selection Graphite

					
Name		JD620	JD630	JD640	JD660
Page(s)		434	436	438	440
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
Operation					
					
					
SMG					
GR		●	●	●	●

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

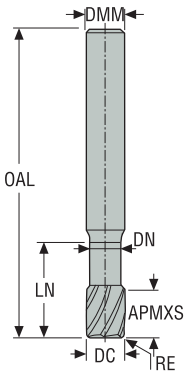
Tool selection Graphite

			 
Name		JME642	JMB642
Page(s)		442	444
Family name		MINI DIAMOND	MINI DIAMOND
Type of mill			
Shank	Cylindrical	■	■
	Weldon		
Number of Flutes		2	2
ICC			
Diameter range	Metric	0,2-2,0	0,2-3,0
	Inch		
Length availability			
		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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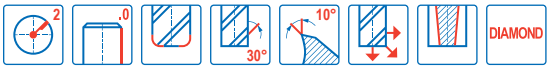


- Tolerances:
- Run-out= <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm

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

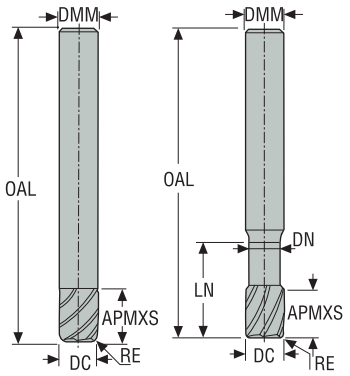
SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520–710) *2000 (1800 — 2300)*

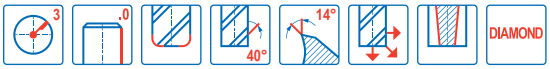
For cutting data recalculations, see pages 447 - 454

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	■
630VL030R020-DIAMOND	00023467	3	E	3,0	3,0	5,0	60,0	25,0	2,9	0,2	3	■
630V040R030-DIAMOND	00023465	3	E	4,0	4,0	5,0	50,0	20,0	3,9	0,3	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

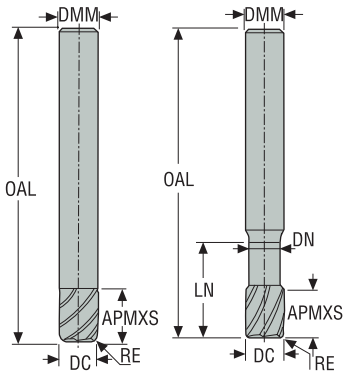
SMG		a_p/DC	f_z					v_c
			3	4	5	6	8	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	620 (520–720) *2025 (1800 — 2300)*

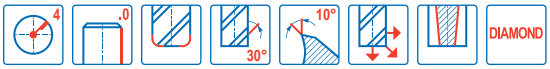
For cutting data recalculations, see pages 447 - 454

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	■
640VL080R100-DIAMOND	00023485	3	E	8,0	8,0	10,0	100,0	60,0	7,8	1,0	4	■
640V100R050-DIAMOND	00023481	3	E	10,0	10,0	12,0	80,0	40,0	9,8	0,5	4	■
640V100R100-DIAMOND	00039781	3	E	10,0	10,0	12,0	80,0	40,0	9,8	1,0	4	■
640V120R050-DIAMOND	00023483	3	E	12,0	12,0	15,0	80,0	40,0	11,8	0,5	4	■
640V120R100-DIAMOND	00023484	3	E	12,0	12,0	15,0	80,0	40,0	11,8	1,0	4	■
640VL100R050-DIAMOND	00023486	4	E	10,0	10,0	12,0	125,0	80,0	9,8	0,5	4	■
640VL100R100-DIAMOND	02462696	4	E	10,0	10,0	12,0	125,0	80,0	9,7	1,0	4	■
640VL120R050-DIAMOND	02462698	4	E	12,0	12,0	15,0	125,0	80,0	11,7	0,5	4	■
640VL120R100-DIAMOND	00023487	4	E	12,0	12,0	15,0	125,0	80,0	11,8	1,0	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

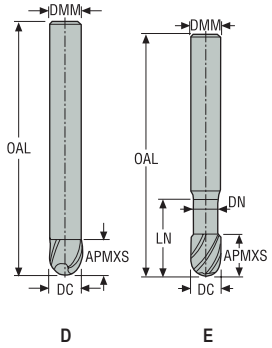
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
GR1	D	0.50 *0,50*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520–710) *2000 (1800 — 2300)*

For cutting data recalculations, see pages 447 - 454

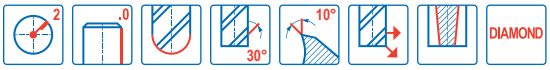
SMG = Seco material group
Coolant = A=air D=dry E=emulsion M=mist spray
v_c= m/min (*sf/min*)
f_z = mm (*in/tooth*)
a_p = mm/DC (*in/DC*) = factor
a_e = mm/DC (*in/DC*) = factor
All cutting data are target values

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

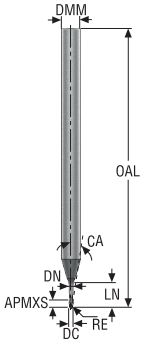
SMG		a_e/DC	a_p/DC	f_z			v_c
				3	4	6	
GR1	D	0.400 *0,400*	2.4 *2,4*	0.024 *0,00095*	0.032 *0,0013*	0.046 *0,0018*	920 (780–1000) *3025 (2600 — 3200)*

For cutting data recalculations, see pages 447 - 454

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

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	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	14,32	0,59	0,65	0,72	0,78	0,84	0,95	■
JME642003G1R002.0Z2-DIA	03215525	1	G	0,3	4,0	0,5	40,0	0,5	0,28	0,02	2	14,1	0,74	0,81	0,87	0,94	1,0	1,11	■
JME642004G1R004.0Z2-DIA	03215526	1	G	0,4	4,0	0,6	40,0	2,0	0,37	0,04	2	11,67	2,29	2,44	2,57	2,68	2,78	2,96	■
JME642005G3R005.0Z2-DIA	03215527	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,05	2	10,97	2,83	3,0	3,13	3,25	3,36	3,56	■
JME642006G3R006.0Z2-DIA	03215528	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,06	2	10,31	3,33	3,52	3,67	3,8	3,92	4,13	■
JME642008G3R008.0Z2-DIA	03215529	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,08	2	9,31	4,33	4,57	4,74	4,89	5,02	5,25	■
JME642010G3R010.0Z2-DIA	03215530	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,1	2	8,04	5,33	5,61	5,81	5,97	6,12	6,37	■
JME642012G3R012.0Z2-DIA	03215531	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,12	2	7,09	6,33	6,65	6,87	7,05	7,2	7,46	■
JME642015G3R015.0Z2-DIA	03215532	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,15	2	5,8	7,99	8,29	8,52	8,71	8,87	9,36	■
JME642020G3R015.0Z2-DIA	03236441	3	G	2,0	4,0	2,2	60,0	10,0	1,9	0,15	2	4,11	10,53	10,88	11,22	11,55	11,99	12,87	■
JME642020G3R020.0Z2-DIA	03215533	3	G	2,0	4,0	3,0	60,0	10,0	1,9	0,2	2	4,11	10,49	10,87	11,13	11,35	11,53	12,48	■
JME642005G5R005.0Z2-DIA	03215534	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,05	2	9,43	4,33	4,57	4,74	4,89	5,03	5,26	■
JME642006G5R006.0Z2-DIA	03215535	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,06	2	8,5	5,33	5,61	5,81	5,98	6,12	6,37	■
JME642008G5R008.0Z2-DIA	03215536	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,08	2	7,02	7,33	7,68	7,92	8,12	8,28	8,72	■
JME642010G5R010.0Z2-DIA	03215537	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,1	2	6,06	8,33	9,23	9,5	9,71	9,89	10,59	■
JME642012G5R012.0Z2-DIA	03215538	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,12	2	5,23	10,33	10,78	11,07	11,3	11,5	12,46	■
JME642015G5R015.0Z2-DIA	03215539	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,15	2	4,25	12,49	12,92	13,22	13,32	13,84	14,99	■
JME642020G5R015.0Z2-DIA	03236442	5	G	2,0	4,0	2,2	60,0	16,0	1,9	0,15	2	2,87	16,53	17,06	17,61	18,91	18,82	–	■
JME642020G5R020.0Z2-DIA	03215540	5	G	2,0	4,0	3,0	60,0	16,0	1,9	0,2	2	2,87	16,49	17,02	17,36	17,77	18,45	–	■
JME642010G6R010.0Z2-DIA	03215541	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,1	2	4,86	12,33	12,84	13,16	13,4	13,81	14,96	■
JME642015G6R015.0Z2-DIA	03215542	6	G	1,5	4,0	2,4	50,0	18,0	1,4	0,15	2	3,13	18,49	19,07	19,43	19,99	20,76	22,49	■
JME642020G6R020.0Z2-DIA	03215543	6	G	2,0	4,0	3,0	60,0	25,0	1,9	0,2	2	1,97	25,49	26,21	26,78	27,77	28,83	–	■
JME642020G7R020.0Z2-DIA	03215544	7	G	2,0	4,0	3,0	60,0	30,0	1,9	0,2	2	1,68	30,49	31,03	32,13	33,32	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to $\alpha\eta$ ($l\alpha\eta$, ref)*

Cutting data – JME642/JME662 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

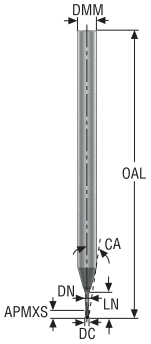
SMG		a_p/DC	f_z									v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.30 *0,30*	0.022 *0,00085*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	140 (110 — 300) *460 (370 — 980)*

Table based on LV3, please recalc based on length version chosen. See page(s) 447 - 454

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	PCEDC	CA°	WDX0*	WDX05*	WDX1*	WDX15*	WDX2*	WDX3*	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	2	14,5	0,59	0,65	0,7	0,76	0,81	0,92	■
JMB642003G1B.0Z2-DIA	03215374	1	G	0,3	4,0	0,5	40,0	0,6	0,28	0,15	2		0,74	0,8	0,86	0,91	0,97	1,07	■
JMB642004G1B.0Z2-DIA	03215375	1	G	0,4	4,0	2,0	40,0	0,8	0,37	0,2	2	13,8	2,29	2,43	2,55	2,66	2,76	2,93	■
JMB642005G3B.0Z2-DIA	03215376	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,25	2	11,19	2,83	2,99	3,12	3,23	3,34	3,52	■
JMB642006G3B.0Z2-DIA	03215377	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,3	2		3,33	3,51	3,65	3,78	3,89	4,09	■
JMB642008G3B.0Z2-DIA	03215378	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,4	2	9,38	4,33	4,55	4,72	4,86	4,99	5,21	■
JMB642010G3B.0Z2-DIA	03215379	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,5	2	8,33	5,33	5,59	5,78	5,94	6,08	6,32	■
JMB642012G3B.0Z2-DIA	03215380	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,6	2	7,38	6,33	6,63	6,84	7,01	7,16	7,41	■
JMB642015G3B.0Z2-DIA	03215381	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,75	2	6,08	7,99	8,28	8,49	8,67	8,83	9,33	■
JMB642020G3B.0Z2-DIA	03215382	3	G	2,0	4,0	3,0	60,0	10,0	1,9	1,0	2	4,35	10,49	10,84	11,1	11,3	11,5	12,44	■
JMB662030G3B.0Z2-DIA	03215384	3	G	3,0	6,0	3,0	60,0	15,0	2,8	1,5	2	4,38	15,71	16,1	16,39	16,67	17,3	18,72	■
JMB642005G5B.0Z2-DIA	03215387	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,25	2	9,6	4,33	4,56	4,73	4,88	5,01	5,23	■
JMB642006G5B.0Z2-DIA	03215388	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,3	2	8,68	5,33	5,6	5,79	5,96	6,1	6,34	■
JMB642008G5B.0Z2-DIA	03215389	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,4	2	7,18	7,33	7,67	7,91	8,09	8,26	8,7	■
JMB642010G5B.0Z2-DIA	03215390	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,5	2	6,22	8,83	9,22	9,48	9,68	9,86	10,57	■
JMB642012G5B.0Z2-DIA	03215391	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,6	2	5,4	10,33	10,77	11,05	11,27	11,49	12,44	■
JMB642015G5B.0Z2-DIA	03215392	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,75	2	4,4	12,49	12,91	13,19	13,42	13,81	14,96	■
JMB642020G5B.0Z2-DIA	03215393	5	G	2,0	4,0	3,0	60,0	16,0	1,9	1,0	2	2,99	16,49	17,0	17,33	17,75	18,42	19,94	■
JMB662030G5B.0Z2-DIA	03215395	5	G	3,0	6,0	3,0	60,0	24,0	2,8	1,5	2	3,0	24,71	25,28	25,73	26,67	27,68	29,97	■
JMB642010G6B.0Z2-DIA	03215396	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,5	2	4,96	12,33	12,83	13,14	13,38	13,8	14,94	■
JMB642015G6B.0Z2-DIA	03215397	6	G	1,5	4,0	2,4	60,0	18,0	1,4	0,75	2	3,21	18,49	19,05	19,41	19,97	20,74	22,45	■
JMB642020G6B.0Z2-DIA	03215398	6	G	2,0	4,0	3,0	60,0	25,0	1,9	1,0	2	2,03	25,49	26,2	26,76	27,75	28,81	–	■
JMB642020G7B.0Z2-DIA	03215399	7	G	2,0	4,0	3,0	60,0	30,0	1,9	1,0	2	1,72	30,49	31,29	32,12	33,3	–	–	■

■ Stocked standard.
For WDX values: Max. cut depth rel. to a_p (l_{a_p}, ref)*

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

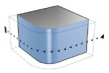
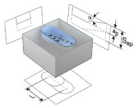
SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Table based on LV3, please recalc based on length version chosen. See page(s) 447 - 454

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

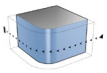
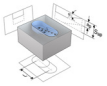

vodafone NL 13:09 61%
JABRO®-HPM
1. Material:...Ni-based super alloys
2. Strategy: HPM
3. Operation: Side rough
4. Type: JHP780
5. Length: 2
6. Diameter: 12 mm
ap = 9.6000 mm
ae = 3.6000 mm
Vc = 30(35-25) m/min
n = 800 rev/min
fz = 0.072 mm
Vf = 230 mm/min
Coolant = E
Calculator
SWAP
Product search
More

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° *						
JS512																
LV2	100	100	100	100	100	110	3	65	125	40	40	100	3	130	40	40
LV3	30	100	25	50	170	110	3	65	210	X	X	X	X	X	X	X
LV4	X	X	X	X	X	70	3	65	290	X	X	X	X	X	X	X
										≤ 5° *						
JS513																
LV2	100	100	100	100	100	110	3	85	150	100	100	100	3	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	70	3	85	350	X	X	X	X	X	X	X
										≤ 5° *						
JS514																
LV2	100	100	100	100	100	110	3	60	150	100	100	100	3	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	70	3	60	350	X	X	X	X	X	X	X
										≤ 45° *						
JS553																
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																
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

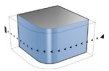
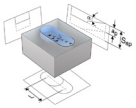
*Max ramping angle
All values are percentages of original (100%) cutting data.

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

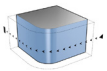
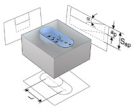
*Max ramping angle
All values are percentages of original (100%) cutting data.

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																
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		

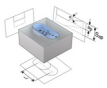
*Max ramping angle
All values are percentages of original (100%) cutting data.

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

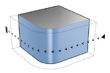
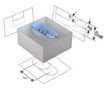
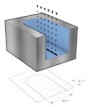
*Max ramping angle
All values are percentages of original (100%) cutting data.

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

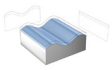
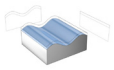
*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version side rough cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!								
	Slotting		Side rough			Side finish				Ramping		Helical			Plunging			
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)	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

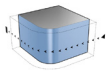
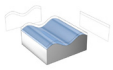
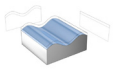
*Max ramping angle
All values are percentages of original (100%) cutting data.

Recalculation

Use original standard version cutting data then recalculate parameters!										Use original standard version slotting cutting data then recalculate parameters!									
	Slotting		Side rough			Side finish				Copy milling roughing			Copy milling finishing				Helical		
BALL																			
	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)
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
JH970																			
LV2	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
JH720																			
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!									
	Slotting		Side rough			Side finish				Copy milling roughing			Copy milling finishing				Helical		
BALL																			
	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

$$v_c = \frac{n \cdot \pi \cdot D_w}{1000} \quad \text{(m/min)}$$

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_w} \quad \text{(RPM)}$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad \text{(mm)}$$

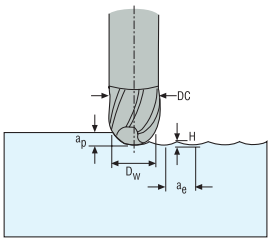
Calculation of a_p vs. overhang length:
If the overhang length (XS) is longer than 4 x DC and Cylindrical shanks are used it is important to adopt another depth of cut (a_p) value than that indicated in the table.
Use the following formula to calculate the new a_p value

$a_p new = a_p \times (4 \times DC/XS)^2$

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)

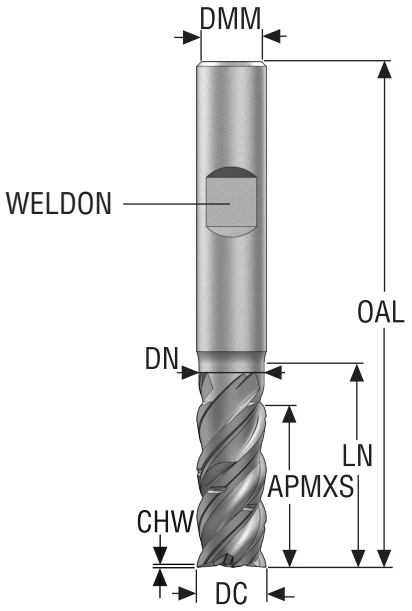
DC	Pitch a_e (µm)						
	0,06	0,08	0,11	0,15	0,20	0,3	0,45
1	0,90	1,60	3,00	5,70	10,0	23,0	53,0
2	0,45	0,80	1,50	2,80	5,0	11,0	26,0
4	0,23	0,40	0,76	1,40	2,5	5,60	13,0
6	0,15	0,27	0,50	0,94	1,7	3,80	8,40
8	0,11	0,20	0,38	0,70	1,3	2,80	6,30
10	0,09	0,16	0,30	0,56	1,0	2,30	5,10
12	0,08	0,13	0,25	0,47	0,83	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 (cm^3/min)
v_c = Cutting speed (m/min)
v_f = Feed speed (mm/min)
D_w = Working diameter

Operation recommendations

Measurement drawing should be read as follows:

DMM	=	Shank diameter
CHW	=	Chamfer
DC	=	Milling cutting diameter
M	=	Minimum clamping length
OAL	=	Total length
LN	=	Maximum milling cutter depth
APMXS	=	Effective cutting length
RE	=	Corner radius
RE2	=	Radius behind the cutting edge
DN	=	Neck reduction

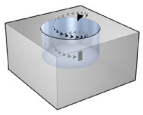


Ramping method

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

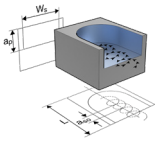


Trochoidal method

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



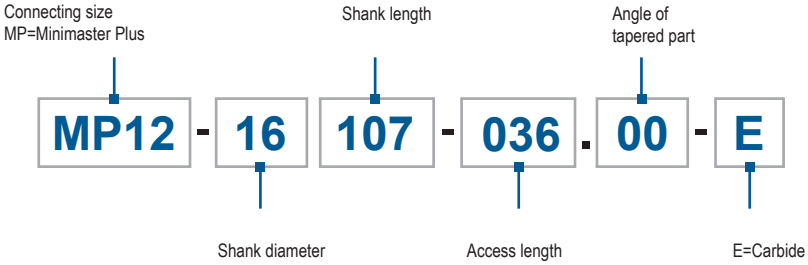
MINIMASTER™ PLUS

Minimaster™ Plus is the next generation line of end mills with replaceable fluted inserts.
This replaceable cutting head tool system builds on the success of the industry leading Minimaster™ system and reaches the highest level of precision and productivity.

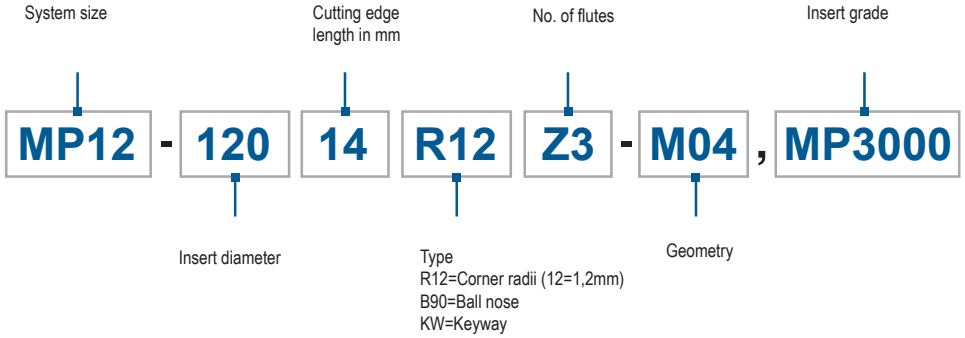
- Square Shoulder range: 10-16 mm (.375 - .625 inch)
- Ballnose range: 10-16 mm (.375 - .625 inch)
- Center Drilling/Chamfering range: 10-16 mm (.375 - .625 inch)
- High Feed range: 10-16 mm (.375 - .625 inch)

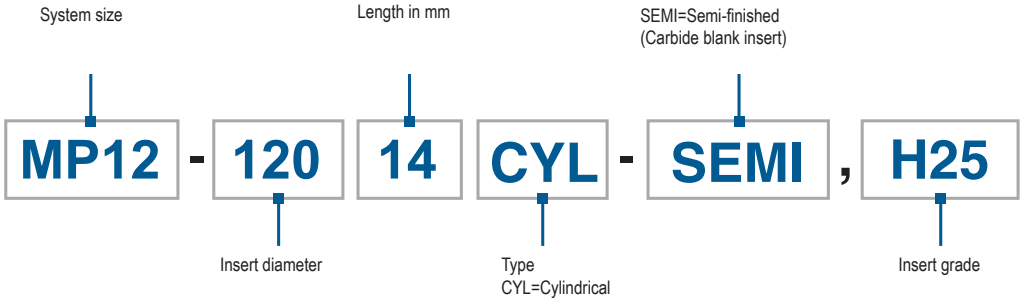
Code keys

Code key shanks



Code key inserts





Internal through coolant

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 616 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.

Note! Carbide shanks are to be used for Finishing/Semi finishing operations only.

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 [XXX].
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(ae/DC%), for ball nose cutters use the effective working diameter Dw 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 Plus figures

Figure 1

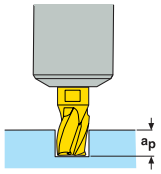


Figure 2

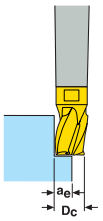


Figure 3

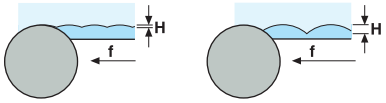


Figure 4

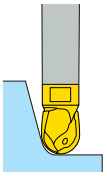


Figure 5

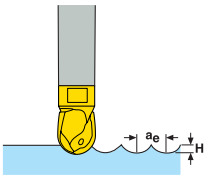
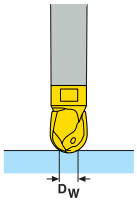
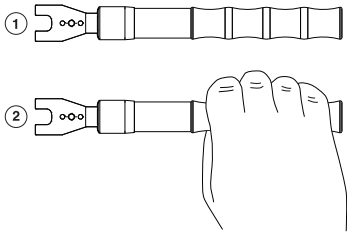
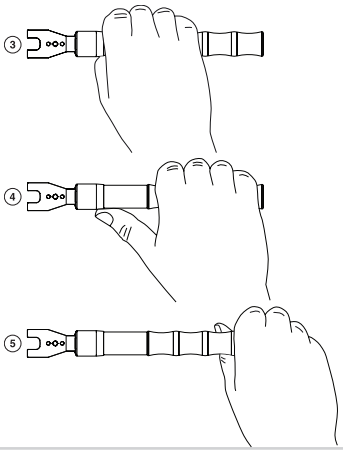


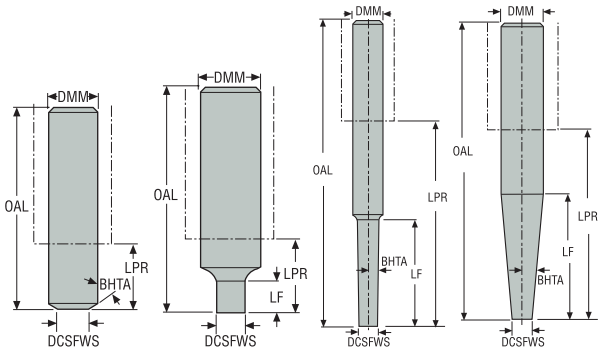
Figure 6



Torque wrench information and user instruction

Torque wrench	
	We recommend a torque wrench when mounting the insert for best precision and extended tool life. Different torque values for assembly – MP10: 11Nm – MP12: 15Nm – MP16: 19Nm Do not use worn out replaceable blades. Note: Torque wrenches and standard keys must be ordered separately!
	Use the arched handle (fig. 1) to grip the wrench by hand as shown (fig. 2)
	Do not grip the wrench as shown on figure 3-5, there is a risk that the applied torque might be incorrect and the insert will not be properly seated.

