YG

Being the best through innovation

SOLID CARBIDE

JET-POWER END MILLS

- Exotic materials like Stainless Steels, Nickel alloys and Titanium

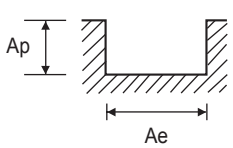
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

EH108 SERIES 3&4 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) 1/4	5/16	3/8	1/2	5/8	3/4	1
P	1-4	Non-alloy steel	1.0D	0.5D	SFM (Vc)	365	345	320	360	360	345	355
					IPT (fz)	.0007	.0011	.0012	.0012	.0012	.0010	.0008
					RPM	5560	4200	3260	2740	2200	1750	1360
					IPM (FEED)	12	13	12	10	8	7	5
	5		1.0D	0.5D	SFM (Vc)	220	205	195	220	225	215	220
					IPT (fz)	.0008	.0009	.0009	.0009	.0010	.0008	.0007
					RPM	3360	2520	2000	1680	1360	1100	840
					IPM (FEED)	8	7	6	5	4	3	2
	6-7	Low alloy steel	1.0D	0.5D	SFM (Vc)	365	345	320	360	360	345	355
					IPT (fz)	.0007	.0011	.0012	.0012	.0012	.0010	.0008
					RPM	5560	4200	3260	2740	2200	1750	1360
					IPM (FEED)	12	13	12	10	8	7	5
	8-9		1.0D	0.5D	SFM (Vc)	220	205	195	220	225	215	220
					IPT (fz)	.0008	.0009	.0009	.0009	.0010	.0008	.0007
					RPM	3360	2520	2000	1680	1360	1100	840
					IPM (FEED)	8	7	6	5	4	3	2
	10	High alloyed steel, and tool steel	1.0D	0.5D	SFM (Vc)	365	345	320	360	360	345	355
					IPT (fz)	.0007	.0011	.0012	.0012	.0012	.0010	.0008
					RPM	5560	4200	3260	2740	2200	1750	1360
					IPM (FEED)	12	13	12	10	8	7	5
	11.1-11.2		1.0D	0.5D	SFM (Vc)	220	205	195	220	225	215	220
					IPT (fz)	.0008	.0009	.0009	.0009	.0010	.0008	.0007
					RPM	3360	2520	2000	1680	1360	1100	840
					IPM (FEED)	8	7	6	5	4	3	2
M	12-14.2	Stainless steel	1.0D	0.05D	SFM (Vc)	185	170	165	180	170	175	175
					IPT (fz)	.0007	.0010	.0011	.0011	.0013	.0010	.0009
					RPM	2840	2100	1680	1370	1050	880	670
					IPM (FEED)	6	6	6	5	4	3	2
S	31-35	Heat Resistant Super Alloys	1.0D	0.05D	SFM (Vc)	75	70	65	75	70	70	70
					IPT (fz)	.0005	.0006	.0008	.0007	.0008	.0009	.0006
					RPM	1160	840	670	560	420	350	270
					IPM (FEED)	2	2	2	1	1	1	1
	36-37	Titanium Alloys	1.0D	0.05D	SFM (Vc)	100	90	85	95	90	95	90
					IPT (fz)	.0005	.0007	.0008	.0008	.0008	.0006	.0006
					RPM	1500	1090	870	730	550	480	350
					IPM (FEED)	2	2	2	2	1	1	1
H	40	Chilled Cast Iron	1.0D	0.5D	SFM (Vc)	220	205	195	220	225	215	220
					IPT (fz)	.0008	.0009	.0009	.0009	.0010	.0008	.0007
					RPM	3360	2520	2000	1680	1360	1100	840
					IPM (FEED)	8	7	6	5	4	3	2



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

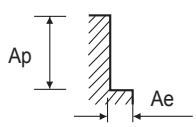
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

SFM(Vc) = ft./min.
IPT(fz) = in./tooth
RPM = rev./min.
IPM(Feed) = in./min.

