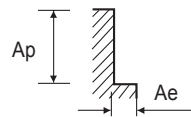


**EE882** SERIES

**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	Non-alloy steel	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	Low alloy steel	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	High alloyed steel, and tool steel	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%.

HSS

CBN END MILLS

i-Xmill END MILLS

i-SMART MODULAR END MILLS

X5070 END MILLS

4G MILL END MILLS

X-POWER PRO END MILLS

TitaNox-POWER END MILLS

JET-POWER END MILLS

V7 PLUS A END MILLS

V7 MILL INOX

ALU-POWER HPC END MILLS

ALU-POWER END MILLS

D-POWER GRAPHITE END MILLS

STANDARD CARBIDE

ONLY ONE COATED PM60 END MILLS

SINE-POWER

TANK-POWER END MILLS

STANDARD COBALT & HSS

TECHNICAL DATA