MP10 Shank – Metric

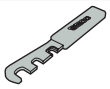
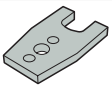


Design 1 **Design 2** **Design 3** **Design 4**

- Cylindrical shank DMM with tolerance h5, compatible for Shrinkfit

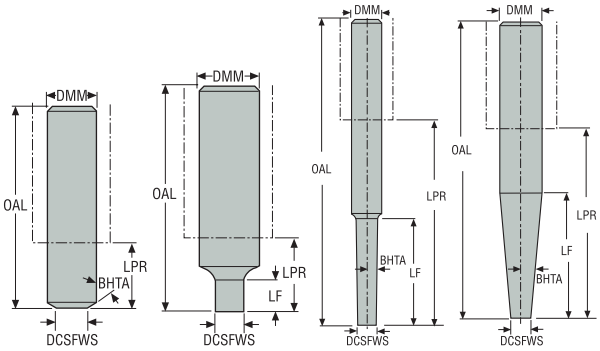
Designation	ShankType	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Design		Weight
		mm	mm	mm	mm	mm					kg
MP10-10055-010.00	Cylindrical	9,8	10,0	55,0	15,0	10,0	80000	0,0	2	✓	0,1
MP10-16068-000.60	Cylindrical	9,5	16,0	68,0	20,0	0,0	80000	60,0	1	✓	0,2
MP10-16073-015.00	Cylindrical	9,8	16,0	73,0	25,0	15,0	80000	0,0	2	✓	0,1
MP10-16118-035.01	Cylindrical	9,5	16,0	118,0	70,0	35,0	80000	1,0	3	✓	0,2
MP10-16158-060.01	Cylindrical	9,5	16,0	158,0	110,0	60,0	80000	1,0	3	✓	0,2
MP10-20100-045.03	Cylindrical	9,5	20,0	100,0	50,0	45,0	80000	3,0	3	✓	0,2
MP10-20140-085.03	Cylindrical	9,5	20,0	140,0	90,0	85,0	80000	3,0	3	✓	0,3
MP10-20140-090.05	Cylindrical	9,5	20,0	140,0	90,0	60,0	80000	5,0	4	✓	0,3
MP10-12095-030.00-E	Cylindrical Carbide	9,8	12,0	95,0	50,0	30,0	80000	0,0	2	✓	0,2
MP10-12105-040.00-E	Cylindrical Carbide	9,8	12,0	105,0	60,0	40,0	80000	0,0	2	✓	0,2
MP10-12125-060.00-E	Cylindrical Carbide	9,8	12,0	125,0	80,0	60,0	80000	0,0	2	✓	0,2
MP10-16120-050.01-E	Cylindrical Carbide	9,5	16,0	120,0	72,0	50,0	80000	1,0	3	✓	0,3
MP10-16150-080.01-E	Cylindrical Carbide	9,5	16,0	150,0	102,0	80,0	80000	1,0	3	✓	0,3
MP10-16170-100.01-E	Cylindrical Carbide	9,5	16,0	170,0	122,0	100,0	80000	1,0	3	✓	0,4
MP10-16140-092.03-E	Cylindrical Carbide	9,5	16,0	140,0	92,0	62,0	80000	3,0	4	✓	0,4
MP10-16170-122.03-E	Cylindrical Carbide	9,5	16,0	170,0	122,0	62,0	80000	3,0	4	✓	0,4

Accessories

Key	Replacement blade	Torque key
		
MP1016	MP00-10M	MP00-10.110

Blades are included with the torque key

MP10 Shank – *Inch*

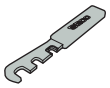
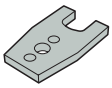


Design 1 Design 2 Design 3 Design 4

- Cylindrical shank DMM with tolerance h5, compatible for Shrinkfit

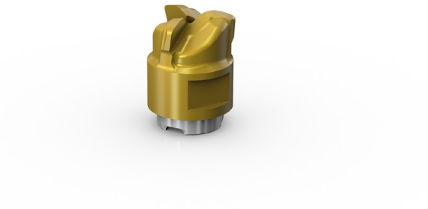
Designation	ShankType	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Design		Weight
		Inch	Inch	Inch	Inch	Inch					lbs
MP10-0372.1-0.39.00	Cylindrical	0.370	0.375	2.122	0.591	0.394	80000	0,0	2	✓	0.220
MP10-0622.6-0.00.60	Cylindrical	0.374	0.625	2.662	0.787	–	80000	60,0	1	✓	0.220
MP10-0622.8-0.59.00	Cylindrical	0.370	0.625	2.859	0.984	0.591	80000	0,0	2	✓	0.220
MP10-0624.6-1.37.01	Cylindrical	0.374	0.625	4.631	2.756	1.378	80000	1,0	3	✓	0.440
MP10-0626.2-2.36.01	Cylindrical	0.374	0.625	6.206	4.331	2.362	80000	1,0	3	✓	0.440
MP10-0753.9-1.80.03	Cylindrical	0.374	0.750	3.969	1.969	1.799	80000	3,0	3	✓	0.440
MP10-0755.5-3.40.03	Cylindrical	0.374	0.750	5.543	3.543	3.402	80000	3,0	4	✓	0.660
MP10-0755.5-3.54.05	Cylindrical	0.374	0.750	5.543	3.543	2.150	80000	5,0	4	✓	0.660
MP10-0504.8-2.36.00-E	Cylindrical Carbide	0.370	0.500	4.900	3.150	2.362	80000	0,0	2	✓	0.440

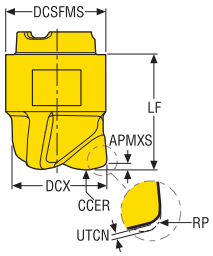
Accessories

Key	Replacement blade	Torque key
		
MP1016	MP00-10M	MP00-10.110

Blades are included with the torque key

MP10 High feed





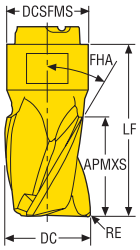
• For insert selection and cutting data recommendations, see page(s) 471-472

Z3

Designation	DCX	DC	APMXS	DCSFMS	CCER	RP	LF	UTCN	RMPX°	C min	C max	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*						MP3000	F40M
MP10-1000.6HFZ3-MD08	10,0 *0.394*	5,0 *0.197*	0,6 *0.024*	9,6 *0.378*	6,2 *0.244*	1,13 *0.044*	11,0 *0.433*	0,32 *0.013*	5,0	10,9	14,8	3	✓	■	
MP10-0950.6HFZ3-MD08	9,525 *0.375*	4,55 *0.179*	0,6 *0.024*	9,4 *0.370*	6,2 *0.244*	1,13 *0.044*	11,0 *0.433*	0,32 *0.013*	5,0	10,4	13,4	3	✓	■	

MP10 Square shoulder

Slotting and contouring



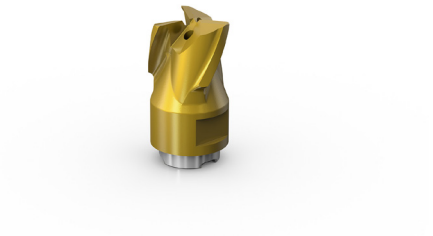
• For insert selection and cutting data recommendations, see page(s) 473-474

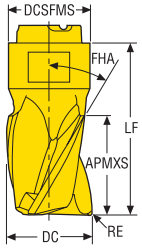
Z3

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	RMPX°	C min	C max	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							MP3000	F40M
MP10-09807KWZ3-E03	9,8 *0.386*	7,0 *0.276*	0,3 *0.012*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,0	18,8	3	✓		■
MP10-10007R04Z3-E03	10,0 *0.394*	7,0 *0.276*	0,4 *0.016*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	19,0	3	✓		■
MP10-10007R04Z3-M03	10,0 *0.394*	7,0 *0.276*	0,4 *0.016*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	19,0	3	✓	■	
MP10-10007R05Z3-E03	10,0 *0.394*	7,0 *0.276*	0,5 *0.020*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	18,8	3	✓		■
MP10-10007R08Z3-E03	10,0 *0.394*	7,0 *0.276*	0,8 *0.031*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	18,2	3	✓		■
MP10-10007R08Z3-M03	10,0 *0.394*	7,0 *0.276*	0,8 *0.031*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	18,2	3	✓	■	
MP10-10007R20Z3-E03	10,0 *0.394*	7,0 *0.276*	2,0 *0.079*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	15,8	3	✓		■
MP10-10007R31Z3-E03	10,0 *0.394*	7,0 *0.276*	3,1 *0.122*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	13,6	3	✓		■

MP10 Square shoulder

Slotting and contouring





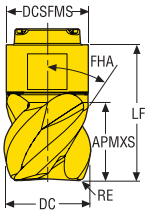
• For insert selection and cutting data recommendations, see page(s) 473-474

Z3

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	RMPX°	C min	C max	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							MP3000	F40M
MP10-09812KWZ3-E03	9,8 *0.386*	12,0 *0.472*	0,3 *0.012*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,0	18,8	3	✓		■
MP10-10012R04Z3-E03	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	19,0	3	✓		■
MP10-10012R04Z3-M03	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	19,0	3	✓	■	
MP10-10012R05Z3-E03	10,0 *0.394*	12,0 *0.472*	0,5 *0.020*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	18,8	3	✓		■
MP10-10012R08Z3-E03	10,0 *0.394*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	18,2	3	✓		■
MP10-10012R08Z3-M03	10,0 *0.394*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	18,2	3	✓	■	
MP10-10012R20Z3-E03	10,0 *0.394*	12,0 *0.472*	2,0 *0.079*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	15,8	3	✓		■
MP10-10012R31Z3-E03	10,0 *0.394*	12,0 *0.472*	3,1 *0.122*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	13,6	3	✓		■
MP10-09512R04Z3-E03	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	18,0	3	✓		■
MP10-09512R04Z3-M03	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	18,0	3	✓	■	
MP10-09512R08Z3-E03	9,525 *0.375*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	17,2	3	✓		■
MP10-09512R08Z3-M03	9,525 *0.375*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	17,2	3	✓	■	
MP10-09512R16Z3-E03	9,525 *0.375*	12,0 *0.472*	1,6 *0.063*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	15,6	3	✓		■
MP10-09512R31Z3-E03	9,525 *0.375*	12,0 *0.472*	3,1 *0.122*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	12,6	3	✓		■

MP10 Square shoulder

Slotting and contouring



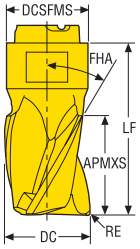
• For insert selection and cutting data recommendations, see page(s) 473-474

Z4

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	RMPX°	ZEFP	Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				MP3000	F40M
MP10-10007R04Z4-M02	10,0 *0.394*	7,0 *0.276*	0,4 *0.016*	9,6 *0.378*	16,0 *0.630*	50	15,0	4	■	
MP10-10007R05Z4-E02	10,0 *0.394*	7,0 *0.276*	0,5 *0.020*	9,6 *0.378*	16,0 *0.630*	50	15,0	4		■
MP10-10007R08Z4-E02	10,0 *0.394*	7,0 *0.276*	0,8 *0.031*	9,6 *0.378*	16,0 *0.630*	50	15,0	4		■
MP10-10007R08Z4-M02	10,0 *0.394*	7,0 *0.276*	0,8 *0.031*	9,6 *0.378*	16,0 *0.630*	50	15,0	4	■	
MP10-10007R16Z4-E02	10,0 *0.394*	7,0 *0.276*	1,6 *0.063*	9,6 *0.378*	16,0 *0.630*	50	15,0	4		■
MP10-10012R04Z4-E02	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-10012R04Z4-M02	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	50	15,0	4	■	
MP10-10012R05Z4-E02	10,0 *0.394*	12,0 *0.472*	0,5 *0.020*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-10012R08Z4-E02	10,0 *0.394*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-10012R08Z4-M02	10,0 *0.394*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	50	15,0	4	■	
MP10-10012R16Z4-E02	10,0 *0.394*	12,0 *0.472*	1,6 *0.063*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-09512R04Z4-E02	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-09512R04Z4-M02	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	50	15,0	4	■	
MP10-09512R08Z4-E02	9,525 *0.375*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-09512R08Z4-M02	9,525 *0.375*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	50	15,0	4	■	

MP10 Square shoulder

Contouring only

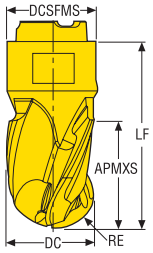


• For insert selection and cutting data recommendations, see page(s) 473-474

Z5

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	ZEFP	Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			MP3000	F40M
MP10-10012R04Z5-M02	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	40	5	■	
MP10-09512R04Z5-M02	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	40	5	■	

MP10 Ball nose design



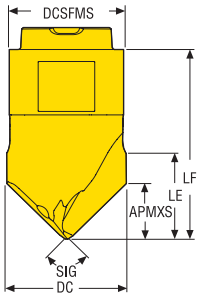
• For insert selection and cutting data recommendations, see page(s) 475-476

Z3

Z4

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	RMPX°	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					MP3000	F40M
MP10-10007B90Z3-E03	10,0 *0.394*	7,0 *0.276*	5,0 *0.197*	9,6 *0.378*	16,0 *0.630*	30	15,0	3	✓		■
MP10-10007B90Z3-M03	10,0 *0.394*	7,0 *0.276*	5,0 *0.197*	9,6 *0.378*	16,0 *0.630*	30	15,0	3	✓	■	
MP10-10012B90Z3-E03	10,0 *0.394*	12,0 *0.472*	5,0 *0.197*	9,6 *0.378*	21,0 *0.827*	30	15,0	3	✓		■
MP10-10012B90Z3-M03	10,0 *0.394*	12,0 *0.472*	5,0 *0.197*	9,6 *0.378*	21,0 *0.827*	30	15,0	3	✓	■	
MP10-10007B90Z4-E02	10,0 *0.394*	7,0 *0.276*	5,0 *0.197*	9,6 *0.378*	16,0 *0.630*	20	15,0	4			■
MP10-10007B90Z4-M02	10,0 *0.394*	7,0 *0.276*	5,0 *0.197*	9,6 *0.378*	16,0 *0.630*	20	15,0	4		■	
MP10-09507B90Z3-E03	9,525 *0.375*	7,0 *0.276*	4,7625 *0.188*	9,4 *0.370*	16,0 *0.630*	30	15,0	3	✓		■
MP10-09507B90Z3-M03	9,525 *0.375*	7,0 *0.276*	4,7625 *0.188*	9,4 *0.370*	16,0 *0.630*	30	15,0	3	✓	■	
MP10-09512B90Z3-E03	9,525 *0.375*	12,0 *0.472*	4,7625 *0.188*	9,6 *0.378*	21,0 *0.827*	30	15,0	3	✓		■
MP10-09512B90Z3-M03	9,525 *0.375*	12,0 *0.472*	4,7625 *0.188*	9,6 *0.378*	21,0 *0.827*	30	15,0	3	✓	■	
MP10-09507B90Z4-E02	9,525 *0.375*	7,0 *0.276*	4,7625 *0.188*	9,4 *0.370*	16,0 *0.630*	20	15,0	4			■
MP10-09507B90Z4-M02	9,525 *0.375*	7,0 *0.276*	4,7625 *0.188*	9,4 *0.370*	16,0 *0.630*	20	15,0	4		■	

MP10 Centre drilling/Chamfering

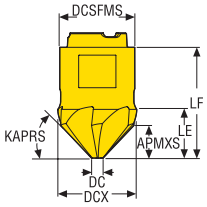


• For insert selection and cutting data recommendations, see page(s) 477-478

Z2

Designation	DC	APMXS	DCSFMS	LE	LF	SIG°	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				MP3000	F40M
MP10-10006C90Z2-M03	10,0 *0.394*	4,6 *0.181*	9,6 *0.378*	7,1 *0.280*	16,0 *0.630*	90,0	2	✓		■

MP10 Chamfering

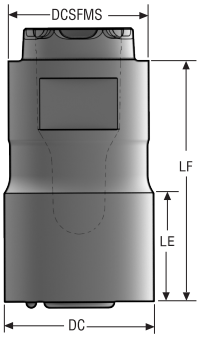


• For insert selection and cutting data recommendations, see page(s) 479-480

Z6

Designation	DCX	DC	APMXS	DCSFMS	LE	LF	KAPRS°	ZEFP	Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			MP3000	F40M
MP10-10006C90Z6-M03	10,1 *0.398*	1,95 *0.077*	4,0 *0.157*	9,6 *0.378*	5,9 *0.232*	14,5 *0.571*	45,0	6		■

MP10 Cylindrical blanks



- Cylindrical carbide blanks for production of own geometries

Designation	DC	DCSFMS	LE	LF	Grades Uncoated
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	H25
MP10-10007CYL-SEMI	10,15 *0.400*	9,6 *0.378*	7,3 *0.287*	16,3 *0.642*	■
MP10-10012CYL-SEMI	10,15 *0.400*	9,6 *0.378*	12,4 *0.488*	21,3 *0.839*	■

MP10 High feed milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P2	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,46 *0.018*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
P3	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,70 *0.028*
P4	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,44 *0.017*	0,44 *0.017*	0,55 *0.022*	0,70 *0.028*
P5	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
P6	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
P7	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
P8	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,70 *0.028*
P11	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
P12	MP10-0950.6HFZ3-MD08 MP3000	0,34 *0.013*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
M1	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,46 *0.018*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
M2	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
M3	MP10-1000.6HFZ3-MD08 MP3000	0,34 *0.013*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
M4	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
M5	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K1	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,46 *0.018*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
K2	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
K3	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
K4	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
K5	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,38 *0.015*	0,38 *0.015*	0,50 *0.020*	0,60 *0.024*
K6	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
K7	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,38 *0.015*	0,38 *0.015*	0,50 *0.020*	0,60 *0.024*
N1	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
N2	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
N3	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
N11	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
S1	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
S2	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
S3	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,30 *0.012*	0,28 *0.011*	0,36 *0.014*	0,44 *0.017*
S11	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
S12	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
S13	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
H5	MP10-1000.6HFZ3-MD08 MP3000	0,34 *0.013*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
H8	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,24 *0.0095*	0,22 *0.0085*	0,28 *0.011*	0,34 *0.013*
H11	MP10-1000.6HFZ3-MD08 MP3000	0,34 *0.013*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
H12	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,24 *0.0095*	0,22 *0.0085*	0,28 *0.011*	0,34 *0.013*
H21	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,24 *0.0095*	0,22 *0.0085*	0,28 *0.011*	0,34 *0.013*

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

MP10 High feed milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000			
	100%	70%	30%	20%
P1	250 *820*	305 *1000*	355 *1175*	370 *1225*
P2	245 *800*	295 *970*	345 *1125*	360 *1175*
P3	215 *710*	260 *850*	295 *970*	315 *1025*
P4	190 *620*	230 *750*	265 *870*	275 *900*
P5	180 *590*	220 *720*	255 *840*	265 *870*
P6	205 *670*	245 *800*	285 *940*	295 *970*
P7	190 *620*	235 *770*	270 *890*	280 *920*
P8	180 *590*	220 *720*	250 *820*	265 *870*
P11	185 *610*	225 *740*	260 *850*	275 *900*
P12	120 *395*	145 *475*	165 *540*	175 *570*
M1	185 *610*	220 *720*	255 *840*	270 *890*
M2	150 *490*	185 *610*	210 *690*	220 *720*
M3	120 *395*	145 *475*	170 *560*	180 *590*
M4	95 *310*	115 *375*	130 *425*	140 *460*
M5	80 *260*	95 *310*	110 *360*	115 *375*
K1	195 *640*	235 *770*	275 *900*	285 *940*
K2	170 *560*	210 *690*	240 *790*	250 *820*
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	120 *395*	150 *490*	170 *560*	180 *590*
K7	110 *360*	130 *425*	150 *490*	160 *520*
N1	1450 *4750*	1750 *5750*	2025 *6650*	2100 *6900*
N2	580 *1900*	710 *2325*	810 *2650*	850 *2800*
N3	390 *1275*	470 *1550*	540 *1775*	570 *1875*
N11	445 *1450*	540 *1775*	620 *2025*	650 *2125*
S1	45 *150*	55 *180*	60 *195*	65 *215*
S2	36 *120*	42 *140*	49 *160*	50 *165*
S3	31 *100*	37 *120*	43 *140*	45 *150*
S11	60 *195*	75 *245*	85 *280*	90 *295*
S12	43 *140*	50 *165*	60 *195*	60 *195*
S13	25 *80*	30 *100*	34 *110*	36 *120*
H5	37 *120*	45 *150*	50 *165*	55 *180*
H8	39 *130*	47 *155*	55 *180*	60 *195*
H11	48 *155*	55 *180*	65 *215*	70 *230*
H12	75 *245*	90 *295*	105 *345*	110 *360*
H21	39 *130*	47 *155*	55 *180*	60 *195*

MP10 Slot and Side milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	30%	10%	5%
P1	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,10 *0.0040*
P2	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*
P3	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 *0.0038*
P4	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,044 *0.0017*	0,065 *0.0026*	0,095 *0.0038*
P5	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
P6	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,038 *0.0015*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
P7	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,038 *0.0015*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
P8	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 *0.0038*
P11	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,038 *0.0015*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
P12	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,026 *0.0010*	0,030 *0.0012*	0,044 *0.0017*	0,060 *0.0024*
M1	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*
M2	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
M3	MP10-10007R04Z3-E03 F40M	2,5 *0.10*	0,032 *0.0013*	0,034 *0.0013*	0,055 *0.0022*	0,075 *0.0030*
M4	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
M5	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
K1	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*
K2	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
K3	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
K4	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
K5	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*	0,080 *0.0032*
K6	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
K7	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*	0,080 *0.0032*
N1	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
N2	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
N3	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
N11	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
S1	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
S2	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
S3	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,026 *0.0010*	0,028 *0.0011*	0,042 *0.0017*	0,060 *0.0024*
S11	MP10-10007R04Z3-E03 F40M	2,5 *0.10*	0,032 *0.0013*	0,034 *0.0013*	0,055 *0.0022*	0,075 *0.0030*
S12	MP10-10007R04Z3-E03 F40M	2,5 *0.10*	0,032 *0.0013*	0,034 *0.0013*	0,055 *0.0022*	0,075 *0.0030*
S13	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
H5	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,026 *0.0010*	0,030 *0.0012*	0,044 *0.0017*	0,060 *0.0024*
H8	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00085*	0,034 *0.0013*	0,048 *0.0019*
H11	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,026 *0.0010*	0,030 *0.0012*	0,044 *0.0017*	0,060 *0.0024*
H12	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00085*	0,034 *0.0013*	0,048 *0.0019*
H21	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00085*	0,034 *0.0013*	0,048 *0.0019*