EH108 SERIES — 3&4 FLUTE - SIDE CUTTING

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø) 1/4	5/16	3/8	1/2	5/8	3/4	1
P	1-4	Non-alloy steel	0.5D	1.5D	SFM (Vc)	365	345	320	360	360	345	355
					IPT (fz)	.0009	.0013	.0015	.0015	.0015	.0012	.0011
					RPM	5560	4200	3260	2740	2200	1750	1360
					IPM (FEED)	16	17	15	12	10	9	6
	5		0.5D	1.5D	SFM (Vc)	220	205	195	220	225	215	220
					IPT (fz)	.0010	.0012	.0012	.0012	.0012	.0010	.0009
					RPM	3360	2520	2000	1680	1360	1100	840
					IPM (FEED)	10	9	7	6	5	4	3
	6-7	Low alloy steel	0.5D	1.5D	SFM (Vc)	365	345	320	360	360	345	355
					IPT (fz)	.0009	.0013	.0015	.0015	.0015	.0012	.0011
					RPM	5560	4200	3260	2740	2200	1750	1360
					IPM (FEED)	16	17	15	12	10	9	6
	8-9		0.5D	1.5D	SFM (Vc)	220	205	195	220	225	215	220
					IPT (fz)	.0010	.0012	.0012	.0012	.0012	.0010	.0009
					RPM	3360	2520	2000	1680	1360	1100	840
					IPM (FEED)	10	9	7	6	5	4	3
	10	High alloyed steel, and tool steel	0.5D	1.5D	SFM (Vc)	365	345	320	360	360	345	355
					IPT (fz)	.0009	.0013	.0015	.0015	.0015	.0012	.0011
					RPM	5560	4200	3260	2740	2200	1750	1360
					IPM (FEED)	16	17	15	12	10	9	6
	11.1-11.2		0.5D	1.5D	SFM (Vc)	220	205	195	220	225	215	220
					IPT (fz)	.0010	.0012	.0012	.0012	.0012	.0010	.0009
					RPM	3360	2520	2000	1680	1360	1100	840
					IPM (FEED)	10	9	7	6	5	4	3
M	12-14.2	Stainless steel	0.5D	1.5D	SFM (Vc)	185	170	165	180	170	175	175
					IPT (fz)	.0010	.0014	.0017	.0017	.0017	.0015	.0017
					RPM	2840	2100	1680	1370	1050	880	670
					IPM (FEED)	8	9	9	7	5	5	5
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	SFM (Vc)	70	70	65	75	70	70	70
					IPT (fz)	.0007	.0008	.0010	.0011	.0011	.0009	.0009
					RPM	1050	840	680	560	420	350	270
					IPM (FEED)	2	2	2	2	1	1	1
	36-37	Titanium Alloys	0.05D	1.0D	SFM (Vc)	90	90	85	95	90	95	90
					IPT (fz)	.0007	.0009	.0011	.0012	.0012	.0008	.0010
					RPM	1360	1090	880	730	550	480	350
					IPM (FEED)	3	3	3	3	2	2	1
H	40	Chilled Cast Iron	0.5D	1.5D	SFM (Vc)	220	205	195	220	225	215	220
					IPT (fz)	.0010	.0012	.0012	.0012	.0012	.0010	.0009
					RPM	3360	2520	2000	1680	1360	1100	840
					IPM (FEED)	10	9	7	6	5	4	3



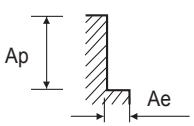
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

