

# TECHNICAL DATA | CENTERING END MILLS |

## CEM Series

Work Material	Carbon Steels, Alloy Steels						Stainless Steels Titanium Alloys		Aluminum	
	≤ 20 HRC 500~800N/mm <sup>2</sup>		20 ~ 30 HRC 800~1000N/mm <sup>2</sup>		30 ~ 40 HRC 1000~1300N/mm <sup>2</sup>		-	-	-	-
Cutting Diameter (metric)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)
3	5,900	95	3,900	65	3,300	50	2,400	40	14,000	230
4	4,800	95	3,200	65	2,800	50	2,000	40	12,000	240
5	3,800	100	2,500	65	2,200	55	1,760	45	9,500	250
6	3,000	110	2,000	70	1,800	60	1,400	50	7,700	300
8	2,300	115	1,540	75	1,300	65	1,100	55	5,800	350
10	2,000	120	1,300	80	1,200	65	1,000	55	5,100	380
12	1,760	130	1,100	90	1,000	70	840	60	4,400	400
16	1,400	140	900	90	770	70	660	60	3,000	330
20	1,100	140	700	90	600	70	440	60	2,640	340