



Being the best through innovation



**SOLID CARBIDE**

**D-POWER GRAPHITE  
END MILLS**

- For Graphites

# D-POWER GRAPHITE END MILLS

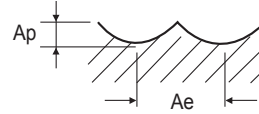
## RECOMMENDED CUTTING CONDITIONS

### E106 SERIES

### 4 FLUTE BALL NOSE - SURFACING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						5/64	3/32	1/8	9/64	5/32	3/16	1/4	5/16	3/8	1/2
N	29.2	Non Metallic Materials	0.2D	0.2D	SFM (Vc)	325	395	525	590	655	760	980	1065	1130	1375
					IPT (fz)	.0010	.0014	.0018	.0021	.0026	.0032	.0039	.0045	.0070	.0059
					RPM	15890	16090	16040	16030	16010	15480	14970	13020	11510	10510
					IPM (FEED)	63	88	114	138	165	201	232	236	324	248

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute

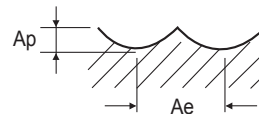


### E1099, E1971, E1972 SERIES

### 2 FLUTE BALL NOSE - SURFACING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						5/64	3/32	1/8	9/64	5/32	3/16	1/4	5/16	3/8	1/2
N	29.2	Non Metallic Materials	0.2D	0.2D	SFM (Vc)	325	395	525	590	655	760	980	1065	1130	1375
					IPT (fz)	.0010	.0014	.0018	.0018	.0026	.0032	.0039	.0045	.0052	.0059
					RPM	15890	16090	16040	16030	16010	15480	14970	13020	11510	10510
					IPM (FEED)	32	44	57	59	83	100	116	118	120	124

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute

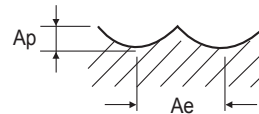


### E1B07 SERIES

### 4 FLUTE BALL NOSE - SURFACING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)															
						1/32	3/64	1/16	5/64	3/32	1/8	9/64	5/32	3/16	1/4	5/16	3/8	1/2			
N	29.2	Non Metallic Materials	0.2D	0.2D	SFM (Vc)	165	245	325	325	395	525	590	655	760	980	1065	1130	1375			
					IPT (fz)	.0005	.0005	.0007	.0009	.0012	.0016	.0019	.0023	.0029	.0035	.0041	.0047	.0053			
					RPM	20170	19970	19860	15890	16090	16040	16030	16010	15480	14970	13020	11510	10510			
					IPM (FEED)	38	43	52	57	79	102	125	147	182	211	212	217	225			

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute

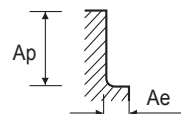


### E1B05 SERIES

### 4 FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						1/16	5/64	1/8	5/32	3/16	1/4	5/16	3/8	1/2
N	29.2	Non Metallic Materials	0.3D	0.3D	SFM (Vc)	655	820	1310	1635	1965	2620	2620	2550	2750
					IPT (fz)	.0008	.0010	.0014	.0020	.0024	.0028	.0034	.0043	.0051
					RPM	40030	40090	40030	39970	40030	40030	32030	25980	21010
					IPM (FEED)	126	158	221	315	378	441	441	451	431

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute



# D-POWER GRAPHITE END MILLS

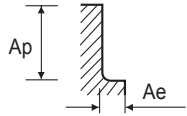
## RECOMMENDED CUTTING CONDITIONS

### EIB06 SERIES

#### 4 FLUTE CORNER RADIUS - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)										
						1/32	3/64	1/16	5/64	1/8	5/32	3/16	1/4	5/16	3/8	1/2
N	29.2	Non Metallic Materials	0.3D	0.3D	SFM (Vc)	325	490	655	820	1310	1635	1965	2620	2620	230	2750
					IPT (fz)	.0003	.0004	.0006	.0007	.0010	.0014	.0017	.0019	.0024	.0030	.0036
					RPM	39730	39930	40030	40090	40030	39970	40030	40030	32030	26070	21010
					IPM (FEED)	44	66	88	110	154	221	265	309	309	316	301

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute

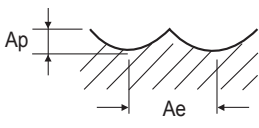


### EI880, EI451, EI450 SERIES

#### 2 FLUTE BALL NOSE - SURFACING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						2	2.5	3	3.5	4	5	6	8	10	12
N	29.2	Non Metallic Materials	0.2D	0.2D	SFM (Vc)	330	410	495	575	660	800	930	1070	1185	1300
					IPT (fz)	.0010	.0014	.0018	.0022	.0026	.0032	.0039	.0046	.0052	.0059
					RPM	16010	15910	16010	15940	16010	15520	15040	12980	11500	10510
					IPM (FEED)	32	44	57	69	83	100	116	118	120	124

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute

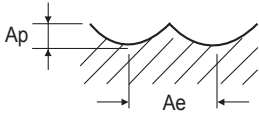


### EI881 SERIES

#### 3 FLUTE BALL NOSE - SURFACING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						2	2.5	3	3.5	4	5	6	8	10	12
N	29.2	Non Metallic Materials	0.2D	0.2D	SFM (Vc)	330	410	495	575	660	800	930	1070	1185	1300
					IPT (fz)	.0010	.0014	.0018	.0022	.0025	.0032	.0039	.0046	.0053	.0059
					RPM	16010	15910	16010	15940	16010	15520	15040	12980	11500	10510
					IPM (FEED)	47	67	85	104	122	150	175	177	181	187

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute



### EI107 SERIES

#### 4 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)						
						1/64	1/8	3/16	1/4	5/16	3/8	1/2
N	29.2	Non Metallic Materials	0.3D	0.3D	SFM (Vc)	165	1310	1965	2620	2620	2550	2620
					IPT (fz)	.0002	.0004	.0008	.0012	.0015	.0020	.0024
					RPM	40340	40030	40030	40030	32030	25980	20020
					IPM (FEED)	32	63	126	189	197	205	189

SFM = Surface Feet per Minute  
 RPM = Revolutions Per Minute  
 IPT = Inches Per Tooth  
 IPM = Inches Per Minute