EE882 SERIES — 6FLUTE - 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)				
						3/4	7/8	1	1 1/4	1 1/2
P	1-4	Non-alloy steel	0.1D	1.5D	SFM (Vc)	190	165	170	170	170
					IPT (fz)	.0014	.0017	.0017	.0017	.0017
					RPM	960	730	640	520	430
					IPM (FEED)	8	7	7	5	4
	5		0.1D	1.5D	SFM (Vc)	40	40	45	45	40
					IPT (fz)	.0006	.0006	.0006	.0006	.0006
					RPM	215	180	165	130	105
					IPM (FEED)	1	1	1	1	1
	6-7	Low alloy steel	0.1D	1.5D	SFM (Vc)	190	165	170	170	170
					IPT (fz)	.0014	.0017	.0017	.0017	.0017
					RPM	960	730	640	520	430
					IPM (FEED)	8	7	7	5	4
	8-9		0.1D	1.5D	SFM (Vc)	40	40	45	45	40
					IPT (fz)	.0006	.0006	.0006	.0006	.0006
					RPM	215	180	165	130	105
					IPM (FEED)	1	1	1	1	1
	10	High alloyed steel, and tool steel	0.1D	1.5D	SFM (Vc)	190	165	170	170	170
					IPT (fz)	.0014	.0017	.0017	.0017	.0017
					RPM	960	730	640	520	430
					IPM (FEED)	8	7	7	5	4
	11.1-11.2		0.1D	1.5D	SFM (Vc)	40	40	45	45	40
					IPT (fz)	.0006	.0006	.0006	.0006	.0006
					RPM	215	180	165	130	105
					IPM (FEED)	1	1	1	1	1
M	12-14.2	Stainless steel	0.1D	1.5D	SFM (Vc)	95	85	85	85	85
					IPT (fz)	.0017	.0020	.0021	.0021	.0020
					RPM	480	365	320	260	215
					IPM (FEED)	5	4	4	3	3
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	SFM (Vc)	35	35	35	35	35
					IPT (fz)	.0010	.0009	.0009	.0010	.0010
					RPM	170	145	130	105	85
					IPM (FEED)	1	1	1	1	1
	36-37	Titanium Alloys	0.05D	1.0D	SFM (Vc)	45	45	45	45	45
					IPT (fz)	.0011	.0010	.0010	.0010	.0009
					RPM	220	190	170	140	110
					IPM (FEED)	1	1	1	1	1
H	40	Chilled Cast Iron	0.1D	1.5D	SFM (Vc)	40	40	45	45	40
					IPT (fz)	.0006	.0006	.0006	.0006	.0006
					RPM	215	180	165	130	105
					IPM (FEED)	1	1	1	1	1



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

JET-POWER END MILLS

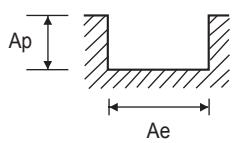
RECOMMENDED CUTTING CONDITIONS

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
					IPM (FEED)	9	8	9	9	8	9	9	7	8	6
	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
					IPM (FEED)	7	7	7	7	7	7	7	6	6	5
	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
					IPM (FEED)	6	5	5	6	5	5	6	5	5	4
	6	Low 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
					IPM (FEED)	9	8	9	9	8	9	9	7	8	6
	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
					IPM (FEED)	7	7	7	7	7	7	7	6	6	5
	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
					IPM (FEED)	6	5	5	6	5	5	6	5	5	4
	10	High alloyed steel, and tool 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
					IPM (FEED)	9	8	9	9	8	9	9	7	8	6
	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
					IPM (FEED)	6	5	5	6	5	5	6	5	5	4
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
					IPM (FEED)	5	4	5	5	5	5	5	4	4	3
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
					IPM (FEED)	7	7	7	7	7	7	7	6	6	5



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

JET-POWER END MILLS

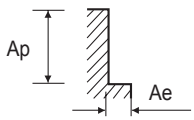
RECOMMENDED CUTTING CONDITIONS

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
					IPM (FEED)	9	8	9	9	8	9	9	7	8	6
	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
					IPM (FEED)	7	7	7	7	7	7	7	6	6	5
	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
					IPM (FEED)	6	5	5	6	5	5	6	5	5	4
	6	Low 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
					IPM (FEED)	9	8	9	9	8	9	9	7	8	6
	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
					IPM (FEED)	7	7	7	7	7	7	7	6	6	5
	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
					IPM (FEED)	6	5	5	6	5	5	6	5	5	4
	10	High alloyed steel, and tool 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
					IPM (FEED)	9	8	9	9	8	9	9	7	8	6
	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
					IPM (FEED)	6	5	5	6	5	5	6	5	5	4
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
					IPM (FEED)	5	4	5	5	5	5	5	4	4	3
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
					IPM (FEED)	7	7	7	7	7	7	7	6	6	5



