



SSE09



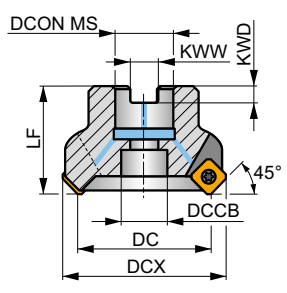
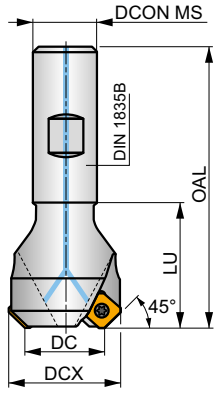
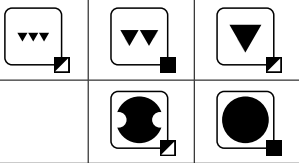
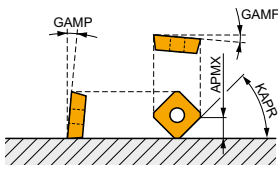
PRAMET



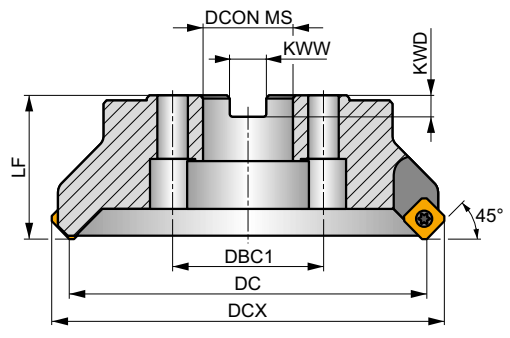
45° Face Mill with Positive Design and Internal Coolant

Highly productive 45° face mill utilising single sided SE.. 09 style inserts with APMX of 4.5 mm. Suited for face milling and chamfering. Weldon and arbor style available, in range from Ø20 up to Ø160 mm and with differential tooth pitch. Body treated for longer tool life.

KAPR	45°
APMX	4.5 mm



DC 32 – 125 mm



DC 160 mm

	0.06 - 0.2
	0.06 - 0.18



Product	DC	DCX	OAL	DCON MS	DCCB	DBC1	LU	LF	KWW	KWD	GAMF	GAMP	max.		kg	FA		AC		
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[°]								
20N2R032B20-SSE09-C	20	29.8	82	20	-	-	32	-	-	-	-5	20	2	-	24600	✓	0.26	GI147	FA010	-
25N3R042B25-SSE09-C	25	34.8	98	25	-	-	42	-	-	-	-5	20	3	-	22000	✓	0.44	GI147	FA010	-
32N4R042B32-SSE09-C	32	42	102	32	-	-	42	-	-	-	-5	20	4	-	19400	✓	0.68	GI147	FA010	-
32A04R-S45SE09F-C	32	42	-	16	14	-	-	40	8.4	6.4	-5	20	4	✓	19400	✓	0.24	GI147	FA012	-
40A04R-S45SE09F-C	40	53.2	-	16	14	-	-	40	8.4	6.4	-5	20	4	✓	17400	✓	0.30	GI147	FA012	-
50A05R-S45SE09F-C	50	59.6	-	22	18	-	-	40	10.4	6.4	-5	20	5	✓	15600	✓	0.56	GI147	FA013	-
63A05R-S45SE09F-C	63	75.8	-	22	18	-	-	40	10.4	6.4	-5	20	5	✓	13900	✓	0.57	GI147	FA013	-
63A06R-S45SE09F-C	63	75.8	-	22	18	-	-	40	10.4	6.4	-5	20	6	✓	13900	✓	0.58	GI147	FA013	-
80A06R-S45SE09F-C	80	89.6	-	27	38	-	-	50	12.4	7	-5	20	6	✓	12300	✓	1.14	GI147	FA011	AC001
80A08R-S45SE09F-C	80	89.6	-	27	38	-	-	50	12.4	7	-5	20	8	✓	12300	✓	1.13	GI147	FA011	AC001
100A08R-S45SE09F-C	100	110	-	32	45	-	-	50	14.4	8	-5	20	8	✓	11000	✓	1.83	GI147	FA011	AC002
100A10R-S45SE09F-C	100	110	-	32	45	-	-	50	14.4	8	-5	20	10	✓	10900	✓	1.82	GI147	FA011	AC002
125A09R-S45SE09F-C	125	134.5	-	40	60	-	-	63	16.4	9	-5	20	9	✓	9800	✓	3.87	GI147	FA011	AC003
125A12R-S45SE09F-C	125	134.5	-	40	60	-	-	63	16.4	9	-5	20	12	✓	9800	✓	3.87	GI147	FA011	AC003
160C10R-S45SE09F	160	169.6	-	40	-	66.7	-	63	16.4	9	-5	20	10	✓	8700	-	6.21	GI147	FA014	-
160C14R-S45SE09F	160	169.6	-	40	-	66.7	-	63	16.4	9	-5	20	14	✓	8700	-	6.29	GI147	FA014	-

GI147	SEET 09T3AF..
	SEMT 09T3AF..

