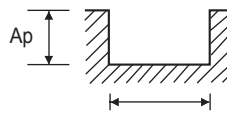


EH917, EH921 SERIES MULTI FLUTE - **SLOTTING**

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	16.0	20.0			
P	1-4	Non-alloy steel	1.0D	0.5D	SFM(Vc)	965	960	950	990	990	990			
					IPT(fz)	.0009	.0012	.0015	.0018	.0019	.0018			
	RPM				15600	11620	9200	8010	6010	4810				
	IPM(Feed)				54	55	55	57	57	51				
	5				Low alloy steel	1.0D	0.5D	SFM(Vc)	765	760	785	740	790	740
								IPT(fz)	.0004	.0006	.0006	.0008	.0007	.0006
	RPM	12410	9190	7610				6000	4800	3600				
	IPM(Feed)	20	20	19				19	18	14				
	6-7	High alloyed steel, and tool steel	1.0D	0.5D				SFM(Vc)	965	960	950	990	990	990
								IPT(fz)	.0009	.0012	.0015	.0018	.0019	.0018
	RPM				15600	11620	9200	8010	6010	4810				
	IPM(Feed)				54	55	55	57	57	51				
8-9	High alloyed steel, and tool steel				1.0D	0.5D	SFM(Vc)	765	760	785	740	790	740	
							IPT(fz)	.0004	.0006	.0006	.0008	.0007	.0006	
RPM		12410	9190	7610			6000	4800	3600					
IPM(Feed)		20	20	19			19	18	14					
10		Stainless steel	1.0D	0.5D			SFM(Vc)	965	960	950	990	990	990	
							IPT(fz)	.0009	.0012	.0015	.0018	.0019	.0018	
RPM	15600				11620	9200	8010	6010	4810					
IPM(Feed)	54				55	55	57	57	51					
11.1-11.2	Heat Resistant Super Alloys				1.0D	0.5D	SFM(Vc)	765	760	785	740	790	740	
							IPT(fz)	.0004	.0006	.0006	.0008	.0007	.0006	
RPM		12410	9190	7610			6000	4800	3600					
IPM(Feed)		20	20	19			19	18	14					
M		12-14.2	Titanium Alloys	1.0D			D4~10:0.25D D12~16:0.15D D18~25:0.1D	SFM(Vc)	520	520	525	520	545	495
								IPT(fz)	.0004	.0005	.0007	.0008	.0007	.0006
	RPM				8380	6290		5090	4190	3300	2400			
	IPM(Feed)				13	13		14	13	12	9			
S	31-35	Chilled Cast Iron	1.0D	0.05D	SFM(Vc)	150	150	135	145	130	135			
					IPT(fz)	.0005	.0006	.0009	.0010	.0006	.0006			
					RPM	2390	1790	1310	1190	800	650			
					IPM(Feed)	5	4	5	5	3	2			
H	40	Titanium Alloys	1.0D	D4~10:0.25D D12~16:0.15D D18~25:0.1D	SFM(Vc)	520	520	525	520	545	495			
					IPT(fz)	.0004	.0005	.0007	.0008	.0007	.0006			
					RPM	8380	6290	5090	4190	3300	2400			
					IPM(Feed)	13	13	14	13	12	9			

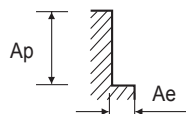


※ The Feed, in long & extra long types, should be reduced by around 50%.

EH917, EH921 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	16.0	20.0			
P	1-4	Non-alloy steel	0.3D	1.5D	SFM(Vc)	965	960	950	990	990	990			
					IPT(fz)	.0015	.0020	.0025	.0030	.0031	.0030			
	RPM				15600	11620	9200	8010	6010	4810				
	IPM(FEED)				91	91	91	95	95	85				
	5				Low alloy steel	0.3D	1.5D	SFM(Vc)	765	760	785	740	790	740
								IPT(fz)	.0007	.0009	.0011	.0013	.0013	.0010
	RPM	12410	9190	7610				6000	4800	3600				
	IPM(FEED)	33	33	34				31	30	22				
	6-7	High alloyed steel, and tool steel	0.3D	1.5D				SFM(Vc)	965	960	950	990	990	990
								IPT(fz)	.0015	.0020	.0025	.0030	.0031	.0030
	RPM				15600	11620	9200	8010	6010	4810				
	IPM(FEED)				91	91	91	95	95	85				
8-9	High alloyed steel, and tool steel				0.3D	1.5D	SFM(Vc)	765	760	785	740	790	740	
							IPT(fz)	.0007	.0009	.0011	.0013	.0013	.0010	
RPM		12410	9190	7610			6000	4800	3600					
IPM(FEED)		33	33	34			31	30	22					
10		High alloyed steel, and tool steel	0.3D	1.5D			SFM(Vc)	965	960	950	990	990	990	
							IPT(fz)	.0015	.0020	.0025	.0030	.0031	.0030	
RPM	15600				11620	9200	8010	6010	4810					
IPM(FEED)	91				91	91	95	95	85					
11.1-11.2	High alloyed steel, and tool steel				0.3D	1.5D	SFM(Vc)	765	760	785	740	790	740	
							IPT(fz)	.0007	.0009	.0011	.0013	.0013	.0010	
RPM		12410	9190	7610			6000	4800	3600					
IPM(FEED)		33	33	34			31	30	22					
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	545	495
								IPT(fz)	.0007	.0009	.0011	.0013	.0012	.0010
	RPM				8380	6290		5090	4190	3300	2400			
	IPM(FEED)				22	23		22	22	20	14			
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	SFM(Vc)	150	150	135	145	130	135			
					IPT(fz)	.0008	.0010	.0015	.0016	.0011	.0010			
					RPM	2390	1790	1310	1190	800	650			
					IPM(FEED)	8	7	8	8	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	545	495			
					IPT(fz)	.0007	.0009	.0011	.0013	.0012	.0010			
					RPM	8380	6290	5090	4190	3300	2400			
					IPM(FEED)	22	23	22	22	20	14			
H	40	Chilled Cast Iron	0.3D	1.5D	SFM(Vc)	765	760	785	740	790	740			
					IPT(fz)	.0007	.0009	.0011	.0013	.0013	.0010			
					RPM	12410	9190	7610	6000	4800	3600			
					IPM(FEED)	33	33	34	31	30	22			



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