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

MP10 Slot and Side milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000				F40M			
	100%	30%	10%	5%	100%	30%	10%	5%
P1	265 *870*	345 *1125*	405 *1325*	435 *1425*	250 *820*	325 *1075*	380 *1250*	410 *1350*
P2	255 *840*	335 *1100*	395 *1300*	425 *1400*	240 *790*	315 *1025*	370 *1225*	400 *1300*
P3	225 *740*	290 *950*	340 *1125*	365 *1200*	210 *690*	275 *900*	320 *1050*	345 *1125*
P4	195 *640*	255 *840*	300 *980*	325 *1075*	185 *610*	240 *790*	285 *940*	305 *1000*
P5	190 *620*	245 *800*	290 *950*	310 *1025*	175 *570*	235 *770*	270 *890*	295 *970*
P6	215 *710*	275 *900*	325 *1075*	350 *1150*	200 *660*	260 *850*	305 *1000*	330 *1075*
P7	200 *660*	260 *850*	305 *1000*	330 *1075*	190 *620*	245 *800*	290 *950*	310 *1025*
P8	190 *620*	245 *800*	285 *940*	310 *1025*	175 *570*	230 *750*	270 *890*	290 *950*
P11	195 *640*	255 *840*	295 *970*	320 *1050*	185 *610*	240 *790*	280 *920*	305 *1000*
P12	125 *410*	160 *520*	185 *610*	200 *660*	115 *375*	150 *490*	175 *570*	190 *620*
M1	190 *620*	250 *820*	295 *970*	315 *1025*	195 *640*	255 *840*	300 *980*	320 *1050*
M2	155 *510*	205 *670*	240 *790*	260 *850*	160 *520*	210 *690*	245 *800*	265 *870*
M3	125 *410*	165 *540*	190 *620*	205 *670*	125 *410*	165 *540*	195 *640*	210 *690*
M4	95 *310*	125 *410*	145 *475*	155 *510*	100 *330*	125 *410*	145 *475*	160 *520*
M5	80 *260*	105 *345*	120 *395*	130 *425*	80 *260*	105 *345*	125 *410*	135 *445*
K1	200 *660*	265 *870*	310 *1025*	335 *1100*	190 *620*	250 *820*	295 *970*	315 *1025*
K2	180 *590*	235 *770*	275 *900*	295 *970*	170 *560*	220 *720*	260 *850*	280 *920*
K3	150 *490*	200 *660*	230 *750*	250 *820*	140 *460*	185 *610*	220 *720*	235 *770*
K4	145 *475*	190 *620*	220 *720*	240 *790*	135 *445*	180 *590*	210 *690*	225 *740*
K5	85 *280*	115 *375*	135 *445*	145 *475*	80 *260*	110 *360*	125 *410*	135 *445*
K6	125 *410*	165 *540*	195 *640*	210 *690*	120 *395*	155 *510*	185 *610*	200 *660*
K7	110 *360*	145 *475*	170 *560*	185 *610*	105 *345*	140 *460*	160 *520*	175 *570*
N1	1525 *5000*	2000 *6550*	2350 *7700*	2525 *8275*	1450 *4750*	1875 *6150*	2225 *7300*	2375 *7800*
N2	620 *2025*	810 *2650*	950 *3125*	1025 *3375*	580 *1900*	760 *2500*	900 *2950*	960 *3150*
N3	410 *1350*	540 *1775*	630 *2075*	680 *2225*	390 *1275*	510 *1675*	600 *1975*	640 *2100*
N11	470 *1550*	610 *2000*	720 *2350*	780 *2550*	445 *1450*	580 *1900*	680 *2225*	730 *2400*
S1	45 *150*	60 *195*	70 *230*	75 *245*	46 *150*	60 *195*	70 *230*	75 *245*
S2	36 *120*	47 *155*	55 *180*	60 *195*	37 *120*	48 *155*	55 *180*	60 *195*
S3	31 *100*	41 *135*	47 *155*	50 *165*	32 *105*	42 *140*	48 *155*	50 *165*
S11	65 *215*	80 *260*	95 *310*	105 *345*	65 *215*	85 *280*	100 *330*	105 *345*
S12	44 *145*	55 *180*	65 *215*	70 *230*	45 *150*	60 *195*	70 *230*	75 *245*
S13	25 *80*	33 *110*	38 *125*	41 *135*	26 *85*	33 *110*	39 *130*	42 *140*
H5	38 *125*	49 *160*	60 *195*	60 *195*	39 *130*	50 *165*	60 *195*	65 *215*
H8	40 *130*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	60 *195*	65 *215*
H11	49 *160*	65 *215*	75 *245*	80 *260*	49 *160*	65 *215*	75 *245*	80 *260*
H12	75 *245*	100 *330*	115 *375*	125 *410*	70 *230*	95 *310*	110 *360*	115 *375*
H21	40 *130*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	60 *195*	65 *215*

MP10 Copy milling – Insert selection – mm/*Inch*

SMG		a_p	f_z				
			100%	30%	10%	5%	2%
P1	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*	0,17 *0.0065*
P2	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*	0,17 *0.0065*
P3	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,046 *0.0018*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P4	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,046 *0.0018*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P5	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P6	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P7	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P8	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,046 *0.0018*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P11	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P12	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
M1	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*	0,17 *0.0065*
M2	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
M3	MP10-10007B90Z3-E03 F40M	2,5 *0.10*	0,038 *0.0015*	0,038 *0.0015*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
M5	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
K1	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*	0,17 *0.0065*
K2	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
K3	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
K4	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
K5	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
K6	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
K7	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N1	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N2	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N3	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N11	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
S1	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
S2	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
S3	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,032 *0.0013*	0,032 *0.0013*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
S11	MP10-10007B90Z3-E03 F40M	2,5 *0.10*	0,038 *0.0015*	0,038 *0.0015*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MP10-10007B90Z3-E03 F40M	2,5 *0.10*	0,038 *0.0015*	0,038 *0.0015*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
H5	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H8	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,025 *0.0010*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,080 *0.0032*
H11	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H12	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,025 *0.0010*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,080 *0.0032*
H21	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,025 *0.0010*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	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

MP10 Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000					F40M				
	100%	30%	10%	5%	2%	100%	30%	10%	5%	2%
P1	275 *900*	330 *1075*	360 *1175*	385 *1275*	385 *1275*	260 *850*	310 *1025*	340 *1125*	365 *1200*	365 *1200*
P2	265 *870*	320 *1050*	345 *1125*	375 *1225*	375 *1225*	250 *820*	300 *980*	325 *1075*	355 *1175*	355 *1175*
P3	230 *750*	280 *920*	300 *980*	325 *1075*	325 *1075*	220 *720*	265 *870*	285 *940*	310 *1025*	305 *1000*
P4	205 *670*	245 *800*	265 *870*	290 *950*	290 *950*	195 *640*	230 *750*	250 *820*	270 *890*	270 *890*
P5	195 *640*	235 *770*	255 *840*	275 *900*	275 *900*	185 *610*	220 *720*	240 *790*	260 *850*	260 *850*
P6	220 *720*	265 *870*	285 *940*	310 *1025*	310 *1025*	205 *670*	250 *820*	270 *890*	295 *970*	290 *950*
P7	205 *670*	250 *820*	270 *890*	295 *970*	290 *950*	195 *640*	235 *770*	255 *840*	275 *900*	275 *900*
P8	195 *640*	235 *770*	255 *840*	275 *900*	270 *890*	185 *610*	220 *720*	240 *790*	260 *850*	255 *840*
P11	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	190 *620*	230 *750*	250 *820*	270 *890*	265 *870*
P12	125 *410*	155 *510*	160 *520*	175 *570*	175 *570*	120 *395*	145 *475*	155 *510*	165 *540*	165 *540*
M1	200 *660*	240 *790*	260 *850*	280 *920*	280 *920*	205 *670*	245 *800*	265 *870*	285 *940*	285 *940*
M2	165 *540*	195 *640*	215 *710*	230 *750*	230 *750*	165 *540*	200 *660*	215 *710*	235 *770*	235 *770*
M3	130 *425*	160 *520*	165 *540*	180 *590*	180 *590*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
M4	100 *330*	125 *410*	125 *410*	140 *460*	140 *460*	105 *345*	125 *410*	130 *425*	140 *460*	140 *460*
M5	85 *280*	100 *330*	105 *345*	115 *375*	115 *375*	85 *280*	105 *345*	110 *360*	115 *375*	115 *375*
K1	210 *690*	255 *840*	275 *900*	300 *980*	300 *980*	200 *660*	240 *790*	260 *850*	280 *920*	280 *920*
K2	185 *610*	220 *720*	245 *800*	260 *850*	260 *850*	175 *570*	210 *690*	230 *750*	245 *800*	245 *800*
K3	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*	150 *490*	180 *590*	195 *640*	210 *690*	210 *690*
K4	150 *490*	180 *590*	195 *640*	210 *690*	210 *690*	140 *460*	170 *560*	185 *610*	200 *660*	200 *660*
K5	90 *295*	110 *360*	120 *395*	125 *410*	130 *425*	85 *280*	105 *345*	110 *360*	120 *395*	120 *395*
K6	130 *425*	160 *520*	175 *570*	185 *610*	185 *610*	125 *410*	150 *490*	165 *540*	175 *570*	175 *570*
K7	115 *375*	140 *460*	150 *490*	165 *540*	165 *540*	110 *360*	130 *425*	145 *475*	155 *510*	155 *510*
N1	1600 *5250*	1925 *6325*	2100 *6900*	2275 *7475*	2250 *7375*	1500 *4925*	1825 *6000*	1975 *6475*	2150 *7050*	2125 *6975*
N2	650 *2125*	780 *2550*	840 *2750*	920 *3025*	900 *2950*	610 *2000*	730 *2400*	800 *2625*	860 *2825*	850 *2800*
N3	430 *1400*	520 *1700*	560 *1825*	610 *2000*	600 *1975*	405 *1325*	490 *1600*	530 *1750*	580 *1900*	570 *1875*
N11	490 *1600*	590 *1925*	640 *2100*	700 *2300*	690 *2275*	465 *1525*	560 *1825*	610 *2000*	660 *2175*	650 *2125*
S1	47 *155*	55 *180*	60 *195*	65 *215*	65 *215*	48 *155*	60 *195*	60 *195*	65 *215*	65 *215*
S2	38 *125*	46 *150*	48 *155*	50 *165*	50 *165*	39 *130*	47 *155*	49 *160*	55 *180*	55 *180*
S3	33 *110*	40 *130*	41 *135*	45 *150*	45 *150*	34 *110*	41 *135*	42 *140*	46 *150*	46 *150*
S11	65 *215*	80 *260*	85 *280*	90 *295*	90 *295*	70 *230*	85 *280*	85 *280*	95 *310*	95 *310*
S12	46 *150*	55 *180*	60 *195*	65 *215*	65 *215*	47 *155*	55 *180*	60 *195*	65 *215*	65 *215*
S13	27 *90*	32 *105*	33 *110*	36 *120*	36 *120*	27 *90*	33 *110*	34 *110*	37 *120*	37 *120*
H5	39 *130*	48 *155*	50 *165*	55 *180*	55 *180*	40 *130*	48 *155*	50 *165*	55 *180*	55 *180*
H8	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*
H11	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*
H12	80 *260*	95 *310*	100 *330*	110 *360*	110 *360*	75 *245*	90 *295*	95 *310*	100 *330*	100 *330*
H21	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*

MP10 Centre drilling – Insert selection – mm/*Inch*

SMG		f_z	a_{so}
			100%
P1	MP10-10006C90Z2-M03 F40M	0,042 *0.0017*	3,0 *0.12*
P2	MP10-10006C90Z2-M03 F40M	0,042 *0.0017*	3,0 *0.12*
P3	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
P4	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
P5	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
P6	MP10-10006C90Z2-M03 F40M	0,038 *0.0015*	3,0 *0.12*
P7	MP10-10006C90Z2-M03 F40M	0,038 *0.0015*	3,0 *0.12*
P8	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
P11	MP10-10006C90Z2-M03 F40M	0,038 *0.0015*	3,0 *0.12*
P12	MP10-10006C90Z2-M03 F40M	0,026 *0.0010*	2,0 *0.080*
M1	MP10-10006C90Z2-M03 F40M	0,042 *0.0017*	3,0 *0.12*
M2	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
M3	MP10-10006C90Z2-M03 F40M	0,032 *0.0013*	2,0 *0.080*
M4	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
M5	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
K1	MP10-10006C90Z2-M03 F40M	0,042 *0.0017*	3,0 *0.12*
K2	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
K3	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
K4	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
K5	MP10-10006C90Z2-M03 F40M	0,036 *0.0014*	3,0 *0.12*
K6	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
K7	MP10-10006C90Z2-M03 F40M	0,036 *0.0014*	3,0 *0.12*
N1	MP10-10006C90Z2-M03 F40M	0,055 *0.0022*	3,0 *0.12*
N2	MP10-10006C90Z2-M03 F40M	0,055 *0.0022*	3,0 *0.12*
N3	MP10-10006C90Z2-M03 F40M	0,055 *0.0022*	3,0 *0.12*
N11	MP10-10006C90Z2-M03 F40M	0,055 *0.0022*	3,0 *0.12*
S1	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
S2	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
S3	MP10-10006C90Z2-M03 F40M	0,025 *0.0010*	1,7 *0.065*
S11	MP10-10006C90Z2-M03 F40M	0,032 *0.0013*	1,9 *0.075*
S12	MP10-10006C90Z2-M03 F40M	0,032 *0.0013*	1,9 *0.075*
S13	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
H5	MP10-10006C90Z2-M03 F40M	0,026 *0.0010*	2,0 *0.080*
H8	MP10-10006C90Z2-M03 F40M	0,020 *0.00080*	1,9 *0.075*
H11	MP10-10006C90Z2-M03 F40M	0,026 *0.0010*	2,0 *0.080*
H12	MP10-10006C90Z2-M03 F40M	0,020 *0.00080*	1,9 *0.075*
H21	MP10-10006C90Z2-M03 F40M	0,020 *0.00080*	1,9 *0.075*

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

MP10 Centre drilling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M
	100%
P1	305 *1000*
P2	295 *970*
P3	260 *850*
P4	225 *740*
P5	215 *710*
P6	245 *800*
P7	230 *750*
P8	215 *710*
P11	225 *740*
P12	135 *445*
M1	240 *790*
M2	195 *640*
M3	150 *490*
M4	110 *360*
M5	95 *310*
K1	235 *770*
K2	205 *670*
K3	175 *570*
K4	165 *540*
K5	100 *330*
K6	145 *475*
K7	130 *425*
N1	1775 *5825*
N2	710 *2325*
N3	475 *1550*
N11	540 *1775*
S1	50 *165*
S2	42 *140*
S3	36 *120*
S11	75 *245*
S12	50 *165*
S13	29 *95*
H5	45 *150*
H8	46 *150*
H11	55 *180*
H12	85 *280*
H21	46 *150*

MP10 Chamfering – Insert selection – mm/*Inch*

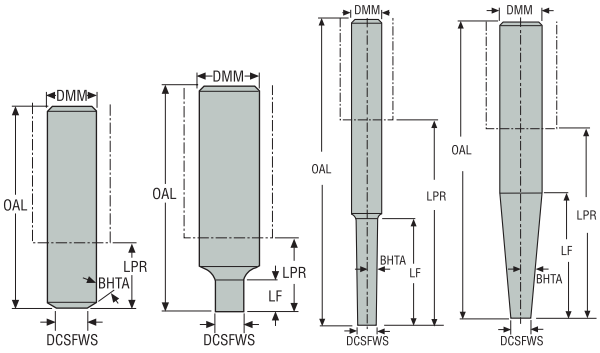
SMG		a_p	f_z				
			100%	50%	30%	20%	10%
P1	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
P2	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
P3	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
P4	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
P5	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
P6	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
P7	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
P8	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
P11	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
P12	MP10-10006C90Z2-M03 F40M	1,8 *0.070*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*
M1	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
M2	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
M3	MP10-10006C90Z2-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*
M4	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
M5	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
K1	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
K2	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
K3	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
K4	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
K5	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
K6	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
K7	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
N1	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
N2	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
N3	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
N11	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
S1	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
S2	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
S3	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,044 *0.0017*
S11	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*
S12	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*
S13	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
H5	MP10-10006C90Z2-M03 F40M	1,8 *0.070*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*
H8	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*
H11	MP10-10006C90Z2-M03 F40M	1,8 *0.070*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*
H12	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*
H21	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	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

MP10 Chamfering – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M				
	100%	50%	30%	20%	10%
P1	330 *1075*	300 *980*	360 *1175*	395 *1300*	465 *1525*
P2	320 *1050*	290 *950*	350 *1150*	385 *1275*	455 *1500*
P3	285 *940*	255 *840*	305 *1000*	340 *1125*	395 *1300*
P4	250 *820*	225 *740*	270 *890*	300 *980*	350 *1150*
P5	240 *790*	215 *710*	260 *850*	285 *940*	335 *1100*
P6	265 *870*	240 *790*	290 *950*	320 *1050*	380 *1250*
P7	250 *820*	230 *750*	275 *900*	300 *980*	355 *1175*
P8	240 *790*	215 *710*	260 *850*	285 *940*	330 *1075*
P11	245 *800*	220 *720*	265 *870*	295 *970*	345 *1125*
P12	155 *510*	140 *460*	160 *520*	175 *570*	220 *720*
M1	260 *850*	235 *770*	280 *920*	310 *1025*	365 *1200*
M2	215 *710*	195 *640*	230 *750*	255 *840*	305 *1000*
M3	170 *560*	150 *490*	175 *570*	195 *640*	240 *790*
M4	130 *425*	110 *360*	125 *410*	140 *460*	185 *610*
M5	105 *345*	90 *295*	105 *345*	120 *395*	155 *510*
K1	255 *840*	230 *750*	275 *900*	305 *1000*	360 *1175*
K2	225 *740*	205 *670*	245 *800*	270 *890*	320 *1050*
K3	190 *620*	175 *570*	205 *670*	230 *750*	270 *890*
K4	180 *590*	165 *540*	200 *660*	220 *720*	260 *850*
K5	110 *360*	100 *330*	120 *395*	135 *445*	155 *510*
K6	160 *520*	145 *475*	175 *570*	190 *620*	230 *750*
K7	140 *460*	130 *425*	155 *510*	170 *560*	200 *660*
N1	1925 *6325*	1725 *5650*	2075 *6800*	2300 *7550*	2700 *8850*
N2	770 *2525*	690 *2275*	840 *2750*	930 *3050*	1100 *3600*
N3	520 *1700*	465 *1525*	560 *1825*	620 *2025*	730 *2400*
N11	590 *1925*	530 *1750*	640 *2100*	710 *2325*	830 *2725*
S1	60 *195*	50 *165*	60 *195*	65 *215*	85 *280*
S2	48 *155*	41 *135*	47 *155*	55 *180*	70 *230*
S3	42 *140*	36 *120*	41 *135*	46 *150*	60 *195*
S11	85 *280*	75 *245*	85 *280*	95 *310*	120 *395*
S12	60 *195*	50 *165*	60 *195*	65 *215*	85 *280*
S13	34 *110*	29 *95*	33 *110*	37 *120*	48 *155*
H5	50 *165*	46 *150*	50 *165*	60 *195*	75 *245*
H8	55 *180*	47 *155*	55 *180*	60 *195*	75 *245*
H11	65 *215*	60 *195*	65 *215*	75 *245*	90 *295*
H12	95 *310*	85 *280*	95 *310*	110 *360*	135 *445*
H21	55 *180*	47 *155*	55 *180*	60 *195*	75 *245*

MP12 Shank – Metric

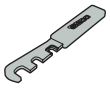
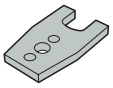


Design 1 Design 2 Design 3 Design 4

- Cylindrical shank DMM with tolerance h5, compatible for Shrinkfit

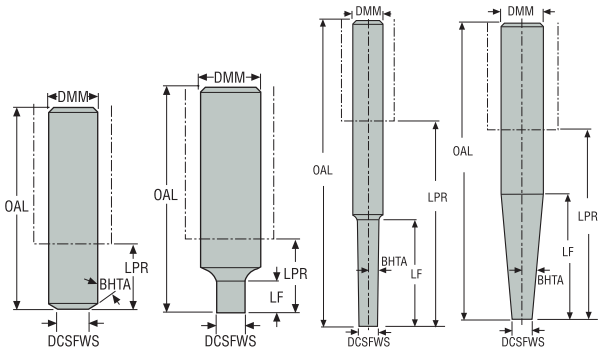
Designation	ShankType	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Design		Weight
		mm	mm	mm	mm	mm					kg
MP12-12060-012.00	Cylindrical	11,5	12,0	60,0	15,0	12,0	72700	0,0	2	✓	0,1
MP12-16068-000.60	Cylindrical	11,5	16,0	68,0	20,0	0,0	72700	60,0	1	✓	0,2
MP12-16078-018.00	Cylindrical	11,5	16,0	78,0	30,0	18,0	72700	0,0	2	✓	0,1
MP12-16153-042.01	Cylindrical	11,5	16,0	153,0	105,0	42,0	72700	1,0	3	✓	0,2
MP12-20170-072.01	Cylindrical	11,5	20,0	170,0	120,0	72,0	72700	1,0	3	✓	0,3
MP12-20110-055.03	Cylindrical	11,5	20,0	110,0	60,0	55,0	72700	3,0	3	✓	0,2
MP12-20150-100.03	Cylindrical	11,5	20,0	150,0	100,0	81,1	72700	3,0	3	✓	0,3
MP12-20155-105.05	Cylindrical	11,5	20,0	155,0	105,0	48,6	72700	5,0	4	✓	0,4
MP12-16107-036.00-E	Cylindrical Carbide	11,5	16,0	107,0	59,0	36,0	72700	0,0	2	✓	0,3
MP12-16120-048.00-E	Cylindrical Carbide	11,5	16,0	120,0	72,0	48,0	72700	0,0	2	✓	0,3
MP12-16150-072.00-E	Cylindrical Carbide	11,5	16,0	150,0	102,0	72,0	72700	0,0	2	✓	0,3
MP12-16120-060.01-E	Cylindrical Carbide	11,5	16,0	120,0	72,0	60,0	72700	1,0	3	✓	0,3
MP12-16150-096.01-E	Cylindrical Carbide	11,5	16,0	150,0	102,0	96,0	72700	1,0	3	✓	0,4
MP12-16175-120.01-E	Cylindrical Carbide	11,5	16,0	175,0	127,0	120,0	72700	1,0	3	✓	0,4
MP12-16155-107.03-E	Cylindrical Carbide	11,5	16,0	155,0	107,0	42,9	72700	3,0	4	✓	0,4
MP12-16180-132.03-E	Cylindrical Carbide	11,5	16,0	180,0	132,0	42,9	72700	3,0	4	✓	0,5

Accessories

Key	Replacement blade	Torque key
		
MP1016	MP00-12M	MP00-12.150

Blades are included with the torque key

MP12 Shank – *Inch*

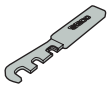
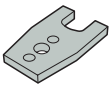


Design 1 **Design 2** **Design 3** **Design 4**

- Cylindrical shank DMM with tolerance h5, compatible for Shrinkfit

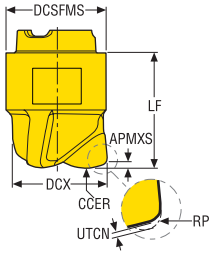
Designation	ShankType	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Design		Weight
		Inch	Inch	Inch	Inch	Inch					lbs
MP12-0502.3-0.47.00	Cylindrical	0.453	0.500	2.341	0.591	0.472	72700	0,0	2	✓	0.220
MP12-0622.6-0.00.60	Cylindrical	0.453	0.625	2.662	0.787	–	72700	60,0	1	✓	0.220
MP12-0623.0-0.70.00	Cylindrical	0.453	0.625	3.056	1.181	0.709	72700	0,0	2	✓	0.220
MP12-0626.0-1.65.01	Cylindrical	0.453	0.625	6.009	4.134	1.654	72700	1,0	3	✓	0.440
MP12-0754.3-2.20.03	Cylindrical	0.453	0.750	4.362	2.362	2.201	72700	3,0	3	✓	0.440
MP12-0755.9-3.93.03	Cylindrical	0.453	0.750	5.937	3.937	2.835	72700	3,0	3	✓	0.660
MP12-0756.1-4.13.05	Cylindrical	0.453	0.750	6.134	4.134	1.697	72700	5,0	4	✓	0.660
MP12-0756.7-2.83.01	Cylindrical	0.453	0.750	6.724	4.724	2.835	72700	1,0	4	✓	0.660
MP12-0627.0-5.19.03-E	Cylindrical Carbide	0.453	0.625	7.072	5.197	1.654	72700	3,0	4	✓	1.100
MP12-0625.8-2.83.00-E	Cylindrical Carbide	0.453	0.625	5.891	4.016	2.835	72700	0,0	2	✓	0.660

Accessories

Key	Replacement blade	Torque key
		
MP1016	MP00-12M	MP00-12.150

Blades are included with the torque key

MP12 High feed



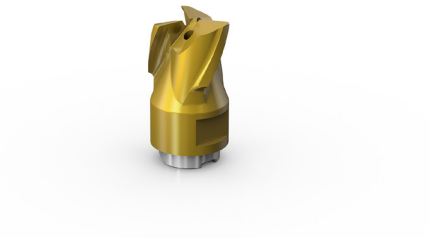
• For insert selection and cutting data recommendations, see page(s) 492-493

