

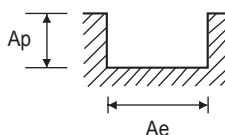


E5075, E5105, E5074, E5104 SERIES

3 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)									
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1
P	1-2	Non-alloy steel	1.0D	0.5D	SFM(Vc)	110	110	110	110	110	110	110	110	110	110
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	3360	2240	1680	1340	1120	960	840	670	560	420
	3-4		1.0D	0.5D	SFM(Vc)	90	90	90	90	90	90	90	90	90	90
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2750	1830	1380	1100	920	790	690	550	460	340
	5		1.0D	0.5D	SFM(Vc)	70	70	70	70	70	70	70	70	70	70
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2140	1430	1070	860	710	610	530	430	360	270
	6		1.0D	0.5D	SFM(Vc)	110	110	110	110	110	110	110	110	110	110
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
RPM		3360			2240	1680	1340	1120	960	840	670	560	420		
7	1.0D	0.5D	SFM(Vc)	90	90	90	90	90	90	90	90	90	90		
			IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050		
			RPM	2750	1830	1380	1100	920	790	690	550	460	340		
8-9	1.0D	0.5D	SFM(Vc)	70	70	70	70	70	70	70	70	70	70		
			IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050		
			RPM	2140	1430	1070	860	710	610	530	430	360	270		
10	1.0D	0.5D	SFM(Vc)	110	110	110	110	110	110	110	110	110	110		
			IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050		
			RPM	3360	2240	1680	1340	1120	960	840	670	560	420		
11.1	1.0D	0.5D	SFM(Vc)	70	70	70	70	70	70	70	70	70	70		
			IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050		
			RPM	2140	1430	1070	860	710	610	530	430	360	270		
M	12-14.2	Stainless steel	1.0D	0.5D	SFM(Vc)	60	60	60	60	60	60	60	60	60	60
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	1830	1220	920	730	610	520	460	370	310	230
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	1.0D	0.5D	SFM(Vc)	90	90	90	90	90	90	90	90	90	90
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2750	1830	1380	1100	920	790	690	550	460	340
					SFM(Vc)	70	70	70	70	70	70	70	70	70	70
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2140	1430	1070	860	710	610	530	430	360	270
					SFM(Vc)	60	60	60	60	60	60	60	60	60	60
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	1830	1220	920	730	610	520	460	370	310	230
					SFM(Vc)	90	90	90	90	90	90	90	90	90	90
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2750	1830	1380	1100	920	790	690	550	460	340
					SFM(Vc)	70	70	70	70	70	70	70	70	70	70
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2140	1430	1070	860	710	610	530	430	360	270



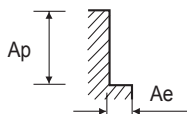
※ The Feed, in long & extra long types, should be reduced by around 50%.

E5075, E5105, E5074, E5104 SERIES

3 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)									
						1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1
P	1-2	Non-alloy steel	0.5D	1.5D	SFM(Vc)	110	110	110	110	110	110	110	110	110	110
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	3360	2240	1680	1340	1120	960	840	670	560	420
	3-4		0.5D	1.5D	SFM(Vc)	90	90	90	90	90	90	90	90	90	90
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2750	1830	1380	1100	920	790	690	550	460	340
	5		0.5D	1.5D	SFM(Vc)	70	70	70	70	70	70	70	70	70	70
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2140	1430	1070	860	710	610	530	430	360	270
	6		0.5D	1.5D	SFM(Vc)	110	110	110	110	110	110	110	110	110	110
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	3360	2240	1680	1340	1120	960	840	670	560	420
7	0.5D	1.5D	SFM(Vc)	90	90	90	90	90	90	90	90	90	90		
			IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050		
			RPM	2750	1830	1380	1100	920	790	690	550	460	340		
8-9	0.5D	1.5D	SFM(Vc)	70	70	70	70	70	70	70	70	70	70		
			IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050		
			RPM	2140	1430	1070	860	710	610	530	430	360	270		
10	0.5D	1.5D	SFM(Vc)	110	110	110	110	110	110	110	110	110	110		
			IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050		
			RPM	3360	2240	1680	1340	1120	960	840	670	560	420		
11.1	0.5D	1.5D	SFM(Vc)	70	70	70	70	70	70	70	70	70	70		
			IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050		
			RPM	2140	1430	1070	860	710	610	530	430	360	270		
M	12-14.2	Stainless steel	0.05D	1.0D	SFM(Vc)	60	60	60	60	60	60	60	60	60	60
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	1830	1220	920	730	610	520	460	370	310	230
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.5D	1.5D	SFM(Vc)	90	90	90	90	90	90	90	90	90	90
					IPT(fz)	.0009	.0012	.0017	.0022	.0025	.0030	.0035	.0037	.0045	.0050
					RPM	2750	1830	1380	1100	920	790	690	550	460	340
			0.5D	1.5D	IPM(Feed)	9	8	9	9	8	9	9	7	8	6
					IPM(Feed)	7	7	7	7	7	7	7	6	6	5
					IPM(Feed)	6	5	5	6	5	5	6	5	5	4



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