

## SUPER MILL

## SEFA

► Long Neck / Square / for **H** **P** **K**

unit: mm

S  
MG

2 Flutes

35°

HRC  
60

ALTiN

Finishing  
Semi-  
Finishing

Slotting

| Order No.  | Diameter<br>D1 | Neck Dia<br>D3 | Flute Length<br>L1 | Effective Length<br>L3 | O.A.L.<br>L2 | Shank Dia<br>D2 |
|------------|----------------|----------------|--------------------|------------------------|--------------|-----------------|
| SEFA 01006 | 1.0            | 0.95           | 3                  | 6                      | 50           | 4               |
| SEFA 01008 | 1.0            | 0.95           | 3                  | 8                      | 50           | 4               |
| SEFA 01010 | 1.0            | 0.95           | 3                  | 10                     | 50           | 4               |
| SEFA 01012 | 1.0            | 0.95           | 3                  | 12                     | 50           | 4               |
| SEFA 01508 | 1.5            | 1.45           | 4                  | 8                      | 50           | 4               |
| SEFA 01510 | 1.5            | 1.45           | 4                  | 10                     | 50           | 4               |
| SEFA 01512 | 1.5            | 1.45           | 4                  | 12                     | 50           | 4               |
| SEFA 01516 | 1.5            | 1.45           | 4                  | 16                     | 50           | 4               |
| SEFA 02008 | 2.0            | 1.92           | 6                  | 8                      | 50           | 4               |
| SEFA 02010 | 2.0            | 1.92           | 6                  | 10                     | 50           | 4               |
| SEFA 02012 | 2.0            | 1.92           | 6                  | 12                     | 50           | 4               |
| SEFA 02016 | 2.0            | 1.92           | 6                  | 16                     | 50           | 4               |
| SEFA 02020 | 2.0            | 1.92           | 6                  | 20                     | 50           | 4               |
| SEFA 02510 | 2.5            | 2.40           | 8                  | 10                     | 50           | 4               |
| SEFA 02512 | 2.5            | 2.40           | 8                  | 12                     | 50           | 4               |
| SEFA 02516 | 2.5            | 2.40           | 8                  | 16                     | 50           | 4               |
| SEFA 02520 | 2.5            | 2.40           | 8                  | 20                     | 50           | 4               |
| SEFA 03010 | 3.0            | 2.90           | 8                  | 10                     | 50           | 6               |
| SEFA 03012 | 3.0            | 2.90           | 8                  | 12                     | 50           | 6               |
| SEFA 03016 | 3.0            | 2.90           | 8                  | 16                     | 50           | 6               |
| SEFA 03020 | 3.0            | 2.90           | 8                  | 20                     | 75           | 6               |
| SEFA 03025 | 3.0            | 2.90           | 8                  | 25                     | 75           | 6               |

DAVA GROUP CNC  
COMERCIALIZADORA

## ▼ Depth of cut



## ▼ Recommended cutting condition for SEFA

| MATERIAL |                  | Alloy Steels . Tool Steels . Hardened Steels<br>S45C , SCM , S50C , SKS , SCr , SNCM , SKD11 , SKD61 , NAK80 |               |                      |
|----------|------------------|--------------------------------------------------------------------------------------------------------------|---------------|----------------------|
| Dia.(D1) | EFFECTIVE LENGTH | SPEED (min <sup>-1</sup> )                                                                                   | FEED mm / min | DEPTH OF CUT ap (mm) |
| 1        | 4                | 25000                                                                                                        | 1500          | 0.05                 |
|          | 6                | 25000                                                                                                        | 1500          | 0.03                 |
|          | 10               | 25000                                                                                                        | 1500          | 0.01                 |
| 1.5      | 4                | 15000                                                                                                        | 1200          | 0.1                  |
|          | 8                | 15000                                                                                                        | 1200          | 0.05                 |
|          | 10               | 15000                                                                                                        | 1200          | 0.025                |
|          | 12               | 15000                                                                                                        | 1200          | 0.018                |
| 2        | 8                | 12000                                                                                                        | 900           | 0.2                  |
|          | 10               | 8800                                                                                                         | 700           | 0.12                 |
|          | 12               | 7500                                                                                                         | 600           | 0.05                 |
|          | 16               | 7000                                                                                                         | 500           | 0.02                 |
| 3        | 10               | 8000                                                                                                         | 600           | 0.5                  |
|          | 12               | 8000                                                                                                         | 600           | 0.45                 |
|          | 16               | 5500                                                                                                         | 450           | 0.18                 |
|          | 20               | 4000                                                                                                         | 300           | 0.15                 |
|          | 25               | 6000                                                                                                         | 400           | 0.1                  |