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

JET-POWER END MILLS

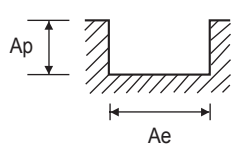
RECOMMENDED CUTTING CONDITIONS

EH094, EH095, EH969, EH970 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) 1/4	5/16	3/8	1/2	5/8	3/4	1
P	1-4	Non-alloy steel	1.0D	0.5D	SFM (Vc)	1020	950	905	1045	980	1020	1125
					IPT (fz)	.0015	.0020	.0025	.0030	.0032	.0029	.0033
					RPM	15600	11600	9200	8000	6000	5200	4300
					IPM (FEED)	91	91	91	95	95	91	85
	5		1.0D	0.5D	SFM (Vc)	810	755	745	785	785	865	840
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	12400	9200	7600	6000	4800	4400	3200
					IPM (FEED)	33	33	33	32	30	28	24
	6-7	Low alloy steel	1.0D	0.5D	SFM (Vc)	1020	950	905	1045	980	1020	1125
					IPT (fz)	.0015	.0020	.0025	.0030	.0032	.0029	.0033
					RPM	15600	11600	9200	8000	6000	5200	4300
					IPM (FEED)	91	91	91	95	95	91	85
	8-9		1.0D	0.5D	SFM (Vc)	810	755	745	785	785	865	840
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	12400	9200	7600	6000	4800	4400	3200
					IPM (FEED)	33	33	33	32	30	28	24
	10	High alloyed steel, and tool steel	1.0D	0.5D	SFM (Vc)	1020	950	905	1045	980	1020	1125
					IPT (fz)	.0015	.0020	.0025	.0030	.0032	.0029	.0033
					RPM	15600	11600	9200	8000	6000	5200	4300
					IPM (FEED)	91	91	91	95	95	91	85
	11.1-11.2		1.0D	0.5D	SFM (Vc)	810	755	745	785	785	865	840
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	12400	9200	7600	6000	4800	4400	3200
					IPM (FEED)	33	33	33	32	30	28	24
M	12-14.2	Stainless steel	1.0D	D1/4 ~ D3/8 : 0.25D D1/2 ~ D5/8 : 0.15D D3/4 ~ D1 : 0.1D	SFM (Vc)	550	515	500	550	540	490	565
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	8400	6300	5100	4200	3300	2500	2160
					IPM (FEED)	23	23	23	23	20	17	16
S	31-35	Heat Resistant Super Alloys	1.0D	0.05D	SFM (Vc)	155	145	130	155	130	135	155
					IPT (fz)	.0008	.0010	.0014	.0016	.0011	.0010	.0012
					RPM	2400	1800	1300	1200	800	675	600
					IPM (FEED)	8	7	8	8	4	4	4
	36-37	Titanium Alloys	1.0D	0.05D	SFM (Vc)	205	190	165	205	170	180	205
					IPT (fz)	.0008	.0010	.0015	.0016	.0011	.0010	.0011
					RPM	3150	2350	1700	1560	1040	910	780
					IPM (FEED)	11	10	10	10	6	6	5
H	40	Chilled Cast Iron	1.0D	0.5D	SFM (Vc)	810	755	745	785	785	865	840
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	12400	9200	7600	6000	4800	4400	3200
					IPM (FEED)	33	33	33	32	30	28	24



