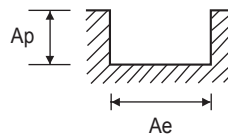


**EH852, EH831** SERIES

**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)								
						6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0
<b>P</b>	1-4	Non-alloy steel	1.0D	0.5D	SFM (Vc)	965	960	950	990	980	990	965	990	1110
					IPT (fz)	.0012	.0016	.0015	.0018	.0021	.0024	.0026	.0027	.0024
					RPM	15600	11620	9200	8010	6800	6010	5200	4810	4300
					IPM (FEED)	55	55	55	57	57	57	55	51	51
	5	Non-alloy steel	1.0D	0.5D	SFM (Vc)	765	760	785	740	750	790	815	740	825
					IPT (fz)	.0005	.0007	.0006	.0008	.0009	.0009	.0009	.0009	.0009
					RPM	12410	9190	7610	6000	5210	4800	4400	3600	3200
					IPM (FEED)	19	20	19	19	20	18	17	14	14
	6-7	Low alloy steel	1.0D	0.5D	SFM (Vc)	965	960	950	990	980	990	965	990	1110
					IPT (fz)	.0012	.0016	.0015	.0018	.0021	.0024	.0026	.0027	.0024
					RPM	15600	11620	9200	8010	6800	6010	5200	4810	4300
					IPM (FEED)	55	55	55	57	57	57	55	51	51
8-9	Low alloy steel	1.0D	0.5D	SFM (Vc)	765	760	785	740	750	790	815	740	825	
				IPT (fz)	.0005	.0007	.0006	.0008	.0009	.0009	.0009	.0009	.0009	
				RPM	12410	9190	7610	6000	5210	4800	4400	3600	3200	
				IPM (FEED)	19	20	19	19	20	18	17	14	14	
10	High alloyed steel, and tool steel	1.0D	0.5D	SFM (Vc)	965	960	950	990	980	990	965	990	1110	
				IPT (fz)	.0012	.0016	.0015	.0018	.0021	.0024	.0026	.0027	.0024	
				RPM	15600	11620	9200	8010	6800	6010	5200	4810	4300	
				IPM (FEED)	55	55	55	57	57	57	55	51	51	
11.1-11.2	High alloyed steel, and tool steel	1.0D	0.5D	SFM (Vc)	765	760	785	740	750	790	815	740	825	
				IPT (fz)	.0005	.0007	.0006	.0008	.0009	.0009	.0009	.0009	.0009	
				RPM	12410	9190	7610	6000	5210	4800	4400	3600	3200	
				IPM (FEED)	19	20	19	19	20	18	17	14	14	
<b>M</b>	12-14.2	Stainless steel	1.0D	D4 ~ 10: 0.25D D12 ~ 16: 0.15D D18 ~ 25: 0.1D	SFM (Vc)	520	520	525	520	520	545	505	495	560
					IPT (fz)	.0005	.0007	.0007	.0008	.0009	.0009	.0009	.0009	.0009
					RPM	8380	6290	5090	4190	3590	3300	2710	2400	2170
					IPM (FEED)	13	13	14	13	14	12	10	9	10
<b>S</b>	31-35	Heat Resistant Super Alloys	1.0D	0.05D	SFM (Vc)	150	150	135	145	130	130	130	135	155
					IPT (fz)	.0006	.0008	.0009	.0010	.0009	.0008	.0008	.0009	.0009
					RPM	2390	1790	1310	1190	910	800	710	650	600
					IPM (FEED)	5	4	5	5	3	3	2	2	3
	36-37	Titanium Alloys	1.0D	D4 ~ 10: 0.25D D12 ~ 16: 0.15D D18 ~ 25: 0.1D	SFM (Vc)	520	520	525	520	520	545	505	495	560
					IPT (fz)	.0005	.0007	.0007	.0008	.0009	.0009	.0009	.0009	.0009
					RPM	8380	6290	5090	4190	3590	3300	2710	2400	2170
					IPM (FEED)	13	13	14	13	14	12	10	9	10
<b>H</b>	40	Chilled Cast Iron	1.0D	0.5D	SFM (Vc)	765	760	785	740	750	790	815	740	825
					IPT (fz)	.0005	.0007	.0006	.0008	.0009	.0009	.0009	.0009	.0009
					RPM	12410	9190	7610	6000	5210	4800	4400	3600	3200
					IPM (FEED)	19	20	19	19	20	18	17	14	14



