

**3-6 FLUTE FINE PITCH ROUGHER, 45° HELIX**  
EH919, & EH920 Series

**CUTTING DATA**  
Slotting & Side Cutting

Long Length

MATERIAL	CARBON STEEL, ALLOY STEEL & TOOL STEEL								STAINLESS STEEL				INCONEL			
	~ HRc30				HRc30 ~ HRc45				TITANIUM ALLOY							
Hardness	~ 1000N/mm <sup>2</sup>				1000 ~ 1500N/mm <sup>2</sup>											
Strength																
Dia.	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz	RPM	Feed	Vc	Fz
<b>SLOTTING</b>																
4	23400	1390	294	0.020	18600	500	234	0.009	12600	340	158	0.009	3600	115	45	0.011
6	15600	1390	294	0.022	12400	500	234	0.010	8400	340	158	0.010	2400	115	45	0.012
8	11600	1390	292	0.030	9200	500	231	0.014	6300	340	158	0.013	1800	110	45	0.015
10	9200	1390	289	0.038	7600	500	239	0.016	5100	340	160	0.017	1300	115	41	0.022
12	8000	1440	302	0.045	6000	480	226	0.020	4200	340	158	0.020	1200	115	45	0.024
14	6800	1440	299	0.042	5200	500	229	0.019	3600	340	158	0.019	900	80	40	0.018
16	6000	1440	302	0.048	4800	460	241	0.019	3300	310	166	0.019	800	65	40	0.016
20	4800	1300	302	0.045	3600	340	226	0.016	2400	220	151	0.015	660	60	41	0.015
25	4300	1290	338	0.050	3200	370	251	0.019	2160	250	170	0.019	600	65	47	0.018
<b>SIDE CUTTING</b>																
4	23400	2320	294	0.033	18600	840	234	0.015	12600	570	158	0.015	3600	190	45	0.018
6	15600	2320	294	0.037	12400	840	234	0.017	8400	570	158	0.017	2400	190	45	0.020
8	11600	2320	292	0.050	9200	840	231	0.023	6300	570	158	0.023	1800	180	45	0.025
10	9200	2320	289	0.063	7600	840	239	0.028	5100	570	160	0.028	1300	190	41	0.037
12	8000	2400	302	0.075	6000	800	226	0.033	4200	570	158	0.034	1200	190	45	0.040
14	6800	2400	299	0.071	5200	840	229	0.032	3600	570	158	0.032	900	130	40	0.029
16	6000	2400	302	0.080	4800	760	241	0.032	3300	510	166	0.031	800	110	40	0.028
20	4800	2160	302	0.075	3600	560	226	0.026	2400	360	151	0.025	660	100	41	0.025
25	4300	2150	338	0.083	3200	620	251	0.032	2160	410	170	0.032	600	110	47	0.031

NOTE: For long & extra long types the feed should be reduced by around 50%.



**ON ORDERS OVER £75 PLACED BEFORE 6PM**

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\*Exclusions apply.

RPM: revolutions per minute Feed: mm per minute Vc: surface speed (metres per minute) Fz: feed per tooth