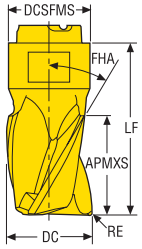
Z3

Designation	DCX	DC	APMXS	DCSFMS	CCER	RP	LF	UTCN	RMPX°	C min	C max	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*						MP3000	F40M
MP12-1200.7HFZ3-MD10	12,0 *0.472*	6,0 *0.236*	0,7 *0.028*	11,52 *0.454*	7,5 *0.295*	1,66 *0.065*	13,3 *0.524*	0,33 *0.013*	5,0	13,1	17,8	3	✓	■	
MP12-1270.7HFZ3-MD10	12,7 *0.500*	6,7 *0.264*	0,7 *0.028*	11,52 *0.454*	7,5 *0.295*	1,66 *0.065*	13,3 *0.524*	0,32 *0.013*	5,0	13,8	19,2	3	✓	■	

MP12 Square shoulder

Slotting and contouring





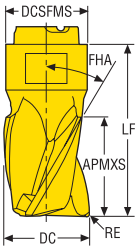
• For insert selection and cutting data recommendations, see page(s) 494-495

Z3

Designation	DC	APMXS	RE	DCSFMS	FHA°	LF	RMPX°	C min	C max	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*						MP3000	F40M
MP12-12008R04Z3-E04	12,0 *0.472*	8,0 *0.315*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	23,0	3	✓		■
MP12-12008R04Z3-M04	12,0 *0.472*	8,0 *0.315*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	23,0	3	✓	■	
MP12-12008R05Z3-E04	12,0 *0.472*	8,0 *0.315*	0,5 *0.020*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	22,8	3	✓		■
MP12-12008R08Z3-E04	12,0 *0.472*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	22,2	3	✓		■
MP12-12008R08Z3-M04	12,0 *0.472*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	22,2	3	✓	■	
MP12-12008R16Z3-E04	12,0 *0.472*	8,0 *0.315*	1,6 *0.063*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	20,6	3	✓		■
MP12-12008R31Z3-E04	12,0 *0.472*	8,0 *0.315*	3,1 *0.122*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	17,6	3	✓		■
MP12-12708R08Z3-M04	12,7 *0.500*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	15,4	23,6	3	✓	■	

MP12 Square shoulder

Slotting and contouring



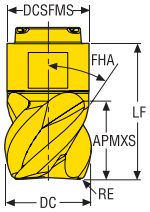
• For insert selection and cutting data recommendations, see page(s) 494-495

Z3

Designation	DC	APMXS	RE	DCSFMS	FHA°	LF	RMPX°	C min	C max	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*						MP3000	F40M
MP12-11714KWZ3-E04	11,7 *0.461*	14,0 *0.551*	0,3 *0.012*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,2	22,6	3	✓		■
MP12-12014R04Z3-E04	12,0 *0.472*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	23,0	3	✓		■
MP12-12014R04Z3-M04	12,0 *0.472*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	23,0	3	✓	■	
MP12-12014R05Z3-E04	12,0 *0.472*	14,0 *0.551*	0,5 *0.020*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	22,8	3	✓		■
MP12-12014R08Z3-M04	12,0 *0.472*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	22,2	3	✓	■	
MP12-12014R12Z3-E04	12,0 *0.472*	14,0 *0.551*	1,2 *0.047*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	21,4	3	✓		■
MP12-12014R12Z3-M04	12,0 *0.472*	14,0 *0.551*	1,2 *0.047*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	21,4	3	✓	■	
MP12-12014R20Z3-E04	12,0 *0.472*	14,0 *0.551*	2,0 *0.079*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	19,8	3	✓		■
MP12-12014R31Z3-E04	12,0 *0.472*	14,0 *0.551*	3,1 *0.122*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	17,6	3	✓		■
MP12-12714R04Z3-E04	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	24,4	3	✓		■
MP12-12714R04Z3-M04	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	24,4	3	✓	■	
MP12-12714R08Z3-E04	12,7 *0.500*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	23,6	3	✓		■
MP12-12714R08Z3-M04	12,7 *0.500*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	23,6	3	✓	■	
MP12-12714R16Z3-E04	12,7 *0.500*	14,0 *0.551*	1,6 *0.063*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	23,9	3	✓		■
MP12-12714R31Z3-E04	12,7 *0.500*	14,0 *0.551*	3,1 *0.122*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	22,0	3	✓		■

MP12 Square shoulder

Slotting and contouring



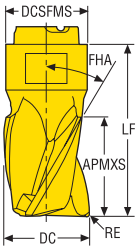
• For insert selection and cutting data recommendations, see page(s) 494-495

Z4

Designation	DC	APMXS	RE	DCSFMS	FHA°	LF	RMPX°	C min	C max	ZEFP	Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					MP3000	F40M
MP12-12008R04Z4-M03	12,0 *0.472*	8,0 *0.315*	0,4 *0.016*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	23,0	4	■	
MP12-12008R05Z4-E03	12,0 *0.472*	8,0 *0.315*	0,5 *0.020*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	22,8	4		■
MP12-12008R08Z4-E03	12,0 *0.472*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	22,2	4		■
MP12-12008R08Z4-M03	12,0 *0.472*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	22,2	4	■	
MP12-12008R12Z4-M03	12,0 *0.472*	8,0 *0.315*	1,2 *0.047*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	21,4	4	■	
MP12-12008R24Z4-E03	12,0 *0.472*	8,0 *0.315*	2,4 *0.094*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	19,0	4		■
MP12-12014R04Z4-M03	12,0 *0.472*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	23,0	4	■	
MP12-12014R05Z4-E03	12,0 *0.472*	14,0 *0.551*	0,5 *0.020*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	22,8	4		■
MP12-12014R08Z4-E03	12,0 *0.472*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	22,2	4		■
MP12-12014R08Z4-M03	12,0 *0.472*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	22,2	4	■	
MP12-12014R12Z4-E03	12,0 *0.472*	14,0 *0.551*	1,2 *0.047*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	21,4	4		■
MP12-12014R12Z4-M03	12,0 *0.472*	14,0 *0.551*	1,2 *0.047*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	21,4	4	■	
MP12-12014R16Z4-E03	12,0 *0.472*	14,0 *0.551*	1,6 *0.063*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	20,6	4		■
MP12-12714R04Z4-E03	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	15,4	24,4	4		■
MP12-12714R04Z4-M03	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	15,4	24,4	4	■	
MP12-12714R08Z4-E03	12,7 *0.500*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	15,4	23,9	4		■
MP12-12714R08Z4-M03	12,7 *0.500*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	15,4	23,6	4	■	

MP12 Square shoulder

Contouring only

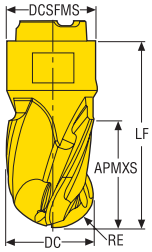


• For insert selection and cutting data recommendations, see page(s) 494-495

Z6

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	ZEFP	Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			MP3000	F40M
MP12-12014R04Z6-M03	12,0 *0.472*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	24,0 *0.945*	40	6	■	
MP12-12714R04Z6-M03	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	24,0 *0.945*	40	6	■	

MP12 Ball nose design



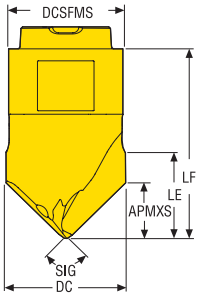
• For insert selection and cutting data recommendations, see page(s) 496-497

Z3

Z4

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	RMPX°	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					MP3000	F40M
MP12-12008B90Z3-E04	12,0 *0.472*	8,0 *0.315*	6,0 *0.236*	11,5 *0.453*	18,8 *0.740*	30	15,0	3	✓		■
MP12-12008B90Z3-M04	12,0 *0.472*	8,0 *0.315*	6,0 *0.236*	11,5 *0.453*	18,8 *0.740*	30	15,0	3	✓	■	
MP12-12014B90Z3-E04	12,0 *0.472*	14,0 *0.551*	6,0 *0.236*	11,5 *0.453*	24,0 *0.945*	30	15,0	3	✓		■
MP12-12014B90Z3-M04	12,0 *0.472*	14,0 *0.551*	6,0 *0.236*	11,5 *0.453*	24,0 *0.945*	30	15,0	3	✓	■	
MP12-12008B90Z4-E03	12,0 *0.472*	8,0 *0.315*	6,0 *0.236*	11,5 *0.453*	18,7 *0.736*	20	15,0	4			■
MP12-12008B90Z4-M03	12,0 *0.472*	8,0 *0.315*	6,0 *0.236*	11,5 *0.453*	18,7 *0.736*	20	15,0	4		■	
MP12-12708B90Z3-E04	12,7 *0.500*	8,0 *0.315*	6,35 *0.250*	11,5 *0.453*	18,8 *0.740*	30	15,0	3	✓		■
MP12-12708B90Z3-M04	12,7 *0.500*	8,0 *0.315*	6,35 *0.250*	11,5 *0.453*	18,8 *0.740*	30	15,0	3	✓	■	
MP12-12714B90Z3-E04	12,7 *0.500*	14,0 *0.551*	6,35 *0.250*	11,5 *0.453*	24,0 *0.945*	30	15,0	3	✓		■
MP12-12714B90Z3-M04	12,7 *0.500*	14,0 *0.551*	6,35 *0.250*	11,5 *0.453*	24,0 *0.945*	30	15,0	3	✓	■	
MP12-12708B90Z4-E03	12,7 *0.500*	8,0 *0.315*	6,35 *0.250*	11,5 *0.453*	18,7 *0.736*	20	15,0	4			■
MP12-12708B90Z4-M03	12,7 *0.500*	8,0 *0.315*	6,35 *0.250*	11,5 *0.453*	18,7 *0.736*	20	15,0	4		■	

MP12 Centre drilling/Chamfering

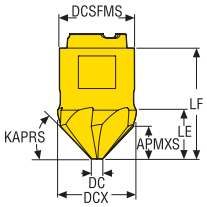


• For insert selection and cutting data recommendations, see page(s) 498-499

Z2

Designation	DC	APMXS	DCSFMS	LE	LF	SIG°	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				MP3000	F40M
MP12-12007C90Z2-M04	12,0 *0.472*	5,6 *0.220*	11,5 *0.453*	8,7 *0.343*	19,0 *0.748*	90,0	2	✓		■

MP12 Chamfering

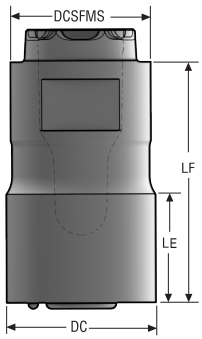


• For insert selection and cutting data recommendations, see page(s) 500-501

Z6

Designation	DCX	DC	APMXS	DCSFMS	LE	LF	KAPRS°	ZEFP		Grades	
										Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				MP3000	F40M
MP12-12007C90Z6-M04	12,1 *0.476*	2,95 *0.116*	4,4 *0.173*	11,5 *0.453*	7,5 *0.295*	18,0 *0.709*	45,0	6			■

MP12 Cylindrical blanks



- Cylindrical carbide blanks for production of own geometries

Designation	DC	DCSFMS	LE	LF	Grades Uncoated
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	H25
MP12-12008CYL-SEMI	12,95 *0.510*	11,5 *0.453*	9,4 *0.370*	19,35 *0.762*	■
MP12-12014CYL-SEMI	12,95 *0.510*	11,5 *0.453*	14,3 *0.563*	24,15 *0.951*	■

MP12 High feed milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P2	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,90 *0.036*
P3	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
P4	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P5	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P6	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P7	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P8	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
P11	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P12	MP12-1200.7HFZ3-MD10 MP3000	0,40 *0.016*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
M1	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,90 *0.036*
M2	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
M3	MP12-1200.7HFZ3-MD10 MP3000	0,40 *0.016*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
M4	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
M5	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
K1	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,90 *0.036*
K2	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K3	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K4	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K5	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K6	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K7	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
N1	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,70 *0.028*	0,70 *0.028*	0,95 *0.038*	1,2 *0.048*
N2	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,70 *0.028*	0,70 *0.028*	0,95 *0.038*	1,2 *0.048*
N3	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,70 *0.028*	0,70 *0.028*	0,95 *0.038*	1,2 *0.048*
N11	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,70 *0.028*	0,70 *0.028*	0,95 *0.038*	1,2 *0.048*
S1	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S2	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S3	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*	0,50 *0.020*
S11	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S12	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S13	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
H5	MP12-1200.7HFZ3-MD10 MP3000	0,40 *0.016*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
H8	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,28 *0.011*	0,26 *0.010*	0,34 *0.013*	0,40 *0.016*
H11	MP12-1200.7HFZ3-MD10 MP3000	0,40 *0.016*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
H12	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,28 *0.011*	0,26 *0.010*	0,34 *0.013*	0,40 *0.016*
H21	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,28 *0.011*	0,26 *0.010*	0,34 *0.013*	0,40 *0.016*

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

MP12 High feed milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000			
	100%	70%	30%	20%
P1	240 *790*	295 *970*	340 *1125*	355 *1175*
P2	235 *770*	285 *940*	325 *1075*	345 *1125*
P3	205 *670*	245 *800*	285 *940*	300 *980*
P4	185 *610*	220 *720*	250 *820*	265 *870*
P5	175 *570*	210 *690*	245 *800*	255 *840*
P6	195 *640*	240 *790*	275 *900*	290 *950*
P7	185 *610*	225 *740*	260 *850*	275 *900*
P8	170 *560*	205 *670*	240 *790*	255 *840*
P11	180 *590*	220 *720*	250 *820*	265 *870*
P12	115 *375*	140 *460*	160 *520*	170 *560*
M1	175 *570*	215 *710*	245 *800*	260 *850*
M2	145 *475*	175 *570*	205 *670*	215 *710*
M3	120 *395*	140 *460*	160 *520*	170 *560*
M4	95 *310*	110 *360*	125 *410*	135 *445*
M5	80 *260*	90 *295*	105 *345*	110 *360*
K1	185 *610*	225 *740*	260 *850*	275 *900*
K2	165 *540*	200 *660*	230 *750*	245 *800*
K3	140 *460*	170 *560*	195 *640*	205 *670*
K4	135 *445*	160 *520*	190 *620*	195 *640*
K5	80 *260*	100 *330*	115 *375*	120 *395*
K6	120 *395*	145 *475*	165 *540*	175 *570*
K7	105 *345*	125 *410*	145 *475*	150 *490*
N1	1400 *4600*	1700 *5575*	1925 *6325*	2025 *6650*
N2	560 *1825*	680 *2225*	780 *2550*	820 *2700*
N3	375 *1225*	455 *1500*	520 *1700*	540 *1775*
N11	430 *1400*	520 *1700*	600 *1975*	620 *2025*
S1	44 *145*	50 *165*	60 *195*	60 *195*
S2	35 *115*	41 *135*	47 *155*	50 *165*
S3	31 *100*	36 *120*	42 *140*	44 *145*
S11	60 *195*	70 *230*	80 *260*	85 *280*
S12	42 *140*	49 *160*	55 *180*	60 *195*
S13	25 *80*	29 *95*	33 *110*	35 *115*
H5	36 *120*	44 *145*	50 *165*	55 *180*
H8	39 *130*	46 *150*	55 *180*	55 *180*
H11	46 *150*	55 *180*	65 *215*	65 *215*
H12	75 *245*	90 *295*	100 *330*	110 *360*
H21	39 *130*	46 *150*	55 *180*	55 *180*

MP12 Slot and Side milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	30%	10%	5%
P1	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*	0,13 *0.0050*
P2	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*
P3	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
P4	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,12 *0.0048*
P5	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
P6	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
P7	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
P8	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
P11	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
P12	MP12-12008R08Z3-M04 MP3000	3,0 *0.12*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
M1	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*
M2	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
M3	MP12-12008R04Z3-E04 F40M	3,0 *0.12*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*
M4	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
M5	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
K1	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*
K2	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
K3	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
K4	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
K5	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,048 *0.0019*	0,050 *0.0020*	0,080 *0.0032*	0,11 *0.0044*
K6	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
K7	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,048 *0.0019*	0,050 *0.0020*	0,080 *0.0032*	0,11 *0.0044*
N1	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
N2	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
N3	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
N11	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
S1	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
S2	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
S3	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*	0,080 *0.0032*
S11	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*
S12	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*
S13	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
H5	MP12-12008R04Z3-M04 MP3000	3,0 *0.12*	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*	0,080 *0.0032*
H8	MP12-12008R04Z3-M04 MP3000	2,5 *0.10*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
H11	MP12-12008R04Z3-M04 MP3000	3,0 *0.12*	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*	0,080 *0.0032*
H12	MP12-12008R04Z3-M04 MP3000	2,5 *0.10*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
H21	MP12-12008R04Z3-M04 MP3000	2,5 *0.10*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*

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

MP12 Slot and Side milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000				F40M			
	100%	30%	10%	5%	100%	30%	10%	5%
P1	250 *820*	325 *1075*	380 *1250*	415 *1350*	235 *770*	310 *1025*	360 *1175*	390 *1275*
P2	240 *790*	315 *1025*	370 *1225*	405 *1325*	225 *740*	295 *970*	350 *1150*	380 *1250*
P3	210 *690*	275 *900*	320 *1050*	345 *1125*	200 *660*	260 *850*	305 *1000*	325 *1075*
P4	185 *610*	240 *790*	285 *940*	310 *1025*	175 *570*	230 *750*	270 *890*	295 *970*
P5	180 *590*	235 *770*	275 *900*	295 *970*	170 *560*	220 *720*	260 *850*	280 *920*
P6	200 *660*	265 *870*	310 *1025*	330 *1075*	190 *620*	250 *820*	290 *950*	315 *1025*
P7	190 *620*	250 *820*	290 *950*	315 *1025*	180 *590*	235 *770*	275 *900*	295 *970*
P8	175 *570*	230 *750*	270 *890*	290 *950*	165 *540*	215 *710*	255 *840*	275 *900*
P11	185 *610*	240 *790*	280 *920*	305 *1000*	175 *570*	230 *750*	265 *870*	290 *950*
P12	115 *375*	150 *490*	175 *570*	195 *640*	110 *360*	145 *475*	165 *540*	180 *590*
M1	180 *590*	235 *770*	275 *900*	300 *980*	180 *590*	240 *790*	280 *920*	305 *1000*
M2	150 *490*	195 *640*	230 *750*	245 *800*	150 *490*	200 *660*	235 *770*	250 *820*
M3	120 *395*	155 *510*	180 *590*	195 *640*	120 *395*	155 *510*	185 *610*	200 *660*
M4	90 *295*	120 *395*	140 *460*	150 *490*	95 *310*	120 *395*	140 *460*	155 *510*
M5	75 *245*	100 *330*	115 *375*	125 *410*	75 *245*	100 *330*	120 *395*	125 *410*
K1	190 *620*	250 *820*	295 *970*	320 *1050*	180 *590*	235 *770*	275 *900*	300 *980*
K2	170 *560*	220 *720*	260 *850*	280 *920*	160 *520*	210 *690*	245 *800*	265 *870*
K3	145 *475*	190 *620*	220 *720*	240 *790*	135 *445*	180 *590*	210 *690*	225 *740*
K4	140 *460*	180 *590*	210 *690*	225 *740*	130 *425*	170 *560*	200 *660*	215 *710*
K5	85 *280*	110 *360*	125 *410*	135 *445*	80 *260*	105 *345*	120 *395*	130 *425*
K6	120 *395*	160 *520*	185 *610*	200 *660*	115 *375*	150 *490*	175 *570*	190 *620*
K7	105 *345*	140 *460*	160 *520*	175 *570*	100 *330*	130 *425*	155 *510*	165 *540*
N1	1425 *4675*	1875 *6150*	2200 *7225*	2375 *7800*	1350 *4425*	1775 *5825*	2100 *6900*	2250 *7375*
N2	570 *1875*	760 *2500*	890 *2925*	960 *3150*	540 *1775*	720 *2350*	840 *2750*	910 *2975*
N3	385 *1275*	500 *1650*	600 *1975*	640 *2100*	360 *1175*	475 *1550*	560 *1825*	610 *2000*
N11	440 *1450*	580 *1900*	680 *2225*	730 *2400*	415 *1350*	540 *1775*	640 *2100*	690 *2275*
S1	43 *140*	55 *180*	65 *215*	70 *230*	43 *140*	55 *180*	65 *215*	70 *230*
S2	34 *110*	45 *150*	50 *165*	55 *180*	35 *115*	46 *150*	55 *180*	55 *180*
S3	30 *100*	39 *130*	46 *150*	49 *160*	31 *100*	40 *130*	46 *150*	50 *165*
S11	60 *195*	80 *260*	90 *295*	100 *330*	60 *195*	80 *260*	95 *310*	100 *330*
S12	42 *140*	55 *180*	65 *215*	70 *230*	42 *140*	55 *180*	65 *215*	70 *230*
S13	24 *80*	31 *100*	36 *120*	39 *130*	24 *80*	32 *105*	37 *120*	40 *130*
H5	36 *120*	47 *155*	55 *180*	60 *195*	36 *120*	48 *155*	55 *180*	60 *195*
H8	38 *125*	49 *160*	55 *180*	60 *195*	38 *125*	50 *165*	60 *195*	60 *195*
H11	46 *150*	60 *195*	70 *230*	75 *245*	46 *150*	60 *195*	70 *230*	75 *245*
H12	70 *230*	95 *310*	110 *360*	120 *395*	70 *230*	90 *295*	105 *345*	110 *360*
H21	38 *125*	49 *160*	55 *180*	60 *195*	38 *125*	50 *165*	60 *195*	60 *195*

MP12 Copy milling – Insert selection – mm/*Inch*

SMG		a_p	f_z				
			100%	30%	10%	5%	2%
P1	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,10 *0.0040*	0,14 *0.0055*	0,22 *0.0085*
P2	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,22 *0.0085*
P3	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P4	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P5	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P6	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P7	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P8	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P11	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P12	MP12-12008B90Z3-M04 MP3000	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
M1	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,22 *0.0085*
M2	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
M3	MP12-12008B90Z3-E04 F40M	3,0 *0.12*	0,050 *0.0020*	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
M4	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
M5	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
K1	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,22 *0.0085*
K2	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
K3	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
K4	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
K5	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*	0,11 *0.0044*	0,18 *0.0070*
K6	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
K7	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*	0,11 *0.0044*	0,18 *0.0070*
N1	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
N2	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
N3	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
N11	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
S1	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
S2	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
S3	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,042 *0.0017*	0,044 *0.0017*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
S11	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
S12	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
S13	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
H5	MP12-12008B90Z3-M04 MP3000	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
H8	MP12-12008B90Z3-M04 MP3000	2,5 *0.10*	0,034 *0.0013*	0,034 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H11	MP12-12008B90Z3-M04 MP3000	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
H12	MP12-12008B90Z3-M04 MP3000	2,5 *0.10*	0,034 *0.0013*	0,034 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H21	MP12-12008B90Z3-M04 MP3000	2,5 *0.10*	0,034 *0.0013*	0,034 *0.0013*	0,048 *0.0019*	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

MP12 Copy milling – Cutting data v_c = (m/min)/(sf/min)

