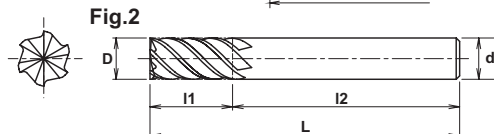
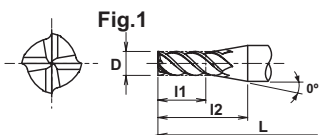


# Solid Carbide End Mills

METRIC

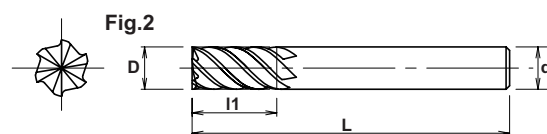
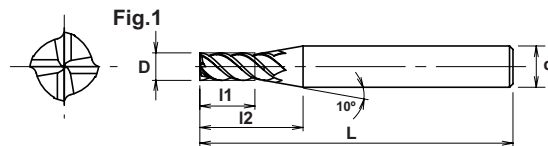
## DV-SEH, DV-SEH-R02 & DV-SEHLS-R02 Type

- 4, 6 & 8 Flute with 50° Helix for high hardened steel up to 70 HRC



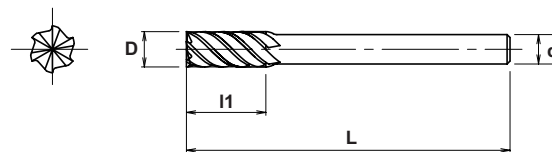
DV-SEH

	CATALOG NUMBER	STK	DIMENSIONS					Flutes	FIG.
			D	I1	I2	L	d		
SHORT	DV-SEHS4010	•	1.0	2	12	60	6	4	1
	DV-SEHS4015	•	1.5	3	12	60	6	4	1
	DV-SEHS4020	•	2.0	4	12	60	6	4	1
	DV-SEHS4025	•	2.5	5	12	60	6	4	1
	DV-SEHS4030	•	3.0	7	17	60	6	4	1
	DV-SEHS4040	•	4.0	9	16	60	6	4	1
	DV-SEHS4050	•	5.0	12	16	60	6	4	1
	DV-SEHS6060	•	6.0	13	-	60	6	6	2
	REGULAR	DV-SEHH4010	•	1.0	3.5	13	60	6	4
DV-SEHH4015		•	1.5	5	14	60	6	4	1
DV-SEHH4020		•	2.0	7	15	60	6	4	1
DV-SEHH4025		•	2.5	8	15	60	6	4	1
DV-SEHH4030		•	3.0	10	20	60	6	4	1
DV-SEHH4035		•	3.5	12	20	60	6	4	1
DV-SEHH4040		•	4.0	12	19	60	6	4	1
DV-SEHH4045		•	4.5	15	20	60	6	4	1
DV-SEHH4050		•	5.0	15	19	60	6	4	1
DV-SEHH4055		•	5.5	15	18	60	6	4	1
DV-SEHH6060		•	6.0	15	-	60	6	6	2
DV-SEHH6065		•	6.5	20	25	75	8	6	1
DV-SEHH6070		•	7.0	20	24	75	8	6	1
DV-SEHH6075		•	7.5	20	22	75	8	6	1
DV-SEHH6080		•	8.0	20	-	75	8	6	2
DV-SEHH6085		•	8.5	25	30	80	10	6	1
DV-SEHH6090		•	9.0	25	29	80	10	6	1
DV-SEHH6095		•	9.5	25	27	80	10	6	1
DV-SEHH6100		•	10.0	25	-	80	10	6	2
DV-SEHH6105		•	10.5	30	35	100	12	6	1
DV-SEHH6110		•	11.0	30	34	100	12	6	1
DV-SEHH6115		•	11.5	30	32	100	12	6	1
DV-SEHH6120		•	12.0	30	-	100	12	6	2
DV-SEHH6130		•	13.0	35	45	105	16	6	1
DV-SEHH6140		•	14.0	35	42	105	16	6	1
DV-SEHH6150		•	15.0	40	44	110	16	6	1
DV-SEHH6160		•	16.0	40	-	110	16	6	2
DV-SEHH6170		•	17.0	40	50	120	20	6	1
DV-SEHH6180		•	18.0	40	47	120	20	6	1
DV-SEHH6190		•	19.0	45	49	125	20	6	1
DV-SEHH6200		•	20.0	45	-	125	20	6	2
DV-SEHH6220		•	22.0	45	55	135	25	6	1
DV-SEHH6240	•	24.0	50	54	140	25	6	1	
DV-SEHH8250	•	25.0	50	-	140	25	8	2	
DV-SEHH8260	•	26.0	50	-	140	25	8	2	
DV-SEHH8280	•	28.0	55	-	145	25	8	2	
DV-SEHH8300	•	30.0	60	67	165	32	8	1	
DV-SEHH8320	•	32.0	70	-	175	32	8	2	