FA010	US 3007-T09P	2.0	M 3	7.3	-	-	Flag T09P
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	-
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	HS 0830C



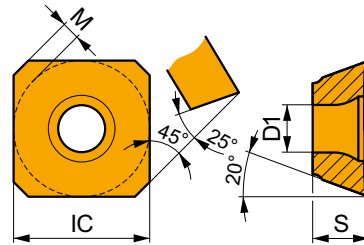
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1030C
FA014	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1240C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SEET 09

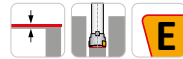
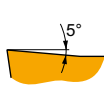


	IC	D1	M	S
	[mm]	[mm]	[mm]	[mm]
09T3	9.525	3.50	1	3.97



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]



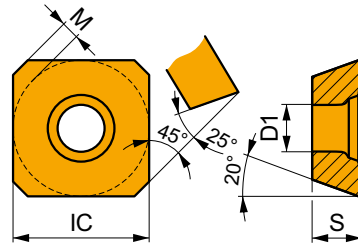
Positive design for light to medium machining.

SEET 09T3AFEN	Material	RE	P			M			K			N			S			H				
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap		
8215	–	■	300	0.14	2.5	✓	180	0.13	2.5	–	–	–	–	–	–	–	75	0.10	2.0	–	–	–
M6330	–	■	255	0.14	2.5	✓	180	0.13	2.5	–	–	–	–	–	–	–	75	0.10	2.0	–	–	–
M8330	–	■	295	0.14	2.5	✓	175	0.13	2.5	–	–	–	–	–	–	–	70	0.10	2.0	–	–	–
M8340	–	■	270	0.14	2.5	✓	160	0.13	2.5	–	–	–	–	–	–	–	65	0.10	2.0	–	–	–
M9325	–	■	380	0.14	2.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
M9340	–	■	345	0.14	2.5	✓	205	0.13	2.5	–	–	–	–	–	–	–	85	0.10	2.0	–	–	–



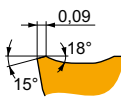
SEMT 09

	IC	D1	M	S
	[mm]	[mm]	[mm]	[mm]
09T3	9.525	3.50	1	3.97



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE [mm]	P			M			K			N			S			H		
		vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]



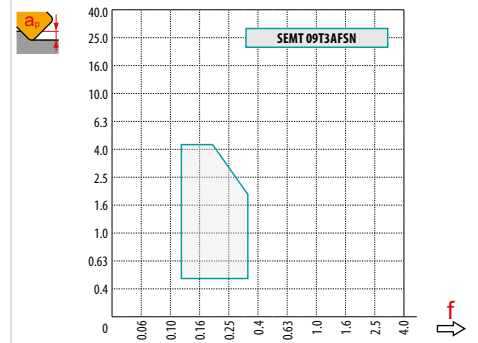
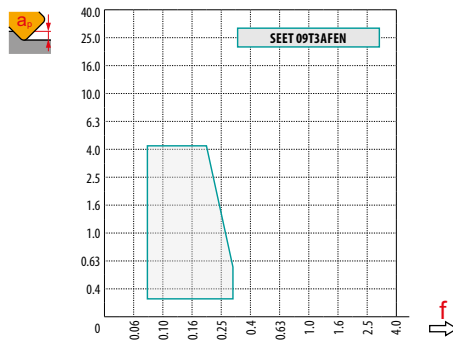
Positive design for light to medium machining.

SEMT 09T3AFSN	8215	–	■	295	0.18	1.8	☑	175	0.16	1.8	■	280	0.18	1.8	–	–	–	–	–	–
	M8330	–	■	290	0.18	1.8	☑	170	0.16	1.8	■	275	0.18	1.8	–	–	–	–	–	–
	M8340	–	■	265	0.18	1.8	☑	155	0.16	1.8	☑	250	0.18	1.8	–	–	–	–	–	–
	M9325	–	■	365	0.18	1.8	–	–	–	–	■	345	0.18	1.8	–	–	–	–	–	–



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SEET 09	SEMT 09
	-	-
	1.28	1.25



DC	X.V	f_{max}
20	1.20	0.18
25	1.24	0.20
32	1.29	0.23
40	1.33	0.25
50	1.37	0.28
63	1.41	0.32
80	1.46	0.36
100	1.50	0.40
125	1.55	0.45
160	1.60	0.51