SMG	MP3000					F40M				
	100%	30%	10%	5%	2%	100%	30%	10%	5%	2%
P1	265 870	320 1050	345 1125	375 1225	370 1225	250 820	300 980	325 1075	355 1175	350 1150
P2	255 840	310 1025	330 1075	360 1175	360 1175	240 790	295 970	315 1025	340 1125	340 1125
P3	220 720	265 870	290 950	315 1025	315 1025	210 690	255 840	270 890	295 970	295 970
P4	195 640	240 790	255 840	275 900	275 900	185 610	225 740	240 790	260 850	260 850
P5	190 620	230 750	245 800	265 870	265 870	175 570	215 710	230 750	250 820	250 820
P6	210 690	255 840	275 900	300 980	295 970	200 660	240 790	260 850	285 940	280 920
P7	200 660	240 790	260 850	285 940	280 920	190 620	230 750	245 800	265 870	265 870
P8	185 610	225 740	240 790	265 870	265 870	175 570	210 690	230 750	250 820	250 820
P11	195 640	235 770	250 820	275 900	270 890	185 610	220 720	240 790	260 850	255 840
P12	120 395	150 490	160 520	170 560	170 560	115 375	140 460	150 490	160 520	160 520
M1	190 620	230 750	250 820	270 890	270 890	190 620	235 770	255 840	275 900	275 900
M2	155 510	190 620	205 670	225 740	220 720	160 520	195 640	210 690	225 740	225 740
M3	125 410	155 510	160 520	175 570	175 570	130 425	155 510	165 540	180 590	175 570
M4	100 330	120 395	125 410	135 445	135 445	100 330	120 395	125 410	135 445	135 445
M5	85 280	100 330	105 345	110 360	110 360	85 280	100 330	105 345	115 375	115 375
K1	200 660	245 800	265 870	285 940	285 940	190 620	235 770	250 820	270 890	270 890
K2	180 590	215 710	230 750	255 840	250 820	170 560	205 670	220 720	240 790	235 770
K3	150 490	185 610	195 640	215 710	210 690	140 460	175 570	185 610	200 660	200 660
K4	145 475	175 570	185 610	205 670	205 670	135 445	165 540	175 570	195 640	190 620
K5	85 280	105 345	115 375	125 410	125 410	80 260	100 330	105 345	115 375	115 375
K6	125 410	155 510	165 540	180 590	180 590	120 395	145 475	155 510	170 560	170 560
K7	110 360	135 445	145 475	160 520	155 510	105 345	130 425	135 445	150 490	150 490
N1	1525 5000	1850 6075	1975 6475	2150 7050	2150 7050	1450 4750	1750 5750	1875 6150	2025 6650	2025 6650
N2	620 2025	750 2450	800 2625	870 2850	870 2850	580 1900	710 2325	760 2500	820 2700	820 2700
N3	410 1350	500 1650	530 1750	580 1900	580 1900	390 1275	470 1550	500 1650	550 1800	550 1800
N11	470 1550	570 1875	610 2000	660 2175	660 2175	445 1450	540 1775	580 1900	620 2025	630 2075
S1	46 150	55 180	60 195	65 215	60 195	47 155	55 180	60 195	65 215	65 215
S2	37 120	45 150	47 155	50 165	50 165	38 125	45 150	47 155	50 165	50 165
S3	32 105	39 130	40 130	44 145	44 145	33 110	40 130	41 135	45 150	44 145
S11	65 215	80 260	80 260	90 295	90 295	65 215	80 260	85 280	90 295	90 295
S12	44 145	55 180	55 180	60 195	60 195	45 150	55 180	60 195	60 195	60 195
S13	26 85	31 100	33 110	35 115	35 115	27 90	32 105	33 110	36 120	36 120
H5	38 125	47 155	49 160	55 180	55 180	38 125	47 155	49 160	55 180	55 180
H8	40 130	48 155	50 165	55 180	55 180	40 130	49 160	50 165	55 180	55 180
H11	48 155	60 195	60 195	65 215	70 230	49 160	60 195	65 215	70 230	70 230
H12	75 245	95 310	95 310	105 345	105 345	70 230	85 280	90 295	100 330	100 330
H21	40 130	48 155	50 165	55 180	55 180	40 130	49 160	50 165	55 180	55 180

MP12 Centre drilling – Insert selection – mm/*Inch*

SMG		f_z	a_{so}
			100%
P1	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P2	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P3	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P4	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P5	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
P6	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
P7	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
P8	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P11	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
P12	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,5 *0.10*
M1	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
M2	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
M3	MP12-12007C90Z2-M04 F40M	0,042 *0.0017*	2,5 *0.10*
M4	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
M5	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
K1	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
K2	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
K3	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
K4	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
K5	MP12-12007C90Z2-M04 F40M	0,046 *0.0018*	3,5 *0.14*
K6	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
K7	MP12-12007C90Z2-M04 F40M	0,046 *0.0018*	3,5 *0.14*
N1	MP12-12007C90Z2-M04 F40M	0,075 *0.0030*	3,5 *0.14*
N2	MP12-12007C90Z2-M04 F40M	0,075 *0.0030*	3,5 *0.14*
N3	MP12-12007C90Z2-M04 F40M	0,075 *0.0030*	3,5 *0.14*
N11	MP12-12007C90Z2-M04 F40M	0,075 *0.0030*	3,5 *0.14*
S1	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
S2	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
S3	MP12-12007C90Z2-M04 F40M	0,034 *0.0013*	2,0 *0.080*
S11	MP12-12007C90Z2-M04 F40M	0,042 *0.0017*	2,5 *0.10*
S12	MP12-12007C90Z2-M04 F40M	0,042 *0.0017*	2,5 *0.10*
S13	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
H5	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,5 *0.10*
H8	MP12-12007C90Z2-M04 F40M	0,028 *0.0011*	2,5 *0.10*
H11	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,5 *0.10*
H12	MP12-12007C90Z2-M04 F40M	0,028 *0.0011*	2,5 *0.10*
H21	MP12-12007C90Z2-M04 F40M	0,028 *0.0011*	2,5 *0.10*

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

MP12 Centre drilling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M
	100%
P1	275 *900*
P2	265 *870*
P3	235 *770*
P4	205 *670*
P5	195 *640*
P6	220 *720*
P7	205 *670*
P8	195 *640*
P11	200 *660*
P12	125 *410*
M1	215 *710*
M2	175 *570*
M3	140 *460*
M4	105 *345*
M5	85 *280*
K1	210 *690*
K2	185 *610*
K3	155 *510*
K4	150 *490*
K5	90 *295*
K6	130 *425*
K7	120 *395*
N1	1575 *5175*
N2	640 *2100*
N3	425 *1400*
N11	490 *1600*
S1	49 *160*
S2	39 *130*
S3	34 *110*
S11	70 *230*
S12	48 *155*
S13	27 *90*
H5	42 *140*
H8	43 *140*
H11	55 *180*
H12	80 *260*
H21	43 *140*

MP12 Chamfering – Insert selection – mm/*Inch*

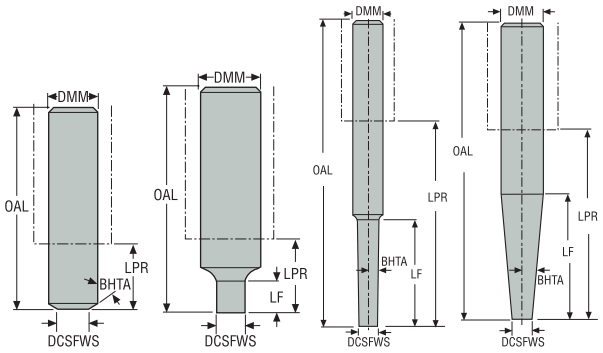
SMG		a_p	f_z				
			100%	50%	30%	20%	10%
P1	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
P2	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
P3	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
P4	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
P5	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
P6	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
P7	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
P8	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
P11	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
P12	MP12-12007C90Z2-M04 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
M1	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
M2	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
M3	MP12-12007C90Z2-M04 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
M4	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
M5	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
K1	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
K2	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
K3	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
K4	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
K5	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
K6	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
K7	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
N1	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
N2	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
N3	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
N11	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
S1	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
S2	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
S3	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0024*
S11	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
S12	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
S13	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
H5	MP12-12007C90Z2-M04 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
H8	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
H11	MP12-12007C90Z2-M04 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
H12	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
H21	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*

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

MP12 Chamfering – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M				
	100%	50%	30%	20%	10%
P1	300 *980*	275 *900*	330 *1075*	365 *1200*	430 *1400*
P2	290 *950*	270 *890*	320 *1050*	355 *1175*	415 *1350*
P3	255 *840*	235 *770*	280 *920*	310 *1025*	360 *1175*
P4	225 *740*	210 *690*	250 *820*	275 *900*	320 *1050*
P5	215 *710*	200 *660*	235 *770*	260 *850*	310 *1025*
P6	240 *790*	225 *740*	265 *870*	295 *970*	345 *1125*
P7	225 *740*	210 *690*	250 *820*	275 *900*	325 *1075*
P8	215 *710*	200 *660*	235 *770*	260 *850*	305 *1000*
P11	220 *720*	205 *670*	245 *800*	270 *890*	320 *1050*
P12	140 *460*	125 *410*	150 *490*	165 *540*	205 *670*
M1	235 *770*	220 *720*	260 *850*	285 *940*	335 *1100*
M2	190 *620*	180 *590*	215 *710*	235 *770*	280 *920*
M3	150 *490*	135 *445*	165 *540*	180 *590*	220 *720*
M4	115 *375*	100 *330*	115 *375*	130 *425*	170 *560*
M5	95 *310*	85 *280*	95 *310*	110 *360*	140 *460*
K1	230 *750*	215 *710*	255 *840*	280 *920*	330 *1075*
K2	200 *660*	190 *620*	225 *740*	250 *820*	295 *970*
K3	170 *560*	160 *520*	190 *620*	210 *690*	250 *820*
K4	165 *540*	150 *490*	180 *590*	200 *660*	235 *770*
K5	100 *330*	95 *310*	110 *360*	125 *410*	145 *475*
K6	145 *475*	135 *445*	160 *520*	175 *570*	210 *690*
K7	130 *425*	120 *395*	145 *475*	160 *520*	185 *610*
N1	1725 *5650*	1600 *5250*	1900 *6225*	2100 *6900*	2450 *8050*
N2	690 *2275*	640 *2100*	770 *2525*	850 *2800*	990 *3250*
N3	460 *1500*	430 *1400*	510 *1675*	570 *1875*	660 *2175*
N11	530 *1750*	490 *1600*	590 *1925*	650 *2125*	750 *2450*
S1	55 *180*	47 *155*	55 *180*	60 *195*	80 *260*
S2	44 *145*	38 *125*	44 *145*	50 *165*	65 *215*
S3	38 *125*	33 *110*	38 *125*	43 *140*	55 *180*
S11	75 *245*	70 *230*	80 *260*	85 *280*	110 *360*
S12	55 *180*	47 *155*	55 *180*	60 *195*	75 *245*
S13	30 *100*	27 *90*	30 *100*	35 *115*	45 *150*
H5	46 *150*	42 *140*	50 *165*	55 *180*	70 *230*
H8	49 *160*	44 *145*	50 *165*	55 *180*	70 *230*
H11	60 *195*	55 *180*	65 *215*	70 *230*	85 *280*
H12	85 *280*	80 *260*	90 *295*	100 *330*	125 *410*
H21	49 *160*	44 *145*	50 *165*	55 *180*	70 *230*

MP16 Shank – Metric

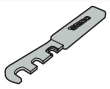
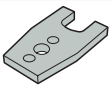


Design 1 **Design 2** **Design 3** **Design 4**

- Cylindrical shank DMM with tolerance h5, compatible for Shrinkfit

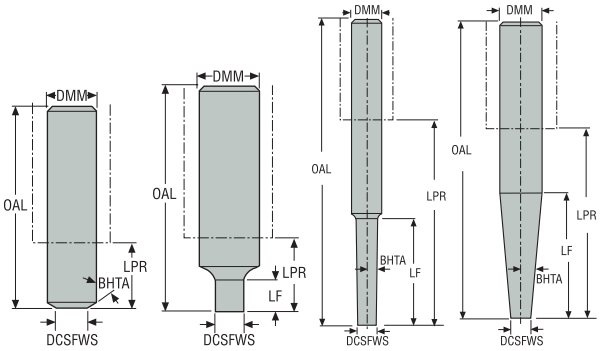
Designation	ShankType	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Design		Weight
		mm	mm	mm	mm	mm					kg
MP16-16068-016.00	Cylindrical	15,2	16,0	68,0	20,0	16,0	63600	0,0	2	✓	0,1
MP16-20070-000.60	Cylindrical	15,2	20,0	70,0	20,0	0,0	63600	60,0	1	✓	0,2
MP16-20090-024.00	Cylindrical	15,2	20,0	90,0	40,0	24,0	63600	0,0	2	✓	0,2
MP16-20190-056.01	Cylindrical	15,2	20,0	190,0	140,0	56,0	63600	1,0	3	✓	0,4
MP16-20195-095.01	Cylindrical	15,2	20,0	195,0	145,0	95,0	63600	1,0	3	✓	0,4
MP16-25136-075.03	Cylindrical	15,2	25,0	136,0	80,0	75,0	63600	3,0	3	✓	0,4
MP16-25181-125.03	Cylindrical	15,2	25,0	181,0	125,0	93,5	63600	3,0	4	✓	0,6
MP16-25181-125.05	Cylindrical	15,2	25,0	181,0	125,0	56,0	63600	5,0	4	✓	0,6
MP16-16126-048.00-E	Cylindrical Carbide	15,2	16,0	126,0	78,0	48,0	63600	0,0	2	✓	0,4
MP16-16140-064.00-E	Cylindrical Carbide	15,2	16,0	140,0	92,0	64,0	63600	0,0	2	✓	0,4
MP16-16180-096.00-E	Cylindrical Carbide	15,2	16,0	180,0	132,0	96,0	63600	0,0	2	✓	0,5
MP16-20135-080.01-E	Cylindrical Carbide	15,2	20,0	135,0	85,0	80,0	63600	1,0	3	✓	0,5
MP16-20180-128.01-E	Cylindrical Carbide	15,2	20,0	180,0	130,0	128,0	63600	1,0	3	✓	0,7
MP16-20200-150.01-E	Cylindrical Carbide	15,2	20,0	200,0	150,0	137,5	63600	1,0	4	✓	0,8
MP16-20180-130.03-E	Cylindrical Carbide	15,2	20,0	180,0	130,0	45,8	63600	3,0	4	✓	0,8
MP16-20210-160.03-E	Cylindrical Carbide	15,2	20,0	210,0	160,0	45,8	63600	3,0	4	✓	0,9

Accessories

Key	Replacement blade	Torque key
		
MP1016	MP00-16M	MP00-16.190

Blades are included with the torque key

MP16 Shank – *Inch*

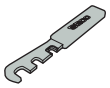
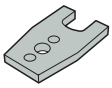


Design 1 Design 2 Design 3 Design 4

- Cylindrical shank DMM with tolerance h5, compatible for Shrinkfit

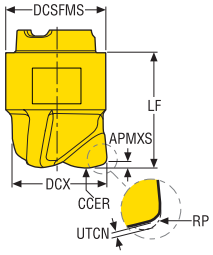
Designation	ShankType	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Design		Weight
		Inch	Inch	Inch	Inch	Inch					lbs
MP16-0622.6-0.63.00	Cylindrical	0.598	0.625	2.662	0.787	0.630	63600	0,0	2	✓	0.220
MP16-0752.7-0.00.60	Cylindrical	0.598	0.750	2.787	0.787	–	63600	60,0	1	✓	1.540
MP16-0753.5-0.94.00	Cylindrical	0.598	0.750	3.575	1.575	0.945	63600	0,0	2	✓	0.440
MP16-0757.5-2.20.01	Cylindrical	0.598	0.750	7.512	5.512	2.205	63600	1,0	3	✓	0.880
MP16-0757.7-3.74.01	Cylindrical	0.598	0.750	7.709	5.709	3.740	63600	1,0	3	✓	0.880
MP16-1007.1-4.92.05	Cylindrical	0.598	1.000	7.171	4.921	2.295	63600	5,0	4	✓	0.440
MP16-0627.0-3.77.00-E	Cylindrical Carbide	0.598	0.625	7.072	5.197	3.780	63600	0,0	2	✓	1.100
MP16-0757.9-5.90.01-E	Cylindrical Carbide	0.598	0.750	7.906	5.906	4.342	63600	1,0	4	✓	1.540
MP16-0758.2-6.29.03-E	Cylindrical Carbide	0.598	0.750	8.299	6.299	1.446	63600	3,0	4	✓	1.760

Accessories

Key	Replacement blade	Torque key
		
MP1016	MP00-16M	MP00-16.190

Blades are included with the torque key

MP16 High feed



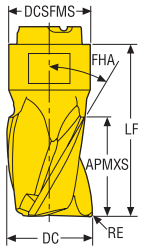
• For insert selection and cutting data recommendations, see page(s) 512-513

Z3

Designation	DCX	DC	APMXS	DCSFMS	CCER	RP	LF	UTCN	RMPX°	C min	C max	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*						MP3000	F40M
MP16-1600.9HFZ3-MD12	16,0 *0.630*	8,0 *0.315*	0,9 *0.035*	15,4 *0.606*	7,8 *0.307*	1,79 *0.070*	18,5 *0.728*	0,46 *0.018*	5,0	17,3	23,8	3	✓	■	
MP16-1580.9HFZ3-MD12	15,875 *0.625*	7,88 *0.310*	0,9 *0.035*	15,4 *0.606*	7,8 *0.307*	1,79 *0.070*	18,5 *0.728*	0,46 *0.018*	5,0	17,2	23,5	3	✓	■	

MP16 Square shoulder

Slotting and contouring



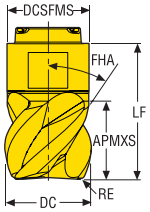
• For insert selection and cutting data recommendations, see page(s) 514-515

Z3

Designation	DC	APMXS	RE	DCSFMS	FHA°	LF	RMPX°	C min	C max	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*						MP3000	F40M
MP16-16010R04Z3-M05	16,0 *0.630*	10,0 *0.394*	0,4 *0.016*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	31,0	3	✓	■	
MP16-16010R05Z3-E05	16,0 *0.630*	10,0 *0.394*	0,5 *0.020*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	30,8	3	✓		■
MP16-16010R08Z3-E05	16,0 *0.630*	10,0 *0.394*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	30,0	3	✓		■
MP16-16010R08Z3-M05	16,0 *0.630*	10,0 *0.394*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	30,0	3	✓	■	
MP16-16010R12Z3-E05	16,0 *0.630*	10,0 *0.394*	1,2 *0.047*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	29,4	3	✓		■
MP16-16010R20Z3-E05	16,0 *0.630*	10,0 *0.394*	2,0 *0.079*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	27,8	3	✓		■
MP16-16010R31Z3-E05	16,0 *0.630*	10,0 *0.394*	3,1 *0.122*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	25,6	3	✓		■
MP16-15719KWZ3-E05	15,7 *0.618*	19,0 *0.748*	0,3 *0.012*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,0	29,6	3	✓		■
MP16-16019R04Z3-M05	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	31,0	3	✓	■	
MP16-16019R05Z3-E05	16,0 *0.630*	19,0 *0.748*	0,5 *0.020*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	30,8	3	✓		■
MP16-16019R08Z3-E05	16,0 *0.630*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	30,2	3	✓		■
MP16-16019R08Z3-M05	16,0 *0.630*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	30,2	3	✓	■	
MP16-16019R20Z3-E05	16,0 *0.630*	19,0 *0.748*	2,0 *0.079*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	27,8	3	✓		■
MP16-16019R31Z3-E05	16,0 *0.630*	19,0 *0.748*	3,1 *0.122*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	25,6	3	✓		■
MP16-15919R04Z3-E05	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	30,7	3	✓		■
MP16-15919R04Z3-M05	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	30,7	3	✓	■	
MP16-15919R08Z3-E05	15,875 *0.625*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	29,9	3	✓		■
MP16-15919R08Z3-M05	15,875 *0.625*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	29,9	3	✓	■	
MP16-15919R31Z3-E05	15,875 *0.625*	19,0 *0.748*	3,1 *0.122*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	25,3	3	✓		■

MP16 Square shoulder

Slotting and contouring



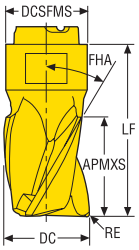
• For insert selection and cutting data recommendations, see page(s) 514-515

Z4

Designation	DC	APMXS	RE	DCSFMS	FHA°	LF	RMPX°	C min	C max	ZEFP	Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					MP3000	F40M
MP16-16010R04Z4-M04	16,0 *0.630*	10,0 *0.394*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	31,0	4	■	
MP16-16010R05Z4-E04	16,0 *0.630*	10,0 *0.394*	0,5 *0.020*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	30,8	4		■
MP16-16010R08Z4-E04	16,0 *0.630*	10,0 *0.394*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	30,2	4		■
MP16-16010R08Z4-M04	16,0 *0.630*	10,0 *0.394*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	30,2	4	■	
MP16-16010R16Z4-M04	16,0 *0.630*	10,0 *0.394*	1,6 *0.063*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	28,6	4	■	
MP16-16010R31Z4-E04	16,0 *0.630*	10,0 *0.394*	3,1 *0.122*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	25,6	4		■
MP16-16019R04Z4-E04	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	31,0	4		■
MP16-16019R04Z4-M04	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	31,0	4	■	
MP16-16019R05Z4-E04	16,0 *0.630*	19,0 *0.748*	0,5 *0.020*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	30,8	4		■
MP16-16019R08Z4-E04	16,0 *0.630*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	30,2	4		■
MP16-16019R08Z4-M04	16,0 *0.630*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	30,2	4	■	
MP16-16019R16Z4-E04	16,0 *0.630*	19,0 *0.748*	1,6 *0.063*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	28,6	4		■
MP16-16019R20Z4-E04	16,0 *0.630*	19,0 *0.748*	2,0 *0.079*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	27,8	4		■
MP16-15919R04Z4-E04	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,3	30,7	4		■
MP16-15919R04Z4-M04	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,3	30,7	4	■	
MP16-15919R08Z4-E04	15,875 *0.625*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,3	29,9	4		■
MP16-15919R08Z4-M04	15,875 *0.625*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,3	29,9	4	■	

MP16 Square shoulder

Contouring only

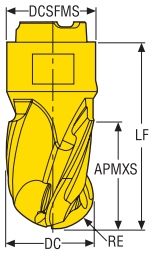


• For insert selection and cutting data recommendations, see page(s) 514-515

Z6/Z8

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				MP3000	F40M
MP16-16019R04Z6-M04	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	32,6 *1.283*	40	6	✓	■	
MP16-16019R04Z8-M04	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	32,6 *1.283*	40	8	✓	■	
MP16-15919R04Z6-M04	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	32,6 *1.283*	40	6	✓	■	

MP16 Ball nose design



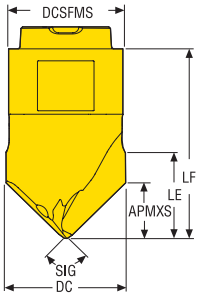
• For insert selection and cutting data recommendations, see page(s) 516-517

Z3

Z4

Designation	DC	APMXS	RE	DCSFMS	LF	FHA°	RMPX°	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					MP3000	F40M
MP16-16010B90Z3-E05	16,0 *0.630*	10,0 *0.394*	8,0 *0.315*	15,4 *0.606*	24,6 *0.969*	30	15,0	3	✓		■
MP16-16010B90Z3-M05	16,0 *0.630*	10,0 *0.394*	8,0 *0.315*	15,4 *0.606*	24,6 *0.969*	30	15,0	3	✓	■	
MP16-16019B90Z3-E05	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	15,4 *0.606*	32,6 *1.283*	30	15,0	3	✓		■
MP16-16019B90Z3-M05	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	15,4 *0.606*	32,6 *1.283*	30	15,0	3	✓	■	
MP16-16010B90Z4-E04	16,0 *0.630*	10,0 *0.394*	8,0 *0.315*	15,4 *0.606*	24,6 *0.969*	20	15,0	4			■
MP16-16010B90Z4-M04	16,0 *0.630*	10,0 *0.394*	8,0 *0.315*	15,4 *0.606*	24,6 *0.969*	20	15,0	4		■	
MP16-15910B90Z3-E05	15,875 *0.625*	10,0 *0.394*	7,9375 *0.313*	15,4 *0.606*	24,6 *0.969*	30	15,0	3	✓		■
MP16-15910B90Z3-M05	15,875 *0.625*	10,0 *0.394*	7,9375 *0.313*	15,4 *0.606*	24,6 *0.969*	30	15,0	3	✓	■	
MP16-15919B90Z3-E05	15,875 *0.625*	19,0 *0.748*	7,9375 *0.313*	15,4 *0.606*	32,6 *1.283*	30	15,0	3	✓		■
MP16-15919B90Z3-M05	15,875 *0.625*	19,0 *0.748*	7,9375 *0.313*	15,4 *0.606*	32,6 *1.283*	30	15,0	3	✓	■	
MP16-15910B90Z4-E04	15,875 *0.625*	10,0 *0.394*	7,9375 *0.313*	15,4 *0.606*	24,6 *0.969*	20	15,0	4			■
MP16-15910B90Z4-M04	15,875 *0.625*	10,0 *0.394*	7,9375 *0.313*	15,4 *0.606*	24,6 *0.969*	20	15,0	4		■	

MP16 Centre drilling/Chamfering

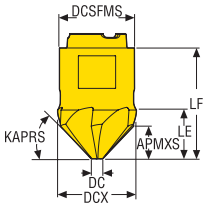


• For insert selection and cutting data recommendations, see page(s) 518-519

Z2

Designation	DC	APMXS	DCSFMS	LE	LF	SIG°	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				MP3000	F40M
MP16-16009C90Z2-M05	16,0 *0.630*	7,4 *0.291*	15,4 *0.606*	12,0 *0.472*	26,4 *1.039*	90,0	2	✓		■

MP16 Chamfering

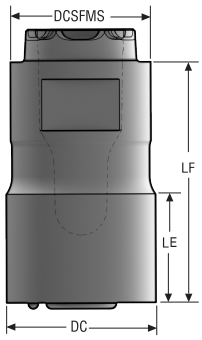


• For insert selection and cutting data recommendations, see page(s) 520-521

Z6

Designation	DCX	DC	APMXS	DCSFMS	LE	LF	KAPRS°	ZEFP		Grades Coated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				MP3000	F40M
MP16-16009C90Z6-M05	16,4 *0.646*	3,95 *0.156*	6,0 *0.236*	15,4 *0.606*	10,4 *0.409*	23,5 *0.925*	45,0	6			■