DV-SEH-R02

	CATALOG NUMBER	STK	DIMENSIONS					Flutes	FIG.
			D	I1	I2	L	d		
	DV-SEHH4030-R02	•	3.0	10	20	60	6	4	1
	DV-SEHH4040-R02	•	4.0	12	19	60	6	4	1
	DV-SEHH4045-R02	•	4.5	15	20	60	6	4	1
	DV-SEHH4050-R02	•	5.0	15	19	60	6	4	1
	DV-SEHH6060-R02	•	6.0	15	-	60	6	6	2
	DV-SEHH6070-R02	•	7.0	20	24	75	8	6	1
	DV-SEHH6080-R02	•	8.0	20	-	75	8	6	2
	DV-SEHH6090-R02	•	9.0	25	29	80	10	6	1
	DV-SEHH6100-R02	•	10.0	25	-	80	10	6	2
	DV-SEHH6120-R02	•	12.0	30	-	100	12	6	2
	DV-SEHH6140-R02	•	14.0	35	42	105	16	6	1
	DV-SEHH6160-R02	•	16.0	40	-	110	16	6	2
	DV-SEHH6200-R02	•	20.0	45	-	125	20	6	2
	DV-SEHH8250-R02	•	25.0	50	-	140	25	8	2
	DV-SEHH8300-R02	•	30.0	60	67	165	32	8	1



DV-SEHLS-R02

	CATALOG NUMBER	STK	DIMENSIONS				Flutes
			D	I1	L	d	
	DV-SEHLS6120-S10-R02	•	12.0	30	125	10	6
	DV-SEHLS6160-S14-R02	•	16.0	40	140	14	6
	DV-SEHLS6200-S18-R02	•	20.0	45	160	18	6



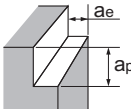
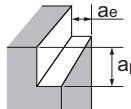
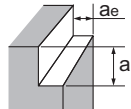
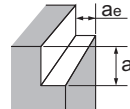
**METRIC**

# Solid Carbide End Mills

## DV-SEH, DV-SEH-RO2 & DV-SEHLS-R02 Type

- 4, 6 & 8 Flute with 50° Helix for high hardened steel up to 70 HRC

### Recommended Cutting Data

Material	Tool & Die Steel, Mold Steel SKD, SKH, NAK (~45HRC) (1.2344, 1.2379, 1.2311, P20)		Hardened Steel SKD, SKT (45~55HRC) (1.2344, 1.2379)		Hardened Steel SKD, SKH (55~65HRC) (1.2344, 1.2379)		Hardened Steel SKD, SKH (65~70HRC) (1.2344, 1.2379)	
	 $a_p \leq 1.5D$ $a_e \leq 0.05D$		 $a_p \leq 1.5D$ $a_e \leq 0.04D$		 $a_p \leq 1.5D$ $a_e \leq 0.04D$ (MAX. 0.6mm)		 $a_p \leq 1.5D$ $a_e \leq 0.02D$ (MAX. 0.4mm)	
Diameter	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)
	1	40,000	700	25,000	410	20,000	320	10,000
2	24,000	950	15,000	560	12,000	430	6,400	220
3	24,000	1,300	15,000	800	12,000	600	6,000	250
4	18,000	1,800	12,000	1,100	9,500	800	5,100	300
6	12,000	2,200	8,000	1,400	6,500	1,100	3,500	420
8	10,000	2,200	6,000	1,400	5,000	1,100	2,500	420
10	8,000	2,200	5,000	1,400	4,000	1,100	2,000	420
12	6,500	1,900	4,000	1,200	3,300	900	1,700	350
16	5,000	1,480	3,000	930	2,500	700	1,300	260
20	3,800	1,150	2,300	730	2,000	550	1,000	200
25	3,000	920	1,800	580	1,600	450	800	160
30	2,500	680	1,500	430	1,300	330	700	140
32	2,300	550	1,400	350	1,200	300	650	120

- Notes:**
- Above cutting conditions are general guidance.
  - Figures should be adjusted according to purpose, rigidity of machine, machining shape and work clamping.
  - Recommend to down cut with air blow or mist coolant.