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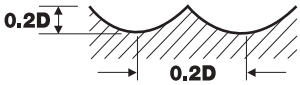
2 FLUTE BALL NOSE WITH NECK

EI880, EI450 & EI451 Series

CUTTING DATA

Slotting

MATERIAL		GRAPHITE			
Hardness		-			
Strength		-			
Dia.	Rad.	RPM	Feed	Vc	Fz
2	1	16000	800	100	0.025
2.5	1.25	16000	1120	125	0.035
3	1.5	16000	1450	150	0.045
3.5	1.75	16000	1750	175	0.055
4	2	16000	2100	200	0.066
5	2.5	15500	2550	245	0.082
6	3	15000	2950	285	0.098
8	4	13000	3000	325	0.115
10	5	11500	3050	360	0.133
12	6	10500	3150	395	0.150



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

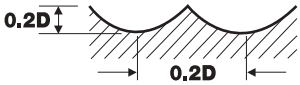
2 FLUTE MINIATURE BALL NOSE WITH NECK
2 FLUTE BALL NOSE WITH TAPER NECK

EI997, EIB93 & EIB87 Series

CUTTING DATA

Slotting

MATERIAL		GRAPHITE			
Hardness		-			
Strength		-			
Dia.	Rad.	RPM	Feed	Vc	Fz
0.4	0.2	40000	600	50	0.008
0.6	0.3	40000	800	75	0.010
0.8	0.4	40000	960	100	0.012
1	0.5	40000	1200	125	0.015
1.2	0.6	40000	1440	150	0.018
1.5	0.75	40000	1600	190	0.020
2	1	40000	2000	250	0.025
3	1.5	27000	2200	255	0.041
4	2	20000	2900	250	0.073
5	2.5	16000	2900	250	0.091
6	3	14000	2900	265	0.104



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