

2 FLUTE WITH NECK

EIB04 Series

CUTTING DATA

Side Cutting

MATERIAL	GRAPHITE			
Hardness	-			
Strength	-			
Dia.	RPM	Feed	Vc	Fz
0.4	40000	200	50	0.003
0.6	40000	350	75	0.004
0.8	40000	550	100	0.007
1	40000	700	125	0.009
1.5	40000	800	190	0.010
2	25000	800	155	0.016
3	20000	800	190	0.020
4	18000	950	225	0.026
5	14000	1200	220	0.043
6	11000	1400	205	0.064
8	8000	1300	200	0.081
10	6500	1200	205	0.092
12	5500	1200	205	0.109

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

2 FLUTE CORNER RADIUS WITH NECK & TAPER NECK

EI996 & EIB86 Series

CUTTING DATA

Slotting

MATERIAL	GRAPHITE			
Hardness	-			
Strength	-			
Dia.	RPM	Feed	Vc	Fz
0.4	40000	640	50	0.008
0.6	40000	640	75	0.008
0.8	40000	800	100	0.010
1	40000	960	125	0.012
1.2	40000	1200	150	0.015
1.5	40000	1440	190	0.018
2	40000	1600	250	0.020
3	27000	1900	255	0.035
4	20000	2300	250	0.058
5	16000	2300	250	0.072
6	14000	2300	265	0.082

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