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

JET-POWER END MILLS

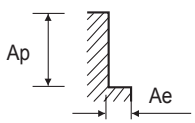
RECOMMENDED CUTTING CONDITIONS

EH094, EH095, EH969, EH970 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) 1/4	5/16	3/8	1/2	5/8	3/4	1
P	1-4	Non-alloy steel	0.3D	1.5D	SFM (Vc)	1020	950	905	1045	980	1020	1125
					IPT (fz)	.0015	.0020	.0025	.0030	.0032	.0029	.0033
					RPM	15600	11600	9200	8000	6000	5200	4300
					IPM (FEED)	91	91	91	95	95	91	85
	5		0.3D	1.5D	SFM (Vc)	810	755	745	785	785	865	840
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	12400	9200	7600	6000	4800	4400	3200
					IPM (FEED)	33	33	33	32	30	28	24
	6-7	Low alloy steel	0.3D	1.5D	SFM (Vc)	1020	950	905	1045	980	1020	1125
					IPT (fz)	.0015	.0020	.0025	.0030	.0032	.0029	.0033
					RPM	15600	11600	9200	8000	6000	5200	4300
					IPM (FEED)	91	91	91	95	95	91	85
	8-9		0.3D	1.5D	SFM (Vc)	810	755	745	785	785	865	840
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	12400	9200	7600	6000	4800	4400	3200
					IPM (FEED)	33	33	33	32	30	28	24
	10	High alloyed steel, and tool steel	0.3D	1.5D	SFM (Vc)	1020	950	905	1045	980	1020	1125
					IPT (fz)	.0015	.0020	.0025	.0030	.0032	.0029	.0033
					RPM	15600	11600	9200	8000	6000	5200	4300
					IPM (FEED)	91	91	91	95	95	91	85
	11.1-11.2		0.3D	1.5D	SFM (Vc)	810	755	745	785	785	865	840
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	12400	9200	7600	6000	4800	4400	3200
					IPM (FEED)	33	33	33	32	30	28	24
M	12-14.2	Stainless steel	D1/4 ~ D3/8 : 0.15D D1/2 ~ D5/8 : 0.1D D3/4 ~ D1 : 0.05D	1.5D	SFM (Vc)	550	515	500	550	540	490	565
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	8400	6300	5100	4200	3300	2500	2160
					IPM (FEED)	23	23	23	23	20	17	16
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	SFM (Vc)	155	145	130	155	130	135	155
					IPT (fz)	.0008	.0010	.0014	.0016	.0011	.0010	.0012
					RPM	2400	1800	1300	1200	800	675	600
					IPM (FEED)	8	7	8	8	4	4	4
	36-37	Titanium Alloys	0.05D	1.0D	SFM (Vc)	205	190	165	205	170	180	205
					IPT (fz)	.0008	.0010	.0015	.0016	.0011	.0010	.0011
					RPM	3150	2350	1700	1560	1040	910	780
					IPM (FEED)	11	10	10	10	6	6	5
H	40	Chilled Cast Iron	0.3D	1.5D	SFM (Vc)	810	755	745	785	785	865	840
					IPT (fz)	.0007	.0009	.0011	.0013	.0012	.0011	.0013
					RPM	12400	9200	7600	6000	4800	4400	3200
					IPM (FEED)	33	33	33	32	30	28	24



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

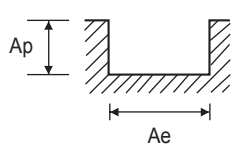
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

EH830 SERIES 3&4 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	18.0	20.0	25.0
P	1-4	Non-alloy steel	1.0D	0.5D	SFM (Vc)	345	345	330	345	360	360	345	345
					IPT (fz)	.0007	.0011	.0012	.0012	.0012	.0012	.0007	.0007
					RPM	5570	4180	3180	2790	2190	1950	1670	1340
					IPM (FEED)	13	13	12	10	8	7	6	4
	5		1.0D	0.5D	SFM (Vc)	215	215	215	215	230	230	215	215
					IPT (fz)	.0008	.0009	.0009	.0009	.0010	.0009	.0007	.0007
					RPM	3450	2590	2070	1720	1390	1240	1040	830
					IPM (FEED)	8	7	6	5	4	3	3	2
	6-7	Low alloy steel	1.0D	0.5D	SFM (Vc)	345	345	330	345	360	360	345	345
					IPT (fz)	.0007	.0011	.0012	.0012	.0012	.0012	.0007	.0007
					RPM	5570	4180	3180	2790	2190	1950	1670	1340
					IPM (FEED)	13	13	12	10	8	7	6	4
	8-9		1.0D	0.5D	SFM (Vc)	215	215	215	215	230	230	215	215
					IPT (fz)	.0008	.0009	.0009	.0009	.0010	.0009	.0007	.0007
					RPM	3450	2590	2070	1720	1390	1240	1040	830
					IPM (FEED)	8	7	6	5	4	3	3	2
	10	High alloyed steel, and tool steel	1.0D	0.5D	SFM (Vc)	345	345	330	345	360	360	345	345
					IPT (fz)	.0007	.0011	.0012	.0012	.0012	.0012	.0007	.0007
					RPM	5570	4180	3180	2790	2190	1950	1670	1340
					IPM (FEED)	13	13	12	10	8	7	6	4
	11.1-11.2		1.0D	0.5D	SFM (Vc)	215	215	215	215	230	230	215	215
					IPT (fz)	.0008	.0009	.0009	.0009	.0010	.0009	.0007	.0007
					RPM	3450	2590	2070	1720	1390	1240	1040	830
					IPM (FEED)	8	7	6	5	4	3	3	2
M	12-14.2	Stainless steel	1.0D	0.5D	SFM (Vc)	180	180	180	165	180	180	180	180
					IPT (fz)	.0007	.0010	.0011	.0011	.0013	.0012	.0008	.0009
					RPM	2920	2190	1750	1330	1090	970	880	700
					IPM (FEED)	7	6	6	5	4	3	3	2
S	31-35	Heat Resistant Super Alloys	1.0D	0.05D	SFM (Vc)	65	65	65	65	65	65	65	65
					IPT (fz)	.0004	.0006	.0008	.0007	.0008	.0007	.0006	.0005
					RPM	1060	800	640	530	400	350	320	260
					IPM (FEED)	1	1	1	1	1	1	1	1
	36-37	Titanium Alloys	1.0D	0.05D	SFM (Vc)	175	175	175	170	175	175	175	175
					IPT (fz)	.0007	.0010	.0011	.0011	.0012	.0012	.0008	.0009
					RPM	2840	2100	1680	1370	1050	950	840	670
					IPM (FEED)	6	6	6	5	4	3	3	2
H	40	Chilled Cast Iron	1.0D	0.5D	SFM (Vc)	215	215	215	215	230	230	215	215
					IPT (fz)	.0008	.0009	.0009	.0009	.0010	.0009	.0007	.0007
					RPM	3450	2590	2070	1720	1390	1240	1040	830
					IPM (FEED)	8	7	6	5	4	3	3	2



