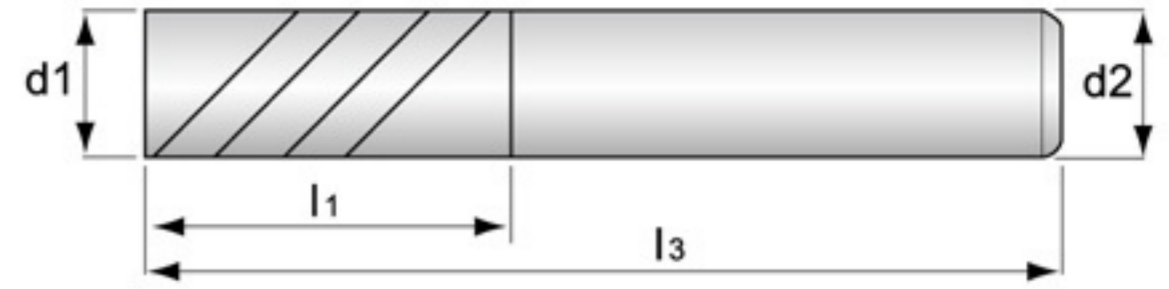




High Speed Cutting
& High Hard Cutting



Micro Diameter

Type No. 型號	Diameter 刃徑 d1	Flute Length 刃長 l1	O. A. L. 全長 l3	Shank Dia. 柄徑 d2
SED454010F	1.0	2.5	50	4
SED454015F	1.5	4	50	4
SED454020F	2.0	5	50	4
SED454025F	2.5	7	50	4
SED454030F	3.0	8	50	4
SED454040F	4.0	10	50	4
SED454020	2.0	5	50	6
SED454030	3.0	8	50	6
SED454040	4.0	10	50	6
SED454050	5.0	13	50	6
SED454060	6.0	15	50	6
SED454080	8.0	20	60	8
SED454100	10.0	25	75	10
SED454120	12.0	30	75	12
SED454140	14.0	35	80	14
SED454160	16.0	40	100	16
SED454180	18.0	40	100	18
SED454200	20.0	45	100	20
SED454250	25.0	45	100	25

d1 (mm)	d1(mm) tolerance
1.0	⁰ _{-0.005} ⁰ _{-0.02}
1.5	⁰ _{-0.005} ⁰ _{-0.02}
2.0	⁰ _{-0.005} ⁰ _{-0.02}
3.0	⁰ ⁰ _{-0.02}
4.0	⁰ ⁰ _{-0.02}
5.0	⁰ ⁰ _{-0.02}
6.0	⁰ ⁰ _{-0.025}
8.0	⁰ ⁰ _{-0.025}
10.0	⁰ ⁰ _{-0.03}
12.0	⁰ ⁰ _{-0.035}
14.0	⁰ ⁰ _{-0.04}
16.0	⁰ ⁰ _{-0.04}
18.0	⁰ ⁰ _{-0.05}
20.0	⁰ ⁰ _{-0.05}
25.0	⁰ ⁰ _{-0.05}

Shank(mm) (h6)	d2(mm) tolerance
Ø 6	⁰ ⁰ _{-0.008}
Ø 8	⁰ ⁰ _{-0.008}
Ø 10	⁰ ⁰ _{-0.009}
Ø 12	⁰ ⁰ _{-0.011}
Ø 14	⁰ ⁰ _{-0.011}
Ø 16	⁰ ⁰ _{-0.011}
Ø 18	⁰ ⁰ _{-0.013}
Ø 20	⁰ ⁰ _{-0.013}
Ø 25	⁰ ⁰ _{-0.013}

$$N = \frac{VC \times 320}{D} \quad F = N \times Fz \times \text{刃數 (Flute No)}$$

Recommended Working Details 白鐵加工數據表

Material	Vc m/min	Fz - feed per tooth									
		ø4	ø5	ø6	ø8	ø10	ø12	ø16	ø18	ø20	ø25
Easy to Cut Steel(304)	90-115	0.015	0.015	0.020	0.030	0.030	0.040	0.050	0.060	0.060	0.060
Moderately difficult to cut Stainless Steels	70-85	0.013	0.013	0.018	0.028	0.028	0.038	0.053	0.058	0.058	0.058
Difficult to cut Stainless Steels (316L)	60-80	0.011	0.011	0.016	0.026	0.026	0.036	0.051	0.056	0.056	0.056
High Temperature Alloy	25-35	0.011	0.011	0.017	0.027	0.027	0.038	0.055	0.060	0.060	0.060
Soft Steels	150-180	0.020	0.020	0.020	0.030	0.030	0.040	0.060	0.060	0.060	0.060
Titanium	50-70	0.012	0.020	0.016	0.022	0.022	0.033	0.044	0.055	0.055	0.055
Gray Cast Iron	120-150	0.015	0.020	0.020	0.030	0.030	0.040	0.060	0.060	0.060	0.060

Material	Profiling		Slotting depth	Performance
	a	b	c	
Easy to Cut Steel(304)	D	50%D	D	Excellent
Moderately difficult to cut Stainless Steels	D	50%D	D	Excellent
Difficult to cut Stainless Steels (316L)	D	50%D	D	Excellent
High Temperature Alloy	D	20%D	30%D	Excellent
Soft Steels	D	50%D	D	Excellent
Titanium	D	20%D	20%D	Recommended for side milling fz x 1.2
Gray Cast Iron	D	50%D	D	Recommended for side milling fz x 1.2