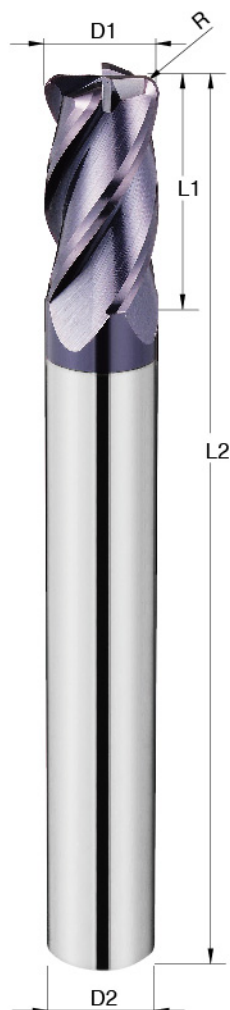


SUPER MILL

SERC

► Long Shank Corner Radius / for **H** **P** **K**

unit: mm

S
MG

4 Flutes



35°

HRC
60

ALTiN

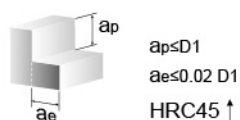
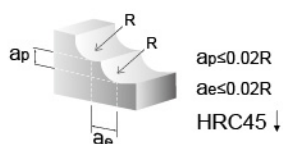
Finishing
Semi-Finishing

Side

Profiling

| Order No. | Diameter D1 | Corner R R | Flute Length L1 | O.A.L. L2 | Shank Dia D2 |
|------------|----------------|---------------|--------------------|--------------|-----------------|
| SERC 0605 | 6.0 | 0.5 | 12 | 75 | 6 |
| SERC 0605A | 6.0 | 0.5 | 12 | 100 | 6 |
| SERC 0610 | 6.0 | 1.0 | 12 | 75 | 6 |
| SERC 0610A | 6.0 | 1.0 | 12 | 100 | 6 |
| SERC 0805 | 8.0 | 0.5 | 16 | 100 | 8 |
| SERC 0810 | 8.0 | 1.0 | 16 | 100 | 8 |
| SERC 1005 | 10.0 | 0.5 | 20 | 100 | 10 |
| SERC 1010 | 10.0 | 1.0 | 20 | 100 | 10 |
| SERC 1020 | 10.0 | 2.0 | 20 | 100 | 10 |
| SERC 1205 | 12.0 | 0.5 | 24 | 100 | 12 |
| SERC 1210 | 12.0 | 1.0 | 24 | 100 | 12 |
| SERC 1220 | 12.0 | 2.0 | 24 | 100 | 12 |

▼ Depth of cut



R=Corner R

▼ Recommended cutting condition for SERC

| MATERIAL | Carbon Steels . Alloy Steels S45C, FC, FCD, SCM, S50C, SKS... | | Alloy Steels . Tool Steels SCr, SNCM, SKD11, SKD61, NAK80... | | Hardened Steels SKD11 | |
|--------------|--|------------------|---|------------------|-------------------------------|------------------|
| HARDNESS | ~HRC30 | | ~HRC50 | | ~HRC60 | |
| Dia. (D1) | SPEED (min ⁻¹) | FEED mm / min | SPEED (min ⁻¹) | FEED mm / min | SPEED (min ⁻¹) | FEED mm / min |
| 6 | 12000 | 3600 | 7200 | 2200 | 3500 | 650 |
| 8 | 9600 | 4000 | 5600 | 2200 | 2700 | 750 |
| 10 | 7000 | 3400 | 4400 | 1700 | 2100 | 650 |
| 12 | 6000 | 2800 | 3600 | 1400 | 1800 | 600 |