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

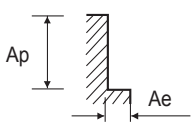
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

EH830 SERIES 3&4 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	18.0	20.0	25.0
P	1-4	Non-alloy steel	0.5D	1.5D	SFM (Vc)	345	345	330	345	360	360	345	345
					IPT (fz)	.0009	.0013	.0015	.0015	.0015	.0015	.0011	.0011
					RPM	5570	4180	3180	2790	2190	1950	1670	1340
					IPM (FEED)	16	16	14	13	10	9	7	6
	5		0.5D	1.5D	SFM (Vc)	215	215	215	215	230	230	215	215
					IPT (fz)	.0010	.0012	.0012	.0012	.0011	.0012	.0009	.0009
					RPM	3450	2590	2070	1720	1390	1240	1040	830
					IPM (FEED)	10	9	7	6	5	4	4	3
	6-7	Low alloy steel	0.5D	1.5D	SFM (Vc)	345	345	330	345	360	360	345	345
					IPT (fz)	.0009	.0013	.0015	.0015	.0015	.0015	.0011	.0011
					RPM	5570	4180	3180	2790	2190	1950	1670	1340
					IPM (FEED)	16	16	14	13	10	9	7	6
	8-9		0.5D	1.5D	SFM (Vc)	215	215	215	215	230	230	215	215
					IPT (fz)	.0010	.0012	.0012	.0012	.0011	.0012	.0009	.0009
					RPM	3450	2590	2070	1720	1390	1240	1040	830
					IPM (FEED)	10	9	7	6	5	4	4	3
	10	High alloyed steel, and tool steel	0.5D	1.5D	SFM (Vc)	345	345	330	345	360	360	345	345
					IPT (fz)	.0009	.0013	.0015	.0015	.0015	.0015	.0011	.0011
					RPM	5570	4180	3180	2790	2190	1950	1670	1340
					IPM (FEED)	16	16	14	13	10	9	7	6
	11.1-11.2		0.5D	1.5D	SFM (Vc)	215	215	215	215	230	230	215	215
					IPT (fz)	.0010	.0012	.0012	.0012	.0011	.0012	.0009	.0009
					RPM	3450	2590	2070	1720	1390	1240	1040	830
					IPM (FEED)	10	9	7	6	5	4	4	3
M	12-14.2	Stainless steel	0.5D	1.5D	SFM (Vc)	180	180	180	165	180	180	180	180
					IPT (fz)	.0011	.0017	.0018	.0017	.0019	.0018	.0013	.0013
					RPM	2920	2190	1750	1330	1090	970	880	700
					IPM (FEED)	10	11	10	7	6	5	5	4
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	SFM (Vc)	65	65	65	65	65	65	65	65
					IPT (fz)	.0007	.0008	.0010	.0011	.0011	.0011	.0009	.0009
					RPM	1060	800	640	530	400	350	320	260
					IPM (FEED)	2	2	2	2	1	1	1	1
	36-37	Titanium Alloys	0.05D	1.0D	SFM (Vc)	180	180	180	165	180	180	180	180
					IPT (fz)	.0011	.0017	.0018	.0017	.0019	.0018	.0013	.0013
					RPM	2920	2190	1750	1330	1090	970	880	700
					IPM (FEED)	10	11	10	7	6	5	5	4
H	40	Chilled Cast Iron	0.5D	1.5D	SFM (Vc)	215	215	215	215	230	230	215	215
					IPT (fz)	.0010	.0012	.0012	.0012	.0011	.0012	.0009	.0009
					RPM	3450	2590	2070	1720	1390	1240	1040	830
					IPM (FEED)	10	9	7	6	5	4	4	3