MP16 Cylindrical blanks



- Cylindrical carbide blanks for production of own geometries

Designation	DC	DCSFMS	LE	LF		Grades
						Uncoated
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		H25
MP16-16010CYL-SEMI	16,4 *0.646*	15,4 *0.606*	11,4 *0.449*	24,8 *0.976*		■
MP16-16019CYL-SEMI	16,4 *0.646*	15,4 *0.606*	19,5 *0.768*	32,85 *1.293*	✓	■

MP16 High feed milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,65 *0.026*	0,85 *0.034*	1,0 *0.040*
P2	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,0 *0.040*
P3	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
P4	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	0,95 *0.038*
P5	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P6	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P7	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P8	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
P11	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P12	MP16-1600.9HFZ3-MD12 MP3000	0,50 *0.020*	0,44 *0.017*	0,40 *0.016*	0,50 *0.020*	0,60 *0.024*
M1	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,0 *0.040*
M2	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
M3	MP16-1600.9HFZ3-MD12 MP3000	0,50 *0.020*	0,55 *0.022*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
M4	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
M5	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
K1	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,0 *0.040*
K2	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K3	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K4	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K5	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
K6	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K7	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
N1	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*	1,4 *0.055*
N2	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*	1,4 *0.055*
N3	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*	1,4 *0.055*
N11	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*	1,4 *0.055*
S1	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
S2	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
S3	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,44 *0.017*	0,38 *0.015*	0,50 *0.020*	0,60 *0.024*
S11	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,55 *0.022*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
S12	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,55 *0.022*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
S13	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
H5	MP16-1600.9HFZ3-MD12 MP3000	0,50 *0.020*	0,44 *0.017*	0,40 *0.016*	0,50 *0.020*	0,60 *0.024*
H8	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,34 *0.013*	0,30 *0.012*	0,40 *0.016*	0,46 *0.018*
H11	MP16-1600.9HFZ3-MD12 MP3000	0,50 *0.020*	0,44 *0.017*	0,40 *0.016*	0,50 *0.020*	0,60 *0.024*
H12	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,34 *0.013*	0,30 *0.012*	0,40 *0.016*	0,46 *0.018*
H21	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,34 *0.013*	0,30 *0.012*	0,40 *0.016*	0,46 *0.018*

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

MP16 High feed milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000			
	100%	70%	30%	20%
P1	225 *740*	270 *890*	315 *1025*	335 *1100*
P2	215 *710*	265 *870*	305 *1000*	325 *1075*
P3	190 *620*	230 *750*	265 *870*	280 *920*
P4	165 *540*	205 *670*	235 *770*	250 *820*
P5	160 *520*	195 *640*	230 *750*	240 *790*
P6	180 *590*	220 *720*	255 *840*	265 *870*
P7	170 *560*	205 *670*	240 *790*	250 *820*
P8	160 *520*	195 *640*	225 *740*	235 *770*
P11	165 *540*	200 *660*	235 *770*	245 *800*
P12	105 *345*	130 *425*	150 *490*	160 *520*
M1	160 *520*	195 *640*	230 *750*	245 *800*
M2	130 *425*	165 *540*	190 *620*	200 *660*
M3	105 *345*	135 *445*	155 *510*	160 *520*
M4	85 *280*	105 *345*	115 *375*	125 *410*
M5	70 *230*	85 *280*	100 *330*	105 *345*
K1	170 *560*	210 *690*	240 *790*	255 *840*
K2	150 *490*	185 *610*	215 *710*	225 *740*
K3	125 *410*	155 *510*	185 *610*	190 *620*
K4	120 *395*	150 *490*	175 *570*	180 *590*
K5	75 *245*	95 *310*	105 *345*	110 *360*
K6	105 *345*	130 *425*	155 *510*	160 *520*
K7	95 *310*	120 *395*	135 *445*	145 *475*
N1	1275 *4175*	1550 *5075*	1775 *5825*	1850 *6075*
N2	510 *1675*	630 *2075*	720 *2350*	750 *2450*
N3	340 *1125*	420 *1375*	480 *1575*	500 *1650*
N11	390 *1275*	480 *1575*	550 *1800*	570 *1875*
S1	40 *130*	48 *155*	55 *180*	60 *195*
S2	32 *105*	39 *130*	44 *145*	47 *155*
S3	28 *90*	34 *110*	39 *130*	41 *135*
S11	55 *180*	65 *215*	75 *245*	80 *260*
S12	38 *125*	46 *150*	55 *180*	55 *180*
S13	22 *70*	27 *90*	31 *100*	33 *110*
H5	33 *110*	41 *135*	47 *155*	50 *165*
H8	36 *120*	43 *140*	50 *165*	55 *180*
H11	42 *140*	50 *165*	60 *195*	65 *215*
H12	70 *230*	85 *280*	95 *310*	100 *330*
H21	36 *120*	43 *140*	50 *165*	55 *180*

MP16 Slot and Side milling – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	30%	10%	5%
P1	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,075 *0.0030*	0,12 *0.0048*	0,16 *0.0065*
P2	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
P3	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*	0,16 *0.0065*
P4	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*	0,16 *0.0065*
P5	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
P6	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
P7	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
P8	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*	0,16 *0.0065*
P11	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
P12	MP16-16010R04Z3-M05 MP3000	4,0 *0.16*	0,044 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 *0.0040*
M1	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
M2	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
M3	MP16-16010R05Z3-E05 F40M	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
M4	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
M5	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
K1	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
K2	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
K3	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
K4	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
K5	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*	0,14 *0.0055*
K6	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
K7	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*	0,14 *0.0055*
N1	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*	0,22 *0.0085*
N2	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*	0,22 *0.0085*
N3	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*	0,22 *0.0085*
N11	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*	0,22 *0.0085*
S1	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
S2	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
S3	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,10 *0.0040*
S11	MP16-16010R05Z3-E05 F40M	3,5 *0.14*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
S12	MP16-16010R05Z3-E05 F40M	3,5 *0.14*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
S13	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
H5	MP16-16010R04Z3-M05 MP3000	4,0 *0.16*	0,044 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 *0.0040*
H8	MP16-16010R04Z3-M05 MP3000	3,5 *0.14*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*	0,080 *0.0032*
H11	MP16-16010R04Z3-M05 MP3000	4,0 *0.16*	0,044 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 *0.0040*
H12	MP16-16010R04Z3-M05 MP3000	3,5 *0.14*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*	0,080 *0.0032*
H21	MP16-16010R04Z3-M05 MP3000	3,5 *0.14*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*	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

MP16 Slot and Side milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000				F40M			
	100%	30%	10%	5%	100%	30%	10%	5%
P1	235 *770*	310 *1025*	360 *1175*	395 *1300*	225 *740*	295 *970*	340 *1125*	375 *1225*
P2	230 *750*	300 *980*	350 *1150*	380 *1250*	215 *710*	280 *920*	335 *1100*	360 *1175*
P3	195 *640*	260 *850*	310 *1025*	330 *1075*	185 *610*	245 *800*	290 *950*	315 *1025*
P4	175 *570*	230 *750*	270 *890*	290 *950*	165 *540*	215 *710*	255 *840*	275 *900*
P5	170 *560*	220 *720*	260 *850*	280 *920*	160 *520*	210 *690*	245 *800*	265 *870*
P6	190 *620*	250 *820*	290 *950*	315 *1025*	180 *590*	235 *770*	275 *900*	300 *980*
P7	180 *590*	235 *770*	275 *900*	300 *980*	170 *560*	225 *740*	260 *850*	285 *940*
P8	165 *540*	220 *720*	260 *850*	280 *920*	155 *510*	205 *670*	245 *800*	265 *870*
P11	175 *570*	230 *750*	265 *870*	290 *950*	165 *540*	215 *710*	255 *840*	275 *900*
P12	110 *360*	145 *475*	170 *560*	185 *610*	105 *345*	140 *460*	160 *520*	175 *570*
M1	170 *560*	225 *740*	265 *870*	285 *940*	175 *570*	225 *740*	270 *890*	290 *950*
M2	140 *460*	185 *610*	215 *710*	235 *770*	145 *475*	190 *620*	220 *720*	240 *790*
M3	115 *375*	150 *490*	175 *570*	190 *620*	115 *375*	150 *490*	175 *570*	190 *620*
M4	85 *280*	115 *375*	135 *445*	145 *475*	90 *295*	115 *375*	135 *445*	145 *475*
M5	75 *245*	95 *310*	110 *360*	120 *395*	75 *245*	95 *310*	115 *375*	120 *395*
K1	180 *590*	235 *770*	280 *920*	300 *980*	170 *560*	225 *740*	265 *870*	285 *940*
K2	160 *520*	210 *690*	245 *800*	270 *890*	150 *490*	200 *660*	235 *770*	255 *840*
K3	135 *445*	180 *590*	210 *690*	225 *740*	130 *425*	170 *560*	195 *640*	215 *710*
K4	130 *425*	170 *560*	200 *660*	215 *710*	120 *395*	160 *520*	190 *620*	205 *670*
K5	80 *260*	105 *345*	120 *395*	130 *425*	75 *245*	95 *310*	115 *375*	125 *410*
K6	115 *375*	150 *490*	175 *570*	190 *620*	110 *360*	140 *460*	165 *540*	180 *590*
K7	100 *330*	130 *425*	155 *510*	165 *540*	95 *310*	125 *410*	145 *475*	160 *520*
N1	1350 *4425*	1775 *5825*	2100 *6900*	2250 *7375*	1275 *4175*	1675 *5500*	1975 *6475*	2125 *6975*
N2	550 *1800*	720 *2350*	850 *2800*	910 *2975*	520 *1700*	680 *2225*	800 *2625*	860 *2825*
N3	365 *1200*	475 *1550*	560 *1825*	600 *1975*	345 *1125*	450 *1475*	530 *1750*	570 *1875*
N11	415 *1350*	540 *1775*	640 *2100*	690 *2275*	395 *1300*	520 *1700*	610 *2000*	650 *2125*
S1	41 *135*	55 *180*	60 *195*	65 *215*	42 *140*	55 *180*	65 *215*	70 *230*
S2	33 *110*	43 *140*	50 *165*	55 *180*	34 *110*	44 *145*	50 *165*	55 *180*
S3	29 *95*	38 *125*	44 *145*	47 *155*	29 *95*	38 *125*	45 *150*	48 *155*
S11	60 *195*	75 *245*	90 *295*	95 *310*	60 *195*	75 *245*	90 *295*	95 *310*
S12	40 *130*	50 *165*	60 *195*	65 *215*	40 *130*	55 *180*	60 *195*	65 *215*
S13	23 *75*	30 *100*	35 *115*	38 *125*	23 *75*	31 *100*	36 *120*	38 *125*
H5	35 *115*	45 *150*	55 *180*	60 *195*	35 *115*	46 *150*	55 *180*	60 *195*
H8	36 *120*	47 *155*	55 *180*	60 *195*	37 *120*	48 *155*	55 *180*	60 *195*
H11	44 *145*	60 *195*	65 *215*	75 *245*	45 *150*	60 *195*	70 *230*	75 *245*
H12	70 *230*	90 *295*	105 *345*	115 *375*	65 *215*	85 *280*	100 *330*	110 *360*
H21	36 *120*	47 *155*	55 *180*	60 *195*	37 *120*	48 *155*	55 *180*	60 *195*

MP16 Copy milling – Insert selection – mm/*Inch*

SMG		a_p	f_z				
			100%	30%	10%	5%	2%
P1	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,080 *0.0032*	0,085 *0.0034*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
P2	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,28 *0.011*
P3	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
P4	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
P5	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
P6	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,11 *0.0044*	0,16 *0.0065*	0,26 *0.010*
P7	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,11 *0.0044*	0,16 *0.0065*	0,26 *0.010*
P8	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
P11	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,11 *0.0044*	0,16 *0.0065*	0,26 *0.010*
P12	MP16-16010B90Z3-M05 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*	0,17 *0.0065*
M1	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,28 *0.011*
M2	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
M3	MP16-16010B90Z3-E05 F40M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
M4	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
M5	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
K1	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,28 *0.011*
K2	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
K3	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
K4	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
K5	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,24 *0.0095*
K6	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
K7	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,24 *0.0095*
N1	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,16 *0.0065*	0,22 *0.0085*	0,38 *0.015*
N2	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,16 *0.0065*	0,22 *0.0085*	0,38 *0.015*
N3	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,16 *0.0065*	0,22 *0.0085*	0,38 *0.015*
N11	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,16 *0.0065*	0,22 *0.0085*	0,38 *0.015*
S1	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
S2	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
S3	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
S11	MP16-16010B90Z3-E05 F40M	3,5 *0.14*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
S12	MP16-16010B90Z3-E05 F40M	3,5 *0.14*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
S13	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
H5	MP16-16010B90Z3-M05 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*	0,17 *0.0065*
H8	MP16-16010B90Z3-M05 MP3000	3,5 *0.14*	0,042 *0.0017*	0,042 *0.0017*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H11	MP16-16010B90Z3-M05 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*	0,17 *0.0065*
H12	MP16-16010B90Z3-M05 MP3000	3,5 *0.14*	0,042 *0.0017*	0,042 *0.0017*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H21	MP16-16010B90Z3-M05 MP3000	3,5 *0.14*	0,042 *0.0017*	0,042 *0.0017*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*

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

MP16 Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000					F40M				
	100%	30%	10%	5%	2%	100%	30%	10%	5%	2%
P1	250 *820*	305 *1000*	330 *1075*	355 *1175*	350 *1150*	235 *770*	290 *950*	310 *1025*	335 *1100*	330 *1075*
P2	240 *790*	295 *970*	320 *1050*	345 *1125*	340 *1125*	225 *740*	275 *900*	300 *980*	325 *1075*	325 *1075*
P3	210 *690*	255 *840*	275 *900*	300 *980*	300 *980*	200 *660*	240 *790*	260 *850*	285 *940*	280 *920*
P4	185 *610*	225 *740*	245 *800*	265 *870*	265 *870*	175 *570*	215 *710*	235 *770*	250 *820*	250 *820*
P5	180 *590*	215 *710*	235 *770*	255 *840*	255 *840*	170 *560*	205 *670*	220 *720*	240 *790*	240 *790*
P6	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	190 *620*	230 *750*	250 *820*	270 *890*	270 *890*
P7	190 *620*	230 *750*	250 *820*	270 *890*	270 *890*	180 *590*	215 *710*	235 *770*	255 *840*	255 *840*
P8	175 *570*	215 *710*	230 *750*	250 *820*	250 *820*	165 *540*	205 *670*	220 *720*	240 *790*	235 *770*
P11	185 *610*	225 *740*	240 *790*	265 *870*	260 *850*	175 *570*	210 *690*	230 *750*	250 *820*	245 *800*
P12	120 *395*	145 *475*	150 *490*	165 *540*	165 *540*	110 *360*	135 *445*	145 *475*	155 *510*	155 *510*
M1	180 *590*	220 *720*	240 *790*	260 *850*	255 *840*	185 *610*	225 *740*	245 *800*	265 *870*	260 *850*
M2	150 *490*	180 *590*	195 *640*	215 *710*	210 *690*	150 *490*	185 *610*	200 *660*	215 *710*	215 *710*
M3	120 *395*	145 *475*	155 *510*	170 *560*	165 *540*	125 *410*	150 *490*	160 *520*	170 *560*	170 *560*
M4	95 *310*	115 *375*	120 *395*	130 *425*	130 *425*	95 *310*	120 *395*	120 *395*	130 *425*	130 *425*
M5	80 *260*	95 *310*	100 *330*	105 *345*	105 *345*	80 *260*	100 *330*	100 *330*	110 *360*	110 *360*
K1	190 *620*	230 *750*	255 *840*	275 *900*	270 *890*	180 *590*	220 *720*	240 *790*	260 *850*	255 *840*
K2	170 *560*	205 *670*	225 *740*	245 *800*	240 *790*	160 *520*	195 *640*	210 *690*	230 *750*	225 *740*
K3	145 *475*	175 *570*	190 *620*	205 *670*	205 *670*	135 *445*	165 *540*	180 *590*	195 *640*	190 *620*
K4	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	130 *425*	155 *510*	170 *560*	185 *610*	185 *610*
K5	80 *260*	100 *330*	110 *360*	120 *395*	120 *395*	80 *260*	95 *310*	105 *345*	110 *360*	110 *360*
K6	120 *395*	145 *475*	160 *520*	175 *570*	170 *560*	115 *375*	140 *460*	150 *490*	165 *540*	160 *520*
K7	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*	100 *330*	120 *395*	130 *425*	145 *475*	145 *475*
N1	1425 *4675*	1750 *5750*	1900 *6225*	2050 *6725*	2025 *6650*	1350 *4425*	1650 *5425*	1775 *5825*	1950 *6400*	1925 *6325*
N2	580 *1900*	700 *2300*	760 *2500*	830 *2725*	820 *2700*	550 *1800*	660 *2175*	720 *2350*	780 *2550*	780 *2550*
N3	385 *1275*	470 *1550*	510 *1675*	550 *1800*	550 *1800*	365 *1200*	445 *1450*	480 *1575*	520 *1700*	520 *1700*
N11	440 *1450*	540 *1775*	580 *1900*	630 *2075*	630 *2075*	415 *1350*	510 *1675*	550 *1800*	600 *1975*	590 *1925*
S1	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*	45 *150*	55 *180*	55 *180*	60 *195*	60 *195*
S2	36 *120*	44 *145*	45 *150*	48 *155*	48 *155*	36 *120*	44 *145*	45 *150*	49 *160*	49 *160*
S3	31 *100*	38 *125*	39 *130*	42 *140*	42 *140*	32 *105*	38 *125*	40 *130*	43 *140*	43 *140*
S11	60 *195*	75 *245*	80 *260*	85 *280*	85 *280*	65 *215*	75 *245*	80 *260*	85 *280*	85 *280*
S12	43 *140*	50 *165*	55 *180*	60 *195*	60 *195*	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*
S13	25 *80*	30 *100*	31 *100*	34 *110*	34 *110*	25 *80*	31 *100*	32 *105*	34 *110*	34 *110*
H5	37 *120*	45 *150*	47 *155*	50 *165*	50 *165*	37 *120*	45 *150*	48 *155*	50 *165*	50 *165*
H8	39 *130*	47 *155*	49 *160*	55 *180*	55 *180*	39 *130*	48 *155*	49 *160*	55 *180*	55 *180*
H11	47 *155*	55 *180*	60 *195*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
H12	75 *245*	90 *295*	95 *310*	100 *330*	100 *330*	70 *230*	85 *280*	90 *295*	95 *310*	95 *310*
H21	39 *130*	47 *155*	49 *160*	55 *180*	55 *180*	39 *130*	48 *155*	49 *160*	55 *180*	55 *180*

MP16 Centre drilling – Insert selection – mm/*Inch*

SMG		f_z	a_{so}
			100%
P1	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
P2	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
P3	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
P4	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P5	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P6	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P7	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P8	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
P11	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P12	MP16-16009C90Z2-M05 F40M	0,044 *0.0017*	3,5 *0.14*
M1	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
M2	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
M3	MP16-16009C90Z2-M05 F40M	0,050 *0.0020*	3,5 *0.14*
M4	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
M5	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
K1	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
K2	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
K3	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
K4	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
K5	MP16-16009C90Z2-M05 F40M	0,060 *0.0024*	4,5 *0.18*
K6	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
K7	MP16-16009C90Z2-M05 F40M	0,060 *0.0024*	4,5 *0.18*
N1	MP16-16009C90Z2-M05 F40M	0,090 *0.0036*	4,5 *0.18*
N2	MP16-16009C90Z2-M05 F40M	0,090 *0.0036*	4,5 *0.18*
N3	MP16-16009C90Z2-M05 F40M	0,090 *0.0036*	4,5 *0.18*
N11	MP16-16009C90Z2-M05 F40M	0,090 *0.0036*	4,5 *0.18*
S1	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
S2	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
S3	MP16-16009C90Z2-M05 F40M	0,042 *0.0017*	2,5 *0.10*
S11	MP16-16009C90Z2-M05 F40M	0,050 *0.0020*	3,0 *0.12*
S12	MP16-16009C90Z2-M05 F40M	0,050 *0.0020*	3,0 *0.12*
S13	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
H5	MP16-16009C90Z2-M05 F40M	0,044 *0.0017*	3,5 *0.14*
H8	MP16-16009C90Z2-M05 F40M	0,034 *0.0013*	3,0 *0.12*
H11	MP16-16009C90Z2-M05 F40M	0,044 *0.0017*	3,5 *0.14*
H12	MP16-16009C90Z2-M05 F40M	0,034 *0.0013*	3,0 *0.12*
H21	MP16-16009C90Z2-M05 F40M	0,034 *0.0013*	3,0 *0.12*

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

MP16 Centre drilling – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M
	100%
P1	290 *950*
P2	285 *940*
P3	250 *820*
P4	220 *720*
P5	210 *690*
P6	235 *770*
P7	225 *740*
P8	210 *690*
P11	220 *720*
P12	140 *460*
M1	230 *750*
M2	190 *620*
M3	150 *490*
M4	115 *375*
M5	95 *310*
K1	225 *740*
K2	200 *660*
K3	170 *560*
K4	160 *520*
K5	100 *330*
K6	145 *475*
K7	125 *410*
N1	1650 *5425*
N2	670 *2200*
N3	445 *1450*
N11	510 *1675*
S1	55 *180*
S2	43 *140*
S3	37 *120*
S11	75 *245*
S12	50 *165*
S13	30 *100*
H5	46 *150*
H8	48 *155*
H11	60 *195*
H12	85 *280*
H21	48 *155*

MP16 Chamfering – Insert selection – mm/*Inch*

SMG		a_p	f_z				
			100%	50%	30%	20%	10%
P1	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
P2	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
P3	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
P4	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*
P5	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
P6	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
P7	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
P8	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
P11	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
P12	MP16-16009C90Z2-M05 F40M	3,0 *0.12*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*
M1	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
M2	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
M3	MP16-16009C90Z2-M05 F40M	3,0 *0.12*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
M4	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
M5	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
K1	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
K2	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K3	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K4	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K5	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,10 *0.0040*
K6	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K7	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,10 *0.0040*
N1	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N2	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N3	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N11	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
S1	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
S2	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
S3	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*
S11	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
S12	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
S13	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
H5	MP16-16009C90Z2-M05 F40M	3,0 *0.12*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*
H8	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0024*
H11	MP16-16009C90Z2-M05 F40M	3,0 *0.12*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*
H12	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0024*
H21	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,060 *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

MP16 Chamfering – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M				
	100%	50%	30%	20%	10%
P1	290 *950*	270 *890*	315 *1025*	350 *1150*	415 *1350*
P2	285 *940*	260 *850*	310 *1025*	345 *1125*	400 *1300*
P3	250 *820*	230 *750*	270 *890*	300 *980*	345 *1125*
P4	220 *720*	200 *660*	235 *770*	265 *870*	310 *1025*
P5	210 *690*	195 *640*	230 *750*	255 *840*	295 *970*
P6	235 *770*	220 *720*	260 *850*	285 *940*	335 *1100*
P7	225 *740*	205 *670*	245 *800*	270 *890*	315 *1025*
P8	210 *690*	190 *620*	225 *740*	250 *820*	290 *950*
P11	220 *720*	200 *660*	235 *770*	260 *850*	305 *1000*
P12	140 *460*	125 *410*	140 *460*	160 *520*	195 *640*
M1	230 *750*	210 *690*	250 *820*	275 *900*	325 *1075*
M2	190 *620*	175 *570*	205 *670*	230 *750*	265 *870*
M3	150 *490*	135 *445*	155 *510*	175 *570*	215 *710*
M4	115 *375*	95 *310*	115 *375*	125 *410*	165 *540*
M5	95 *310*	80 *260*	95 *310*	105 *345*	135 *445*
K1	225 *740*	205 *670*	245 *800*	270 *890*	320 *1050*
K2	200 *660*	185 *610*	220 *720*	240 *790*	280 *920*
K3	170 *560*	155 *510*	185 *610*	205 *670*	240 *790*
K4	160 *520*	150 *490*	175 *570*	195 *640*	230 *750*
K5	100 *330*	90 *295*	105 *345*	120 *395*	140 *460*
K6	145 *475*	130 *425*	155 *510*	170 *560*	200 *660*
K7	125 *410*	115 *375*	135 *445*	150 *490*	175 *570*
N1	1650 *5425*	1500 *4925*	1800 *5900*	2000 *6550*	2325 *7625*
N2	670 *2200*	610 *2000*	720 *2350*	810 *2650*	940 *3075*
N3	445 *1450*	405 *1325*	485 *1600*	540 *1775*	630 *2075*
N11	510 *1675*	465 *1525*	550 *1800*	610 *2000*	720 *2350*
S1	55 *180*	44 *145*	55 *180*	60 *195*	75 *245*
S2	43 *140*	35 *115*	43 *140*	47 *155*	60 *195*
S3	37 *120*	31 *100*	38 *125*	42 *140*	55 *180*
S11	75 *245*	65 *215*	75 *245*	85 *280*	110 *360*
S12	50 *165*	45 *150*	50 *165*	60 *195*	75 *245*
S13	30 *100*	25 *80*	30 *100*	33 *110*	43 *140*
H5	46 *150*	41 *135*	47 *155*	55 *180*	65 *215*
H8	48 *155*	42 *140*	48 *155*	55 *180*	70 *230*
H11	60 *195*	50 *165*	60 *195*	70 *230*	85 *280*
H12	85 *280*	75 *245*	85 *280*	100 *330*	125 *410*
H21	48 *155*	42 *140*	48 *155*	55 *180*	70 *230*

MINIMASTER™

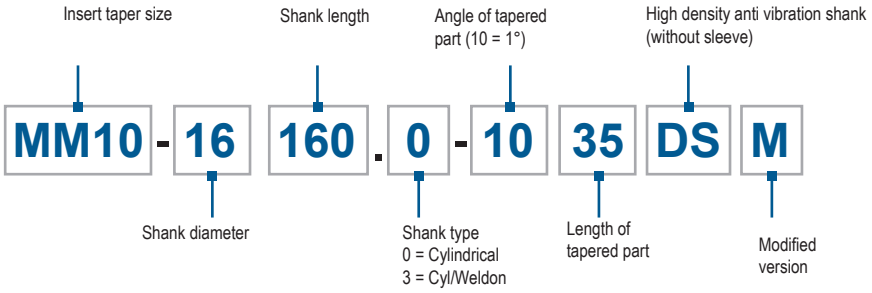
Minimaster™ is a unique, versatile end milling system that can combine different solutions for optimum accessibility and maximum stability and security.

