



JET-POWER END MILLS

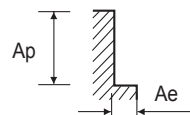
RECOMMENDED CUTTING CONDITIONS

EE515 SERIES

4&6 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)												
						3.0	4.0	5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	
P	1-4	Non-alloy steel	0.1D	1.5D	SFM(Vc)	135	150	155	160	165	165	165	165	165	165	165	165	165
					IPT(fz)	.0004	.0006	.0008	.0009	.0013	.0017	.0019	.0019	.0015	.0015	.0017	.0018	
	RPM	4400	3600	3000	2600	2000	1600	1320	1160	1000	900	800	640					
	IPM(Feed)	7	8	9	9	10	11	10	9	9	8	8	7					
	5	Non-alloy steel	0.1D	1.5D	SFM(Vc)	35	35	40	35	40	40	40	40	40	40	40	45	
					IPT(fz)	.0002	.0003	.0003	.0004	.0005	.0006	.0007	.0009	.0007	.0007	.0008	.0010	
	RPM	1100	900	750	600	500	410	340	290	250	225	200	165					
	IPM(Feed)	1	1	1	1	1	1	1	1	1	1	1	1					
	6-7	Low alloy steel	0.1D	1.5D	SFM(Vc)	135	150	155	160	165	165	165	165	165	165	165	165	
					IPT(fz)	.0004	.0006	.0008	.0009	.0013	.0017	.0019	.0019	.0015	.0015	.0017	.0018	
RPM	4400	3600	3000	2600	2000	1600	1320	1160	1000	900	800	640						
IPM(Feed)	7	8	9	9	10	11	10	9	9	8	8	7						
8-9	Low alloy steel	0.1D	1.5D	SFM(Vc)	35	35	40	35	40	40	40	40	40	40	40	45		
				IPT(fz)	.0002	.0003	.0003	.0004	.0005	.0006	.0007	.0009	.0007	.0007	.0008	.0010		
RPM	1100	900	750	600	500	410	340	290	250	225	200	165						
IPM(Feed)	1	1	1	1	1	1	1	1	1	1	1	1						
10	High alloyed steel, and tool steel	0.1D	1.5D	SFM(Vc)	135	150	155	160	165	165	165	165	165	165	165	165		
				IPT(fz)	.0004	.0006	.0008	.0009	.0013	.0017	.0019	.0019	.0015	.0015	.0017	.0018		
RPM	4400	3600	3000	2600	2000	1600	1320	1160	1000	900	800	640						
IPM(Feed)	7	8	9	9	10	11	10	9	9	8	8	7						
11.1-11.2	High alloyed steel, and tool steel	0.1D	1.5D	SFM(Vc)	35	35	40	35	40	40	40	40	40	40	40	45		
				IPT(fz)	.0002	.0003	.0003	.0004	.0005	.0006	.0007	.0009	.0007	.0007	.0008	.0010		
RPM	1100	900	750	600	500	410	340	290	250	225	200	165						
IPM(Feed)	1	1	1	1	1	1	1	1	1	1	1	1						
M	12-14.2	Stainless steel	0.1D	1.5D	SFM(Vc)	70	75	75	80	80	80	80	85	80	85	80	80	
IPT(fz)	.0005	.0007	.0008	.0012	.0015	.0022	.0023	.0026	.0017	.0019	.0021	.0021						
RPM	2200	1800	1500	1300	1000	800	660	580	500	450	400	320						
IPM(Feed)	4	5	5	6	6	7	6	6	5	5	5	4						
S	31-37	Heat Resistant Super Alloys Titanium Alloys	0.05D	1.0D	SFM(Vc)	25	30	30	30	35	35	35	35	35	35	35	35	
					IPT(fz)	.0003	.0007	.0004	.0005	.0006	.0008	.0009	.0011	.0008	.0009	.0010	.0013	
RPM	880	720	600	480	400	330	270	230	200	180	160	130						
IPM(Feed)	1	2	1	1	1	1	1	1	1	1	1	1						
H	40	Chilled Cast Iron	0.1D	1.5D	SFM(Vc)	865	940	980	940	1045	1075	1070	1065	1045	1060	1045	1080	
					IPT(fz)	.0002	.0003	.0004	.0005	.0006	.0007	.0008	.0009	.0007	.0007	.0006	.0006	
RPM	1100	900	750	600	500	410	340	290	250	225	200	165						
IPM(Feed)	1	1	1	1	1	1	1	1	1	1	1	1						



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