

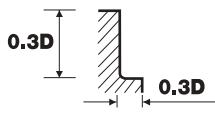
3 FLUTE CORNER RADIUS 40° HELIX

EIA13 & EIA14 Series

CUTTING DATA

Side Cutting

MATERIAL	GRAPHITE			
Hardness	-			
Strength	-			
Dia.	RPM	Feed	Vc	Fz
2	40000	3000	250	0.025
3	40000	4200	375	0.035
4	40000	6000	505	0.050
5	40000	7200	630	0.060
6	40000	8400	755	0.070
8	32000	8400	805	0.088
10	26000	8600	815	0.110
12	21000	8200	790	0.130



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

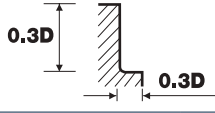
4 FLUTE CORNER RADIUS WITH NECK

EIB88 Series

CUTTING DATA

Side Cutting

MATERIAL	GRAPHITE			
Hardness	-			
Strength	-			
Dia.	RPM	Feed	Vc	Fz
6	40000	5600	755	0.035
8	32000	5600	805	0.044
10	26000	5700	815	0.055
12	21000	5450	790	0.065



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