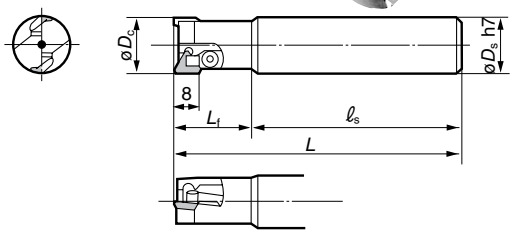
SEC-Multi Use Endmills

CHE 2000Type

8mm 90°



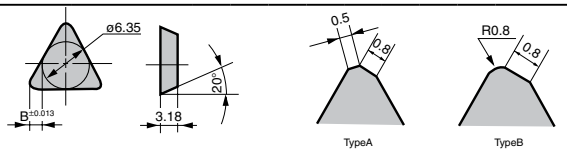
Body

Cat. No.	Stock	Dimensions (mm) øDc	øDs	Lf	ℓs	L	No. of Teeth	Axial Rake	Radial Rake
CHE 2016R	●	16	16	25	75	100	1	+6°	–3°
2018R	●	18	20	30	80	110	1	+8°	–2°
CHE 2020R	●	20	20	30	80	110	2	+10°	–2°
2022R	●	22	20	30	80	110	2	+12°	–1°
2025R	●	25	25	35	85	120	2	+15°	–1°
2028R	●	28	25	35	85	120	2	+15°	0°

Inserts are not included.

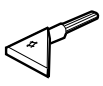
Inserts

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel



Grade		Coated Carbide		Carbide			Cermet	SUMIDIA	
Application	High Speed/Light					K N		N	N
	General Purpose	P M		P	K		P	N	N
	Roughing	P M						N	N
Cat. No.		ACP200		A30N	G10E	H1	T250A	DA1000	DA2200	Cutting Edge
NF-TEEN 22R		—		—	—	—	—	●	▲	A
TECN 22R					●	●		—	—	A
22TR				●				—	—	B
TEKN 22R					●			—	—	A
22TR				●			●	—	—	B

Spare Parts

Clamp	Screw		Ring	Spanner
		N·m		
CCH4R	BHE0407	1.8	ER03	TH025

N·m Recommended Tightening Torque (N·m)

Recommended Cutting Conditions

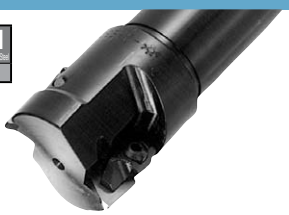
ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - **Optimum** - Max.	Feed Rate f_z (mm/t) Min. - **Optimum** - Max.	Grade
P	Low Carbon Steel	180 to 280HB	50- **75** -100	0.03-**0.06**-0.10	A30N
	Alloy Steel	180 to 280HB	50- **75** -80	0.03-**0.05**-0.06	A30N
K	Cast Iron	250HB	40- **70** -100	0.03-**0.10**-0.15	G10E
N	Non-ferrous Metal	—	40- **90** -150	0.03-**0.10**-0.15	DA1000 H1

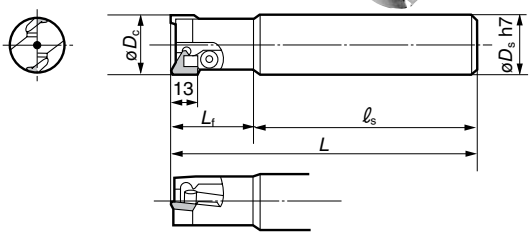
Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

SEC-Multi Use Endmills

CHE 3000Type

13mm 90°





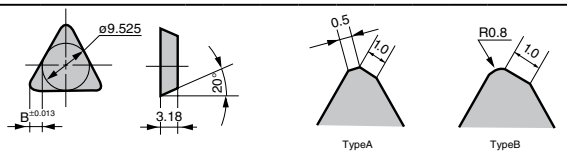
Body

Cat. No.	Stock	Dimensions (mm) øDc	øDs	Lf	ℓs	L	No. of Teeth	Axial Rake	Radial Rake
CHE 3030R	●	30	32	45	115	160	2	+15°	–3°
3032R	●	32	32	45	115	160	2	+15°	–2°
3036R	●	36	32	45	115	160	2	+15°	–1°
3040R	●	40	32	45	115	160	2	+15°	0°

Inserts are not included.

Inserts

P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy H Hardened Steel



Grade		Coated Carbide		Carbide			Cermet	SUMIDIA	
Application	High Speed/Light		K			K N		N	N
	General Purpose	P M	K	P	K		P	N	N
	Roughing	P M						N	N
Cat. No.		ACP200	ACK200	A30N	G10E	H1	T250A	DA1000	DA2200	Cutting Edge
NF-TEEN 32R		—	—	—	—	—	—	●	▲	A
TECN 32R					●	●		—	—	A
32TR				●				—	—	B
TEKN 32R			●		●			—	—	A
32TR		●		●			●	—	—	B

Spare Parts

Clamp	Screw		Ring	Spanner
		N·m		
CCH5R	BHE0510	2.7	ER04	LH030

N·m Recommended Tightening Torque (N·m)

Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed v_c (m/min) Min. - **Optimum** - Max.	Feed Rate f_z (mm/t) Min. - **Optimum** - Max.	Grade
P	Low Carbon Steel	180 to 280HB	60- **90** -120	0.04-**0.08**-0.15	ACP200
	Alloy Steel	180 to 280HB	60- **80** -100	0.04-**0.08**-0.13	ACP200
K	Cast Iron	250HB	60- **90** -120	0.04-**0.12**-0.20	ACK200
N	Non-ferrous Metal	—	60-**130**-200	0.04-**0.12**-0.20	DA1000 H1

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

▲mark :To be replaced by new item (Please confirm stock availability)