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

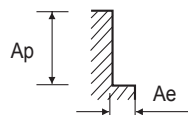


**EH852, EH831** SERIES

**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)								
						6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0
P	1-4	Non-alloy steel	0.3D	1.5D	SFM(Vc)	965	960	950	990	980	990	965	990	1110
					IPT(fz)	.0020	.0026	.0025	.0030	.0035	.0039	.0044	.0044	.0039
					RPM	15600	11620	9200	8010	6800	6010	5200	4810	4300
					IPM(FEED)	92	92	91	95	94	95	92	86	85
	5	Non-alloy steel	0.3D	1.5D	SFM(Vc)	765	760	785	740	750	790	815	740	825
					IPT(fz)	.0009	.0012	.0011	.0013	.0016	.0016	.0016	.0015	.0015
					RPM	12410	9190	7610	6000	5210	4800	4400	3600	3200
					IPM(FEED)	34	33	34	31	33	30	28	22	25
	6-7	Low alloy steel	0.3D	1.5D	SFM(Vc)	965	960	950	990	980	990	965	990	1110
					IPT(fz)	.0020	.0026	.0025	.0030	.0035	.0039	.0044	.0044	.0039
					RPM	15600	11620	9200	8010	6800	6010	5200	4810	4300
					IPM(FEED)	92	92	91	95	94	95	92	86	85
8-9	Low alloy steel	0.3D	1.5D	SFM(Vc)	765	760	785	740	750	790	815	740	825	
				IPT(fz)	.0009	.0012	.0011	.0013	.0016	.0016	.0016	.0015	.0015	
				RPM	12410	9190	7610	6000	5210	4800	4400	3600	3200	
				IPM(FEED)	34	33	34	31	33	30	28	22	25	
10	High alloyed steel, and tool steel	0.3D	1.5D	SFM(Vc)	965	960	950	990	980	990	965	990	1110	
				IPT(fz)	.0020	.0026	.0025	.0030	.0035	.0039	.0044	.0044	.0039	
				RPM	15600	11620	9200	8010	6800	6010	5200	4810	4300	
				IPM(FEED)	92	92	91	95	94	95	92	86	85	
11.1-11.2	High alloyed steel, and tool steel	0.3D	1.5D	SFM(Vc)	765	760	785	740	750	790	815	740	825	
				IPT(fz)	.0009	.0012	.0011	.0013	.0016	.0016	.0016	.0015	.0015	
				RPM	12410	9190	7610	6000	5210	4800	4400	3600	3200	
				IPM(FEED)	34	33	34	31	33	30	28	22	25	
M	12-14.2	Stainless steel	D4~10:0.15D D12~16:0.1D D18~25:0.05D	1.5D	SFM(Vc)	520	520	525	520	520	545	505	495	560
					IPT(fz)	.0009	.0012	.0011	.0013	.0016	.0015	.0015	.0015	.0015
					RPM	8380	6290	5090	4190	3590	3300	2710	2400	2170
					IPM(FEED)	23	22	22	22	23	20	17	14	16
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	SFM(Vc)	150	150	135	145	130	130	130	135	155
					IPT(fz)	.0010	.0013	.0015	.0016	.0014	.0013	.0014	.0015	.0015
					RPM	2390	1790	1310	1190	910	800	710	650	600
					IPM(FEED)	7	7	8	8	5	4	4	4	4
S	36-37	Titanium Alloys	D4~10:0.15D D12~16:0.1D D18~25:0.05D	1.0D	SFM(Vc)	520	520	525	520	520	545	505	495	560
					IPT(fz)	.0009	.0012	.0011	.0013	.0016	.0015	.0015	.0015	.0015
					RPM	8380	6290	5090	4190	3590	3300	2710	2400	2170
					IPM(FEED)	23	22	22	22	23	20	17	14	16
H	40	Chilled Cast Iron	0.3D	1.5D	SFM(Vc)	765	760	785	740	750	790	815	740	825
					IPT(fz)	.0009	.0012	.0011	.0013	.0016	.0016	.0016	.0015	.0015
					RPM	12410	9190	7610	6000	5210	4800	4400	3600	3200
					IPM(FEED)	34	33	34	31	33	30	28	22	25



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