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.

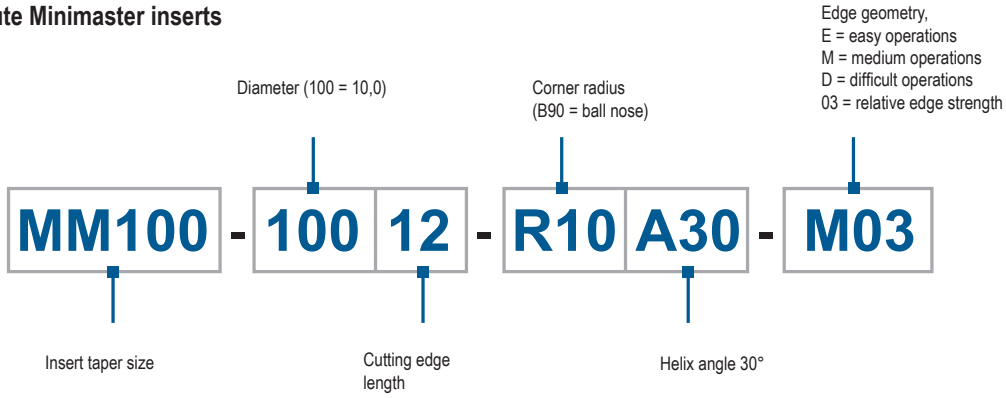
- Square Shoulder range: 6-20 mm (.25 - .75 inch)
- Ballnose range: 6-20 mm (.25 - .75 inch)
- Center Drilling/Chamfering range: 6-19,05mm (.25 - .750 inch)
- High Feed range: 8-12 mm (.375 - .625 inch)
- Plunging range: 6-16 mm (.25 - .625 inch)
- Concave Radius range: 12 mm (.472 inch)

Code keys

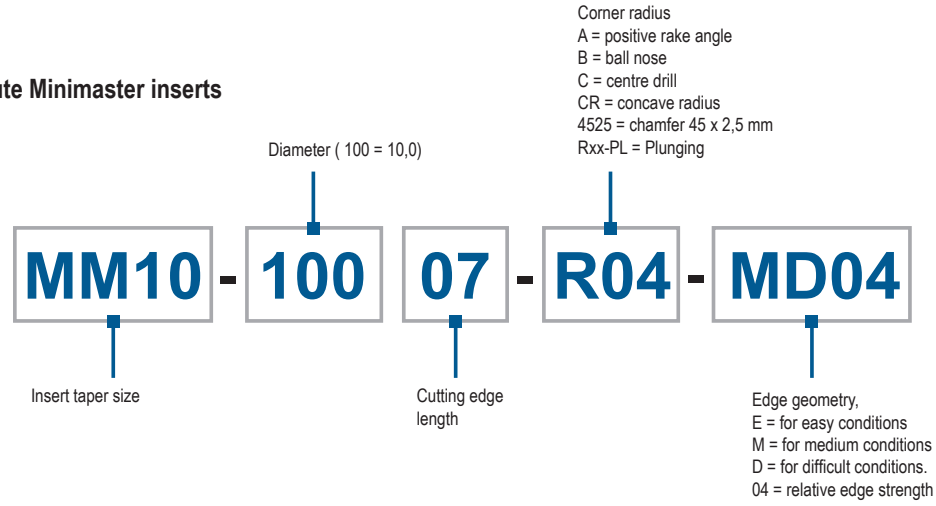
Shanks



3-flute Minimaster inserts



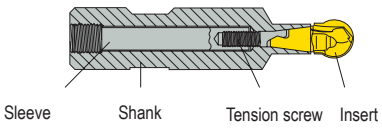
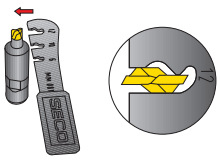
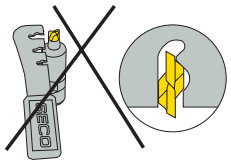
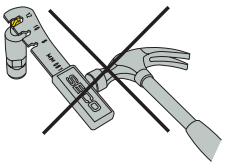
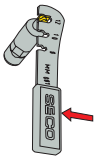
2-flute Minimaster inserts



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 616 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 [XXX].
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

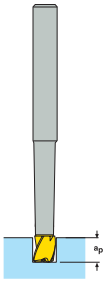


Figure 2

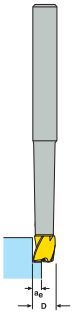


Figure 3

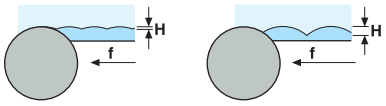


Figure 4

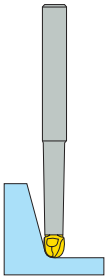


Figure 5

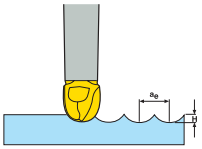
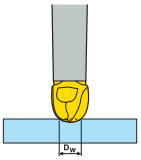
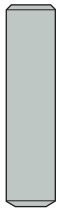
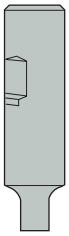
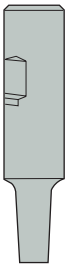
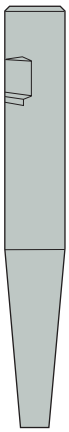
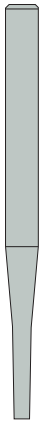


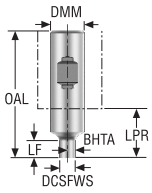
Figure 6



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



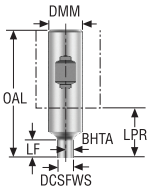
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM06-12070.3-0005	75080695	Weldon	5,75	12,0	70,0	5,0	25,0	0,0	2	✓	80000	0,1	1
MM06-16075.3-3009	75080696	Weldon	5,75	16,0	75,0	9,0	27,0	3,0	3	✓	80000	0,1	1
MM06-16110.3-5058	75080697	Weldon	5,75	16,0	110,0	58,6	62,0	5,0	4	✓	80000	0,2	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 Densimet	5,75	10,0	50,0	7,0	7,0	0,0	2	✓	80000	0,1	3
MM06-10075.0-3041DS	02580701	Cylindrical Densimet	5,75	10,0	75,0	40,5	35,0	3,0	4	✓	80000	0,1	3
MM06-10100.0-1035DS	02580713	Cylindrical Densimet	5,75	10,0	100,0	35,0	60,0	1,0	3	✓	80000	0,1	3
MM06-12120.0-1050DS	02580714	Cylindrical Densimet	5,75	12,0	120,0	50,0	75,0	1,0	3	✓	80000	0,2	3
MM06-16090.0-0012DS	02580670	Cylindrical Densimet	5,75	16,0	90,0	12,0	42,0	0,0	2	✓	80000	0,3	3
MM06-16095.0-0024DS	02580673	Cylindrical Densimet	5,75	16,0	95,0	24,0	47,0	0,0	2	✓	80000	0,3	3
MM06-16140.0-1050DS	02580717	Cylindrical Densimet	5,75	16,0	140,0	50,0	92,0	1,0	3	✓	80000	0,3	3
MM06-16140.0-1035DS	02580716	Cylindrical Densimet	5,75	16,0	140,0	35,0	92,0	1,0	3	✓	80000	0,4	3
MM06-20250.0-1035DS	02580718	Cylindrical Densimet	5,75	20,0	250,0	35,0	190,0	1,0	5	✓	80000	1,0	3

Spare Parts

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	–

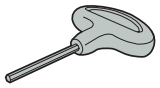
MM06 Shank – *Inch*



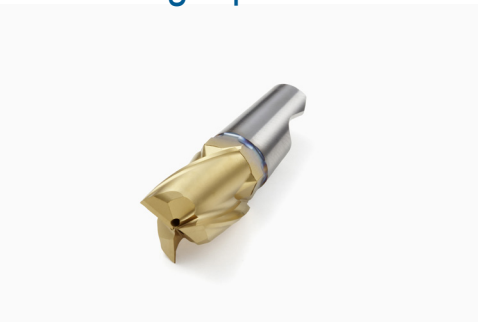
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			Inch	Inch	Inch	Inch	Inch					lbs	
MM06-0.50-2.8-3-0002	00096108	Weldon	0.224	0.500	2.756	0.197	0.984	0,0	2	✓	80000	0.220	1
MM06-0.62-3.0-3-3003	00096116	Weldon	0.224	0.625	2.953	0.354	1.063	3,0	1	✓	80000	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	–	0.787	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 Densimet	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 Densimet	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 Densimet	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 Densimet	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 Densimet	0.224	0.750	9.843	1.378	7.874	1,0	5	✓	80000	1.980	3

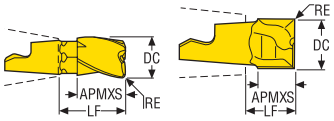
Spare Parts

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

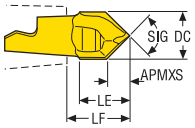




• For Torque keys and torque values, see page 615

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
MM06-06007-A30-E02	6,0 *0.236*	7,5 *0.295*	0,0 *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-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-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-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 *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	✓				■
MM06-06004-M02	6,0 *0.236*	4,1 *0.161*	0,0 *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				■	
MM06-05807-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	✓				■
MM06-05804T-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		■			

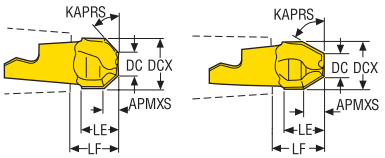
Centre drilling

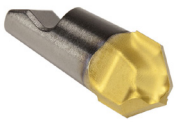


• For Torque keys and torque values, see page 615

Designation	DC	APMXS	LE	LF	SIG°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
MM06-06003-C90-M02	6,0 *0.236*	2,86 *0.113*	6,0 *0.236*	7,12 *0.280*	90,0	2	MM0612	■			
MM06-06003-C120-M02	6,0 *0.236*	1,6 *0.063*	6,27 *0.247*	7,19 *0.283*	120,0	2	MM0612	■			

Chamfering

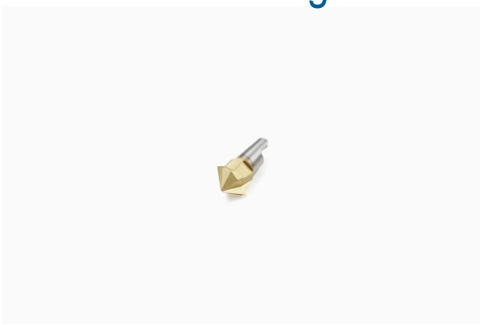


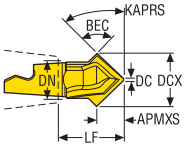


• For Torque keys and torque values, see page 615

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

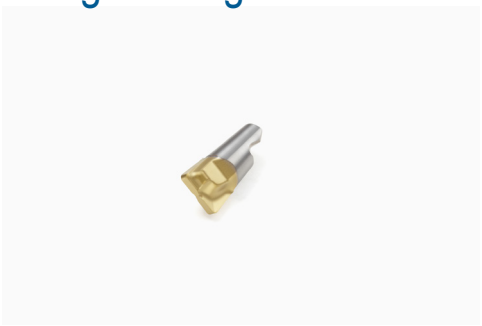


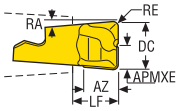


- For Torque keys and torque values, see page 615

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

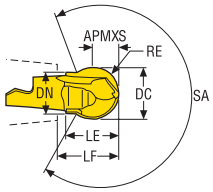




- For Torque keys and torque values, see page 615

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			■	

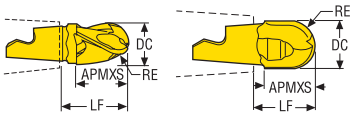
Precision inserts for semi-finishing in all materials



• For Torque keys and torque values, see page 615

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 615

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
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	✓				■
MM06-06006-B90-MD02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*	0,0	2	MM0612		■		■	
MM06-06006-B90S-E02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*	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				■	
MM06-06006-B90P-M02	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*	0,0	2	MM0612				■	
MM06-06406-B90P-M02	6,35 *0.250*	5,4 *0.213*	3,175 *0.125*	7,22 *0.284*	0,0	2	MM0612				■	
MM06-06006-B90PF-M01	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*	0,0	2	MM0612			■		

MM06 - Slot and Side milling – Insert selection – mm/*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

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

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

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*

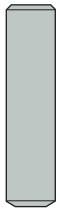
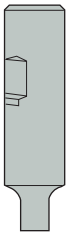
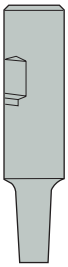
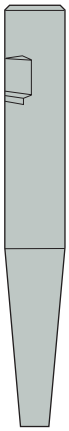
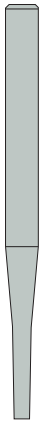
SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *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

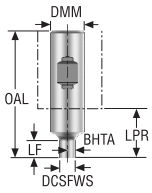
MM06 Z2-Copy milling – Cutting data v_c = (m/min)/*(sf/min)*

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	
	

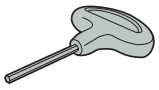
MM08 Shank – Metric



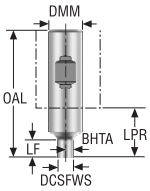
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM08-16070.3-0007	75034241	Weldon	7,6	16,0	70,0	7,6	22,0	0,0	2	✓	80000	0,1	1
MM08-16075.3-3012	75034242	Weldon	7,6	16,0	75,0	12,0	27,0	3,0	3	✓	80000	0,1	1
MM08-16120.3-5048M	00042863	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 Densimet	7,6	10,0	50,0	7,0	10,0	0,0	2	✓	80000	0,1	3
MM08-10080.0-3023DS	02580702	Cylindrical Densimet	7,6	10,0	80,0	22,9	40,0	3,0	4	✓	80000	0,1	3
MM08-12100.0-1035DS	02580719	Cylindrical Densimet	7,6	12,0	100,0	35,0	55,0	1,0	3	✓	80000	0,2	3
MM08-12120.0-1050DS	02580720	Cylindrical Densimet	7,6	12,0	120,0	50,0	75,0	1,0	3	✓	80000	0,2	3
MM08-16085.0-0016DS	02580675	Cylindrical Densimet	7,6	16,0	85,0	16,0	37,0	0,0	2	✓	80000	0,3	3
MM08-16100.0-0032DS	02580687	Cylindrical Densimet	7,6	16,0	100,0	32,0	52,0	0,0	2	✓	80000	0,3	3
MM08-16150.0-1050DS	02580722	Cylindrical Densimet	7,6	16,0	150,0	50,0	102,0	1,0	3	✓	80000	0,4	3
MM08-16150.0-1070DS	02580727	Cylindrical Densimet	7,6	16,0	150,0	70,0	102,0	1,0	3	✓	80000	0,3	3

Spare Parts

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	–

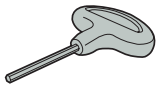
MM08 Shank – *Inch*



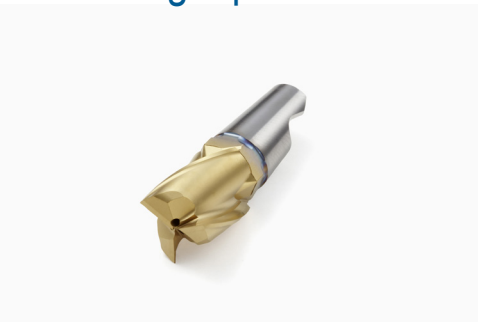
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			Inch	Inch	Inch	Inch	Inch					lbs	
MM08-0.62-2.8-3-0003	75054600	Weldon	0.299	0.625	2.756	0.299	0.866	0,0	2	✓	80000	0.220	1
MM08-0.62-3.0-3-3004	75054601	Weldon	0.299	0.625	2.953	0.472	1.063	3,0	3	✓	80000	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	–	0.787	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 Densimet	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 Densimet	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 Densimet	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 Densimet	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 Densimet	0.299	0.750	9.843	1.969	7.874	1,0	5	✓	80000	1.980	4

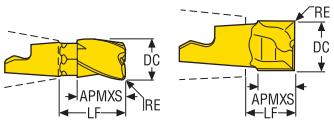
Spare Parts

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

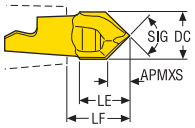




• For Torque keys and torque values, see page 615

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
MM08-08009-A30-E03	8,0 *0.315*	10,0 *0.394*	0,0 *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	✓				■
MM08-08005-M03	8,0 *0.315*	5,5 *0.217*	0,0 *0.0*	6,8 *0.268*	15,0	9,8	15,8	0	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				■	
MM08-08005-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		■		■	
MM08-07809-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	✓				■
MM08-07805T-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		■			

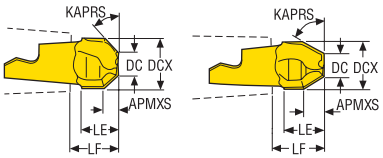
Centre drilling



• For Torque keys and torque values, see page 615

Designation	DC	APMXS	LE	LF	SIG°	ZEFP	Wrench	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*				T60M	F15M	F30M	F40M
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	■			

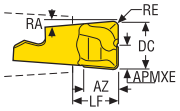
Chamfering



• For Torque keys and torque values, see page 615

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
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	■			

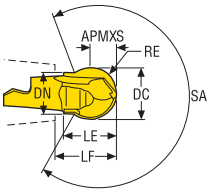
Plunge milling



• For Torque keys and torque values, see page 615

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			■	

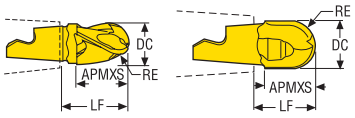
Precision inserts for semi-finishing in all materials



• For Torque keys and torque values, see page 615

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			■	

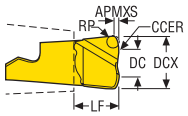
Copy milling



• For Torque keys and torque values, see page 615

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
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	✓				■
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-B90S-E03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*	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-B90PF-M01	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*	0,0	2	MM0612			■		

High feed



• For Torque keys and torque values, see page 615

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				■	

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

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

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

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*

MM08 High-Feed – Insert selection – mm/*Inch*

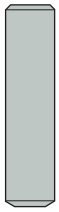
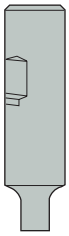
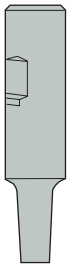
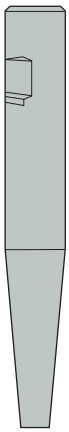
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
P2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
P3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *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

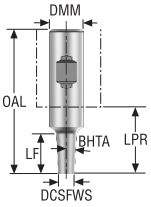
MM08 High-Feed – Cutting data v_c = (m/min)/*(sf/min)*

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	
	

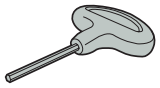
MM10 Shank – Metric



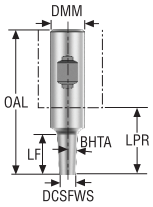
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM10-20075.3-0010	75012787	Weldon	9,5	20,0	75,0	10,0	25,0	0,0	2	✓	80000	0,2	4
MM10-20085.3-3023	75012788	Weldon	9,5	20,0	85,0	23,0	35,0	3,0	3	✓	80000	0,2	4
MM10-20140.3-5060	75012789	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 Densimet	9,6	12,0	60,0	7,0	15,0	0,0	2	✓	76300	0,1	3
MM10-12085.0-3024DS	02580704	Cylindrical Densimet	9,5	12,0	85,0	23,8	40,0	3,0	4	✓	76300	0,2	3
MM10-12100.0-1035DS	02580733	Cylindrical Densimet	9,5	12,0	100,0	35,0	55,0	1,0	3	✓	76300	0,2	3
MM10-14120.0-1050DS	02580736	Cylindrical Densimet	9,5	14,0	120,0	50,0	75,0	1,0	3	✓	76300	0,3	3
MM10-16085.0-0020DS	02580688	Cylindrical Densimet	9,5	16,0	85,0	20,0	37,0	0,0	2	✓	76300	0,3	3
MM10-16105.0-0040DS	02580689	Cylindrical Densimet	9,5	16,0	105,0	40,0	57,0	0,0	2	✓	76300	0,3	3
MM10-16160.0-1055DS	02580748	Cylindrical Densimet	9,5	16,0	160,0	55,0	112,0	1,0	3	✓	76300	0,4	3
MM10-16160.0-1075DS	02580749	Cylindrical Densimet	9,5	16,0	160,0	75,0	112,0	1,0	3	✓	76300	0,4	3
MM10-20250.0-1055DS	02580750	Cylindrical Densimet	9,5	20,0	250,0	55,0	200,0	1,0	5	✓	76300	1,0	3

Spare Parts

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
4	MM-06048	MM10-0627	H06-4
5	MM-06116	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
1	MM-06032	MM10-0627	H06-4
6	MM-06048	MM10-0651	H06-4
7	MM-06032	MM10-0688	H06-4
3	–	MM10-061027	–

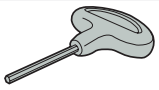
MM10 Shank – *Inch*



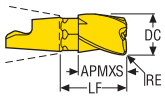
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			Inch	Inch	Inch	Inch	Inch					lbs	
MM10-0.75-3.0-3-0004	75015052	Weldon	0.360	0.750	2.953	0.394	0.984	0,0	2	✓	80000	0.440	3
MM10-0.75-3.3-3-3009	75015053	Weldon	0.374	0.750	3.346	0.906	1.378	3,0	3	✓	80000	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	–	0.669	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 Densimet	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 Densimet	0.360	0.750	4.134	1.575	2.165	0,0	2	✓	76300	0.880	4

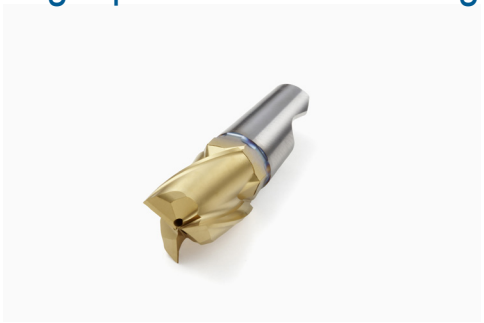
Spare Parts

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
3	MM-06048	MM10-0627	H06-4
5	MM-06116	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
1	MM-06032	MM10-0627	H06-4
7	MM-06032	MM10-0688	H06-4
4	–	MM10-061027	–