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

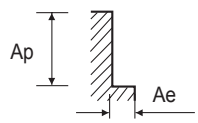
JET-POWER END MILLS

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
					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		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		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		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%.

JET-POWER END MILLS

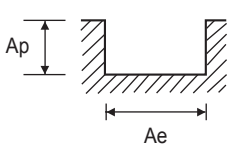
RECOMMENDED CUTTING CONDITIONS

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
P	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		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		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		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
M	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
S	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
H	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%.

JET-POWER END MILLS

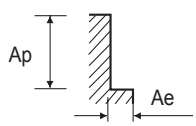
RECOMMENDED CUTTING CONDITIONS

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		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		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		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
	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%.

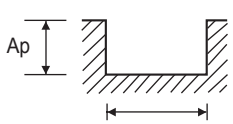
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

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		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	Low 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
	8-9		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	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
	11.1-11.2		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	Stainless steel	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	Heat Resistant Super Alloys	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
	36-37	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
H	40	Chilled Cast Iron	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



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

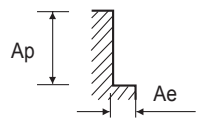
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

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		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	Low 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
	8-9		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		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
	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%.

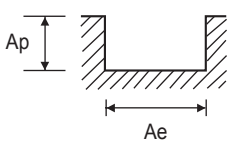
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

EH919 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) 4.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0	25.0
P	1-4	Non-alloy steel	1.0D	0.5D	SFM(Vc)	965	965	960	950	990	980	990	990	1110
					IPT(fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
					IPM(FEED)	55	54	55	55	57	56	57	51	51
	5		1.0D	0.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825
					IPT(fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM(FEED)	20	20	20	19	19	19	18	14	14
	6-7	Low alloy steel	1.0D	0.5D	SFM(Vc)	965	965	960	950	990	980	990	990	1110
					IPT(fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
					IPM(FEED)	55	54	55	55	57	56	57	51	51
	8-9		1.0D	0.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825
					IPT(fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM(FEED)	20	20	20	19	19	19	18	14	14
	10	High alloyed steel, and tool steel	1.0D	0.5D	SFM(Vc)	965	965	960	950	990	980	990	990	1110
					IPT(fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
					IPM(FEED)	55	54	55	55	57	56	57	51	51
	11.1-11.2		1.0D	0.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825
					IPT(fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM(FEED)	20	20	20	19	19	19	18	14	14
M	12-14.2	Stainless steel	1.0D	D4~10:0.25D D12~16:0.15D D18~25:0.1D	SFM(Vc)	520	520	520	525	520	520	545	495	560
					IPT(fz)	.0004	.0004	.0005	.0007	.0008	.0007	.0007	.0006	.0007
					RPM	12570	8380	6290	5090	4190	3590	3300	2400	2170
					IPM(FEED)	13	13	13	14	13	13	12	9	10
S	31-35	Heat Resistant Super Alloys	1.0D	0.05D	SFM(Vc)	150	150	150	135	145	130	130	135	155
					IPT(fz)	.0004	.0005	.0006	.0009	.0010	.0007	.0006	.0006	.0007
					RPM	3580	2390	1790	1310	1190	910	800	650	600
					IPM(FEED)	5	5	4	5	5	3	3	2	3
	36-37	Titanium Alloys	1.0D	D4~10:0.25D D12~16:0.15D D18~25:0.1D	SFM(Vc)	520	520	520	525	520	520	545	495	560
					IPT(fz)	.0004	.0004	.0005	.0007	.0008	.0007	.0007	.0006	.0007
					RPM	12570	8380	6290	5090	4190	3590	3300	2400	2170
					IPM(FEED)	13	13	13	14	13	13	12	9	10
H	40	Chilled Cast Iron	1.0D	0.5D	SFM(Vc)	770	765	760	785	740	750	790	740	825
					IPT(fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM(FEED)	20	20	20	19	19	19	18	14	14



