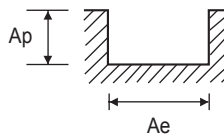


EH919 SERIES

MULTI FLUTE - SLOTTING

SFM(Vc) = ft./min.
 IPT(fz) = in./tooth
 RPM = rev./min.
 IPM(Feed) = in./min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						4.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0	25.0			
P	1-4	Non-alloy steel	1.0D	0.5D	SFM(Vc)	965	965	960	950	990	980	990	990	1110			
					IPT(fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020			
	RPM				23400	15600	11620	9200	8010	6800	6010	4810	4300				
	IPM(Feed)				55	54	55	55	57	56	57	51	51				
	5				Low alloy steel	1.0D	0.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825
								IPT(fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007
	RPM	18620	12410	9190				7610	6000	5210	4800	3600	3200				
	IPM(Feed)	20	20	20				19	19	19	18	14	14				
	6-7	High alloyed steel, and tool steel	1.0D	0.5D				SFM(Vc)	965	965	960	950	990	980	990	990	1110
								IPT(fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
	RPM				23400	15600	11620	9200	8010	6800	6010	4810	4300				
	IPM(Feed)				55	54	55	55	57	56	57	51	51				
8-9	High alloyed steel, and tool steel				1.0D	0.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825	
							IPT(fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007	
RPM		18620	12410	9190			7610	6000	5210	4800	3600	3200					
IPM(Feed)		20	20	20			19	19	19	18	14	14					
10		Stainless steel	1.0D	0.5D			SFM(Vc)	965	965	960	950	990	980	990	990	1110	
							IPT(fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020	
RPM	23400				15600	11620	9200	8010	6800	6010	4810	4300					
IPM(Feed)	55				54	55	55	57	56	57	51	51					
11.1-11.2	Heat Resistant Super Alloys				1.0D	0.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825	
							IPT(fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007	
RPM		18620	12410	9190			7610	6000	5210	4800	3600	3200					
IPM(Feed)		20	20	20			19	19	19	18	14	14					
M		Titanium Alloys	1.0D	0.5D			SFM(Vc)	520	520	520	525	520	520	545	495	560	
							IPT(fz)	.0004	.0004	.0005	.0007	.0008	.0007	.0007	.0006	.0007	
RPM	12570				8380	6290	5090	4190	3590	3300	2400	2170					
IPM(Feed)	13				13	13	14	13	13	12	9	10					
S	Chilled Cast Iron				1.0D	0.5D	SFM(Vc)	150	150	150	135	145	130	130	135	155	
							IPT(fz)	.0004	.0005	.0006	.0009	.0010	.0007	.0006	.0006	.0007	
RPM		3580	2390	1790			1310	1190	910	800	650	600					
IPM(Feed)		5	5	4			5	5	3	3	2	3					
H		D4~10:0.25D D12~16:0.15D D18~25:0.1D	1.0D	0.5D			SFM(Vc)	520	520	520	525	520	520	545	495	560	
							IPT(fz)	.0004	.0004	.0005	.0007	.0008	.0007	.0007	.0006	.0007	
RPM	12570				8380	6290	5090	4190	3590	3300	2400	2170					
IPM(Feed)	13				13	13	14	13	13	12	9	10					



※ The Feed, in long & extra long types, should be reduced by around 50%.

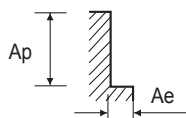


EH919 SERIES

MULTI FLUTE - SIDE CUTTING

SFM(Vc) = ft./min.
IPT (fz) = in./tooth
RPM = rev./min.
IPM(Feed) = in./min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						4.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0	25.0
P	1	Non-alloy steel	0.3D	1.5D	SFM(Vc)	965	965	960	950	990	980	990	990	1110
					IPT (fz)	.0013	.0015	.0020	.0025	.0030	.0028	.0031	.0030	.0033
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
	2-4		0.3D	1.5D	SFM(Vc)	965	965	960	950	990	980	990	990	1110
					IPT (fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
	5		0.3D	1.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825
					IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0013	.0010	.0013
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
	6-7		0.3D	1.5D	SFM(Vc)	965	965	960	950	990	980	990	990	1110
					IPT (fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
8-9	0.3D	1.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825		
			IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0013	.0010	.0013		
			RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200		
10	0.3D	1.5D	SFM(Vc)	965	965	960	950	990	980	990	990	1110		
			IPT (fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020		
			RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300		
11.1-11.2	0.3D	1.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825		
			IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0013	.0010	.0013		
			RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200		
M	12-14.2	Stainless steel	D4~10:0.15D D12~16:0.1D D18~25:0.05D	1.5D	SFM(Vc)	520	520	520	525	520	520	545	495	560
					IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0012	.0010	.0013
					RPM	12570	8380	6290	5090	4190	3590	3300	2400	2170
					IPM (FEED)	22	22	23	22	22	23	20	14	16
S	31-35	Heat Resistant Super Alloys	D4~10:0.15D D12~16:0.1D D18~25:0.05D	1.0D	SFM(Vc)	150	150	150	135	145	130	130	135	155
					IPT (fz)	.0007	.0008	.0010	.0015	.0016	.0011	.0011	.0010	.0012
	36-37	Titanium Alloys		SFM(Vc)	520	520	520	525	520	520	545	495	560	
				IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0012	.0010	.0013	
H	40	Chilled Cast Iron	0.3D	1.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825
					IPT (fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM (FEED)	20	20	20	19	19	19	18	14	14



※ The Feed, in long & extra long types, should be reduced by around 50%.