Slot milling/square shoulder milling

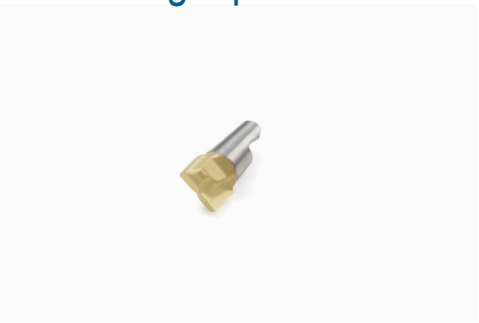


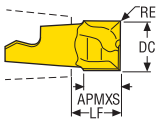


• For Torque keys and torque values, see page 615

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
MM10-10012-A30-E03	10,0 *0.394*	11,8 *0.465*	0,0 *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	✓				■
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-A30-E03	9,525 *0.375*	11,8 *0.465*	0,0 *0.0*	15,72 *0.619*	15,0	11,6	18,8	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	✓				■

Slot milling/square shoulder milling

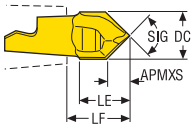




• For Torque keys and torque values, see page 615

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
MM10-10007-M03	10,0 *0.394*	6,9 *0.272*	0,0 *NaN*	8,5 *0.335*	15,0	12,2	19,8	0	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			■	
MM10-09510-M03	9,525 *0.375*	6,8 *0.268*	0,0 *NaN*	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	■			
MM10-10007-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	■		■	
MM10-09510-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	■			

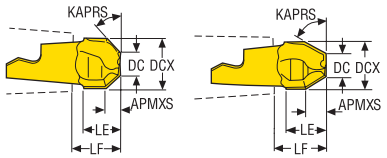
Centre drilling



• For Torque keys and torque values, see page 615

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	■			

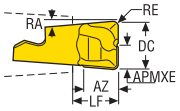
Chamfering



• For Torque keys and torque values, see page 615

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	■			

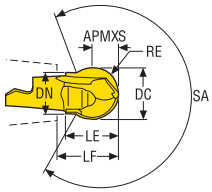
Plunge milling



• For Torque keys and torque values, see page 615

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			■	

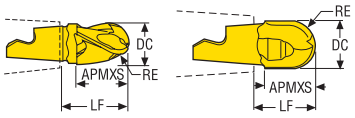
Precision inserts for semi-finishing in all materials

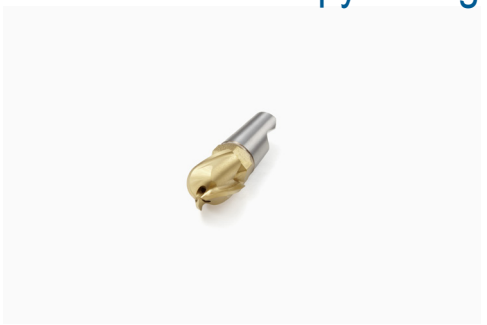


• For Torque keys and torque values, see page 615

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
MM10-12712-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		■		
MM10-12012-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-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

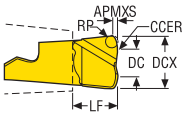




• For Torque keys and torque values, see page 615

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
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	✓				■
MM10-10012-B90A30-D03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10010-B90-MD04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*	0,0	2	MM0612		■		■	
MM10-10010-B90S-E04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*	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-B90PF-M02	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*	0,0	2	MM0612			■		
MM10-09510-B90P-M04	9,525 *0.375*	8,7 *0.343*	4,763 *0.188*	11,74 *0.462*	0,0	2	MM0612		■		■	

High feed



• For Torque keys and torque values, see page 615

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			■	■	

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*

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

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

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*

MM10 High-Feed – Insert selection – mm/*Inch*

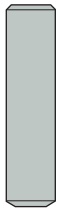
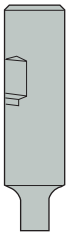
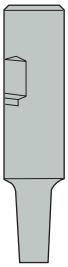
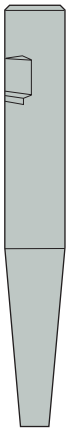
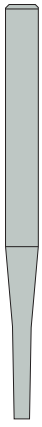
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,48 *0.019*	0,48 *0.019*	0,65 *0.026*	0,80 *0.032*
P2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *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

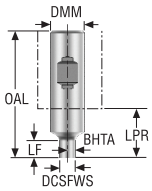
MM10 High-Feed – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	— —	— —	— —	— —	230 *750*	280 *920*	325 *1075*	340 *1125*
P2	— —	— —	— —	— —	225 *740*	270 *890*	315 *1025*	330 *1075*
P3	— —	— —	— —	— —	195 *640*	240 *790*	275 *900*	290 *950*
P4	— —	— —	— —	— —	170 *560*	210 *690*	240 *790*	255 *840*
P5	— —	— —	— —	— —	165 *540*	200 *660*	230 *750*	240 *790*
P6	— —	— —	— —	— —	185 *610*	225 *740*	260 *850*	270 *890*
P7	— —	— —	— —	— —	175 *570*	215 *710*	245 *800*	255 *840*
P8	— —	— —	— —	— —	165 *540*	200 *660*	230 *750*	240 *790*
P11	— —	— —	— —	— —	170 *560*	210 *690*	240 *790*	250 *820*
P12	— —	— —	— —	— —	110 *360*	135 *445*	150 *490*	160 *520*
M1	— —	— —	— —	— —	180 *590*	220 *720*	255 *840*	265 *870*
M2	— —	— —	— —	— —	150 *490*	180 *590*	210 *690*	220 *720*
M3	— —	— —	— —	— —	120 *395*	145 *475*	165 *540*	175 *570*
M4	— —	— —	— —	— —	95 *310*	110 *360*	130 *425*	135 *445*
M5	— —	— —	— —	— —	80 *260*	95 *310*	110 *360*	115 *375*
K1	190 *620*	230 *750*	270 *890*	280 *920*	175 *570*	215 *710*	250 *820*	260 *850*
K2	170 *560*	205 *670*	235 *770*	245 *800*	160 *520*	190 *620*	220 *720*	230 *750*
K3	145 *475*	175 *570*	200 *660*	210 *690*	135 *445*	160 *520*	185 *610*	195 *640*
K4	135 *445*	165 *540*	190 *620*	200 *660*	125 *410*	155 *510*	175 *570*	185 *610*
K5	85 *280*	100 *330*	115 *375*	125 *410*	75 *245*	95 *310*	105 *345*	115 *375*
K6	120 *395*	145 *475*	170 *560*	175 *570*	110 *360*	135 *445*	155 *510*	165 *540*
K7	105 *345*	130 *425*	150 *490*	155 *510*	100 *330*	120 *395*	140 *460*	145 *475*
N1	— —	— —	— —	— —	1325 *4350*	1600 *5250*	1850 *6075*	1925 *6325*
N2	— —	— —	— —	— —	530 *1750*	650 *2125*	750 *2450*	780 *2550*
N3	— —	— —	— —	— —	355 *1175*	430 *1400*	500 *1650*	520 *1700*
N11	— —	— —	— —	— —	405 *1325*	495 *1625*	570 *1875*	590 *1925*
S1	— —	— —	— —	— —	45 *150*	50 *165*	60 *195*	65 *215*
S2	— —	— —	— —	— —	36 *120*	42 *140*	49 *160*	50 *165*
S3	— —	— —	— —	— —	31 *100*	37 *120*	42 *140*	45 *150*
S11	— —	— —	— —	— —	60 *195*	75 *245*	85 *280*	90 *295*
S12	— —	— —	— —	— —	43 *140*	50 *165*	60 *195*	60 *195*
S13	— —	— —	— —	— —	25 *80*	29 *95*	34 *110*	36 *120*
H5	40 *130*	48 *155*	55 *180*	60 *195*	37 *120*	44 *145*	50 *165*	55 *180*
H8	42 *140*	50 *165*	55 *180*	60 *195*	39 *130*	46 *150*	55 *180*	55 *180*
H11	50 *165*	60 *195*	70 *230*	75 *245*	47 *155*	55 *180*	65 *215*	70 *230*
H12	75 *245*	90 *295*	105 *345*	110 *360*	70 *230*	85 *280*	95 *310*	100 *330*
H21	42 *140*	50 *165*	55 *180*	60 *195*	39 *130*	46 *150*	55 *180*	55 *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	
	

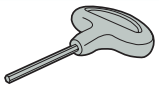
MM12 Shank – Metric



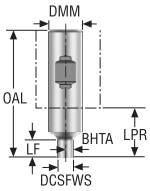
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM12-20080.3-0012	75012864	Weldon	11,4	20,0	80,0	12,0	30,0	0,0	2	✓	80000	0,2	4
MM12-20095.3-3027	75012865	Weldon	11,4	20,0	95,0	27,0	45,0	3,0	3	✓	80000	0,2	4
MM12-20150.3-5049	75012866	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 Densimet	11,5	12,0	70,0	8,5	25,0	0,0	2	✓	63600	0,1	3
MM12-16095.0-0024DS	02580690	Cylindrical Densimet	11,4	16,0	95,0	24,0	47,0	0,0	2	✓	63600	0,3	3
MM12-16090.0-3044DS	02580705	Cylindrical Densimet	11,4	16,0	90,0	43,9	42,0	3,0	4	✓	63600	0,3	3
MM12-16120.0-1045DS	02580752	Cylindrical Densimet	11,4	16,0	120,0	45,0	72,0	1,0	3	✓	63600	0,3	3
MM12-16115.0-0048DS	02580691	Cylindrical Densimet	11,4	16,0	115,0	48,0	67,0	0,0	2	✓	63600	0,3	3
MM12-16170.0-1060DS	02580753	Cylindrical Densimet	11,4	16,0	170,0	60,0	122,0	1,0	3	✓	63600	0,5	3
MM12-16170.0-1080DS	02580755	Cylindrical Densimet	11,4	16,0	170,0	80,0	122,0	1,0	3	✓	63600	0,5	3
MM12-20250.0-1060DS	02580756	Cylindrical Densimet	11,4	20,0	250,0	60,0	200,0	1,0	5	✓	63600	1,0	3

Spare Parts

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
4	MM-06048	MM12-0637	H06-4
5	MM-06116	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
1	MM-06032	MM12-0637	H06-4
3	–	MM12-061037	–

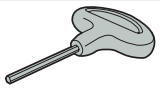
MM12 Shank – *Inch*



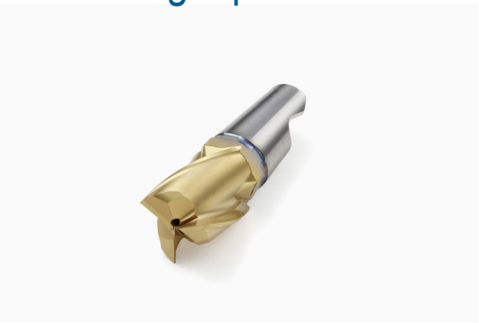
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			Inch	Inch	Inch	Inch	Inch					lbs	
MM12-0.75-3.1-3-0004	75015055	Weldon	0.449	0.750	3.150	0.472	1.181	0,0	2	✓	80000	0.440	3
MM12-0.75-3.7-3-3010	75015056	Weldon	0.449	0.750	3.740	1.063	1.772	3,0	3	✓	80000	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	–	0.669	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	0.660	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 Densimet	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 Densimet	0.449	0.625	6.693	3.150	4.803	1,0	3	✓	63600	1.100	4
MM12-0.75-10.0-0-1023DS	02593427	Cylindrical Densimet	0.449	0.750	9.843	2.362	7.874	1,0	5	✓	63600	2.200	4
MM12-0.75-3.8-0-0009DS	02593428	Cylindrical Densimet	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 Densimet	0.449	0.750	4.528	1.890	2.559	0,0	2	✓	63600	0.880	4

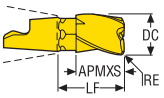
Spare Parts

Accessories

For cutter	Sleeve	Tension screw	Sleeve key
			
3	MM-06048	MM12-0637	H06-4
5	MM-06116	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
1	MM-06032	MM12-0637	H06-4
4	–	MM12-061037	–

Slot milling/square shoulder milling

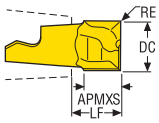




• For Torque keys and torque values, see page 615

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
MM12-12015-A30-E04	12,0 *0.472*	15,35 *0.604*	0,0 *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	✓				■
MM12-11715-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	✓				■
MM12-12715-A30-E04	12,7 *0.500*	15,35 *0.604*	0,0 *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	✓				■

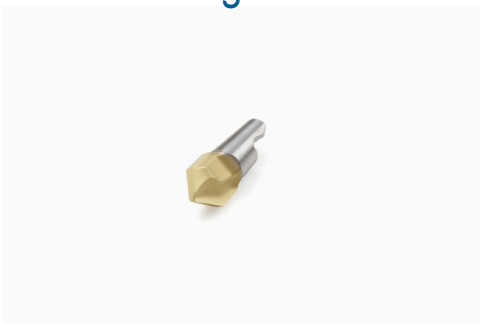
Slot milling/square shoulder milling

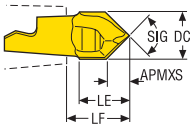


• For Torque keys and torque values, see page 615

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
MM12-12008-M04	12,0 *0.472*	8,2 *0.323*	0,0 *NaN*	10,2 *0.402*	15,0	14,6	23,8	0	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-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-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			■	
MM12-14009-M04	14,0 *0.551*	9,3 *0.366*	0,0 *NaN*	11,26 *0.443*	15,0	17,0	27,8	0	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	■		■	
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	■		■	
MM12-12708-M04	12,7 *0.500*	9,3 *0.366*	0,0 *NaN*	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			■	
MM12-12708-R32-MD05	12,7 *0.500*	9,3 *0.366*	3,175 *0.125*	11,18 *0.440*	15,0	15,4	18,8	0	2	MM1420			■	
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	■			
MM12-13709T-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	■			

Centre drilling

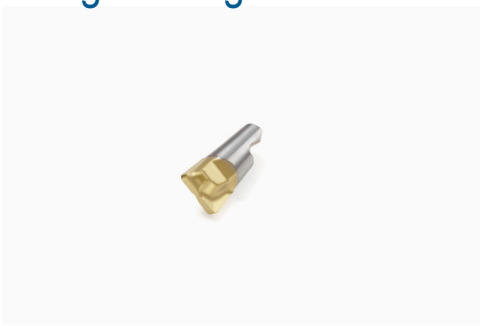


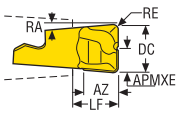


- For Torque keys and torque values, see page 615

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

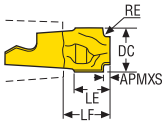




- For Torque keys and torque values, see page 615

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			■	

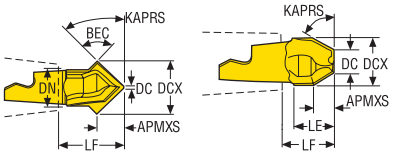
Concave radius



• For Torque keys and torque values, see page 615

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	■			

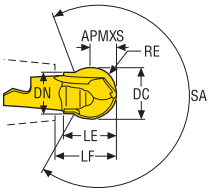
Double chamfering



• For Torque keys and torque values, see page 615

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		■		

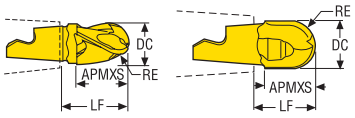
Precision inserts for semi-finishing in all materials

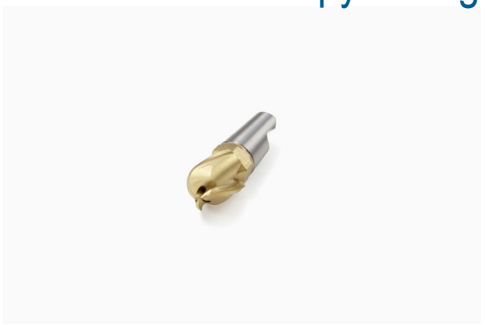


• For Torque keys and torque values, see page 615

Designation	DC	APMXS	RE	LE	LF	DN	SA°	ZEFP	Wrench	Grades Coated T60M	F15M	F30M	F40M
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*							
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-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			■	
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		■		

Copy milling

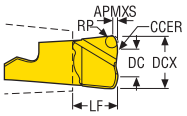




• For Torque keys and torque values, see page 615

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
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	✓				■
MM12-12715-B90A30-M04	12,7 *0.500*	15,3 *0.602*	6,35 *0.250*	19,75 *0.778*	30,0	3	MM0416	✓				■
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-B90S-E05	12,0 *0.472*	12,3 *0.484*	6,0 *0.236*	14,12 *0.556*	0,0	2	MM0612				■	
MM12-14014-B90S-E05	14,0 *0.551*	14,1 *0.555*	7,0 *0.276*	15,92 *0.627*	0,0	2	MM1420				■	
MM12-12012-B90P-M05	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*	0,0	2	MM0612				■	
MM12-12713-B90P-M05	12,7 *0.500*	12,2 *0.480*	6,35 *0.250*	15,92 *0.627*	0,0	2	MM1420		■		■	
MM12-12012-B90PF-M02	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*	0,0	2	MM0612			■		

High feed



• For Torque keys and torque values, see page 615

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

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

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*

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

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*

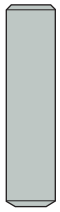
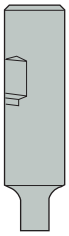
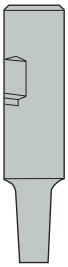
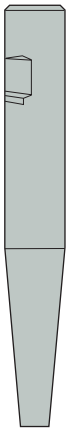
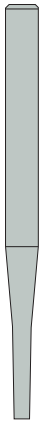
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,95 *0.038*
P2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *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

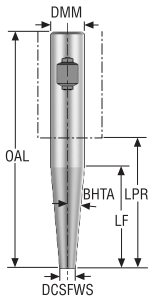
MM12 High-Feed – Cutting data v_c = (m/min)/*(sf/min)*

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

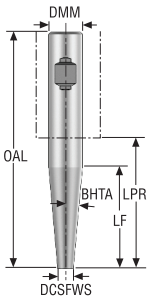


Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			mm	mm	mm	mm	mm					kg	
MM16-20115.3-3045	75014109	Weldon	15,2	20,0	115,0	45,8	65,0	3,0	4	✓	63600	0,3	3
MM16-25100.3-0019	75012790	Weldon	15,2	25,0	100,0	19,0	94,0	0,0	2	✓	63600	0,3	3
MM16-25115.3-3035	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 Densimet	15,2	16,0	150,0	80,0	102,0	0,0	2	✓	47600	0,4	2
MM16-20080.0-0011DS	02580669	Cylindrical Densimet	15,2	20,0	80,0	11,3	30,0	0,0	2	✓	47600	0,4	2
MM16-20150.0-0038DS	02580695	Cylindrical Densimet	15,2	20,0	150,0	38,0	100,0	0,0	2	✓	47600	0,6	2
MM16-20160.0-0076DS	02580699	Cylindrical Densimet	15,2	20,0	160,0	76,0	110,0	0,0	2	✓	47600	0,6	2
MM16-20130.0-1045DS	02580757	Cylindrical Densimet	15,2	20,0	130,0	45,0	80,0	1,0	3	✓	47600	0,5	2
MM16-20190.0-1075DS	02580758	Cylindrical Densimet	15,2	20,0	190,0	75,0	140,0	1,0	3	✓	47600	0,8	2
MM16-20190.0-1095DS	02580760	Cylindrical Densimet	15,2	20,0	190,0	95,0	140,0	1,0	3	✓	47600	0,8	2
MM16-25250.0-1075DS	02580761	Cylindrical Densimet	15,2	25,0	250,0	75,0	194,0	1,0	5	✓	47600	1,6	2

Spare Parts

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*

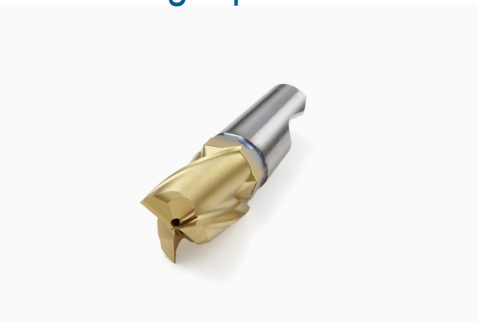


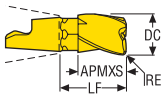
Designation	Item number	ShankType	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Design		RPMX	Weight	Spare part no.
			Inch	Inch	Inch	Inch	Inch					lbs	
MM16-0.75-4.5-3-3018	75054603	Weldon	0.598	0.750	4.528	1.445	2.559	3,0	3	✓	63600	0.440	4
MM16-1.00-3.9-3-0007	75015058	Weldon	0.598	1.000	3.937	0.748	1.732	0,0	2	✓	63600	0.880	4
MM16-1.00-4.5-3-3013	75015059	Weldon	0.598	1.000	4.528	1.378	2.323	3,0	3	✓	63600	0.880	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	–	0.787	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	0.880	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 Densimet	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 Densimet	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 Densimet	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 Densimet	0.598	1.000	6.299	2.992	4.094	0,0	2	✓	47600	1.980	3

Spare Parts

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

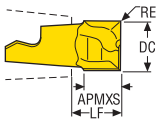




• For Torque keys and torque values, see page 615

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	✓				■
MM16-16019-A30-E06	16,0 *0.630*	19,05 *0.750*	0,0 *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 *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	✓				■
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	✓				■

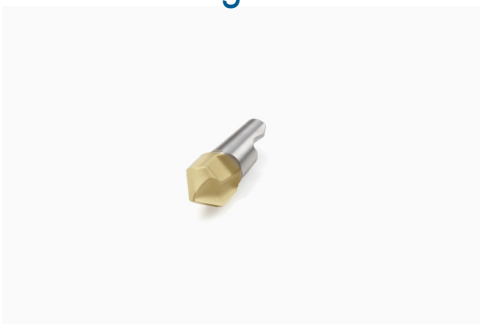
Slot milling/square shoulder milling

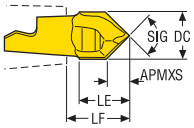


• For Torque keys and torque values, see page 615

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 *NaN*	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	■			
MM16-20013-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	■		■	
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			■	

Centre drilling

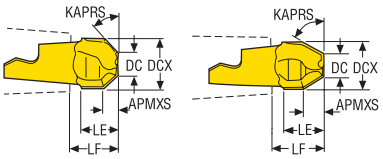




- For Torque keys and torque values, see page 615

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	■			

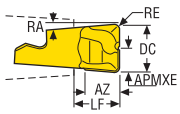
Chamfering



- For Torque keys and torque values, see page 615

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	■			

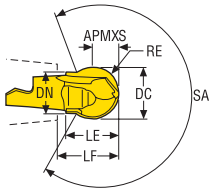
Plunge milling



• For Torque keys and torque values, see page 615

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			■	

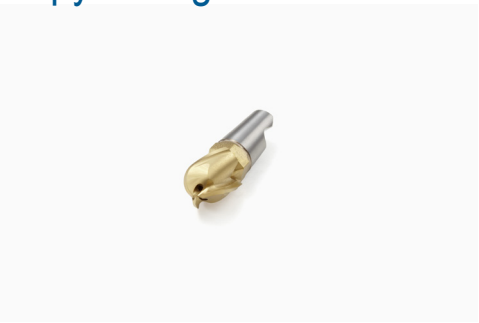
Precision inserts for semi-finishing in all materials

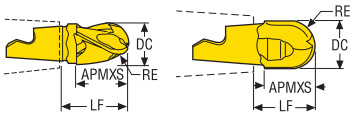


• For Torque keys and torque values, see page 615

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 615

Designation	DC	APMXS	RE	LF	FHA°	ZEFP	Wrench		Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*					T60M	F15M	F30M	F40M
MM16-16019-B90A30-E06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM0416	✓			■	
MM16-20015-B90A30-E06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	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	✓				■
MM16-20015-B90A30-M06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM0416	✓				■
MM16-16016-B90-MD07	16,0 *0.630*	16,2 *0.638*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420		■		■	
MM16-20020-B90-MD07	20,0 *0.787*	20,3 *0.799*	10,0 *0.394*	22,15 *0.872*	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				■	
MM16-20020-B90P-M07	20,0 *0.787*	17,4 *0.685*	10,0 *0.394*	22,12 *0.871*	0,0	2	MM1420				■	
MM16-15916-B90P-M07	15,875 *0.625*	13,8 *0.543*	7,938 *0.313*	18,4 *0.724*	0,0	2	MM1420				■	
MM16-19020-B90P-M07	19,05 *0.750*	7,4 *0.291*	9,525 *0.375*	22,12 *0.871*	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 - 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

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

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

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

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*

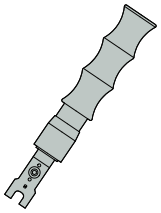
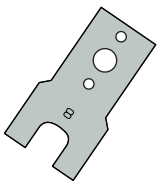
Torque wrench and Max RPM information

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

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
	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
K1	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	
	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
K2	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
	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
K4	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
										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
K5	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
	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
K7	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
	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
N1	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
	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
N2	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
	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
N11			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

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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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