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

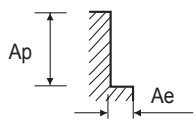
JET-POWER END MILLS

RECOMMENDED CUTTING CONDITIONS

EH919 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) 4.0	6.0	8.0	10.0	12.0	14.0	16.0	20.0	25.0
P	1	Non-alloy steel	0.3D	1.5D	SFM (Vc)	965	965	960	950	990	980	990	990	1110
					IPT (fz)	.0013	.0015	.0020	.0025	.0030	.0028	.0031	.0030	.0033
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
					IPM (FEED)	91	91	91	91	95	95	95	85	84
	2-4		0.3D	1.5D	SFM (Vc)	965	965	960	950	990	980	990	990	1110
					IPT (fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
					IPM (FEED)	55	54	55	55	57	56	57	51	51
	5		0.3D	1.5D	SFM (Vc)	770	765	760	785	740	750	790	740	825
					IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0013	.0010	.0013
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM (FEED)	33	33	33	34	31	33	30	22	24
	6-7	Low alloy steel	0.3D	1.5D	SFM (Vc)	965	965	960	950	990	980	990	990	1110
					IPT (fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
					IPM (FEED)	55	54	55	55	57	56	57	51	51
	8-9		0.3D	1.5D	SFM (Vc)	770	765	760	785	740	750	790	740	825
					IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0013	.0010	.0013
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM (FEED)	33	33	33	34	31	33	30	22	24
	10	High alloyed steel, and tool steel	0.3D	1.5D	SFM (Vc)	965	965	960	950	990	980	990	990	1110
					IPT (fz)	.0008	.0009	.0012	.0015	.0018	.0017	.0019	.0018	.0020
					RPM	23400	15600	11620	9200	8010	6800	6010	4810	4300
					IPM (FEED)	55	54	55	55	57	56	57	51	51
	11.1-11.2		0.3D	1.5D	SFM (Vc)	770	765	760	785	740	750	790	740	825
					IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0013	.0010	.0013
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM (FEED)	33	33	33	34	31	33	30	22	24
M	12-14.2	Stainless steel	D4~10:0.15D D12~16:0.1D D18~25:0.05D	1.5D	SFM (Vc)	520	520	520	525	520	520	545	495	560
					IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0012	.0010	.0013
					RPM	12570	8380	6290	5090	4190	3590	3300	2400	2170
					IPM (FEED)	22	22	23	22	22	23	20	14	16
S	31-35	Heat Resistant Super Alloys	0.05D	1.0D	SFM (Vc)	150	150	150	135	145	130	130	135	155
					IPT (fz)	.0007	.0008	.0010	.0015	.0016	.0011	.0011	.0010	.0012
					RPM	3580	2390	1790	1310	1190	910	800	650	600
					IPM (FEED)	8	8	7	8	8	5	4	4	4
	36-37	Titanium Alloys	D4~10:0.15D D12~16:0.1D D18~25:0.05D	1.0D	SFM (Vc)	520	520	520	525	520	520	545	495	560
					IPT (fz)	.0006	.0007	.0009	.0011	.0013	.0013	.0012	.0010	.0013
					RPM	12570	8380	6290	5090	4190	3590	3300	2400	2170
					IPM (FEED)	22	22	23	22	22	23	20	14	16
H	40	Chilled Cast Iron	0.3D	1.5D	SFM (Vc)	770	765	760	785	740	750	790	740	825
					IPT (fz)	.0004	.0004	.0006	.0006	.0008	.0007	.0007	.0006	.0007
					RPM	18620	12410	9190	7610	6000	5210	4800	3600	3200
					IPM (FEED)	20	20	20	19	19	19	18	14	14



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