

EH128, EH129, EH130,

EHK37, EHK38, EHK39 SERIES

2&3&4 FLUTE - CHAMFERING



Vc = m/min.
fz = mm/tooth
RPM = rev./min.
FEED = mm/min.

ISO	VDI 3323	Material Description	Parameter	Diameter (Ø)								
				3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1-2	Non-alloy steel	Vc	96	102	102	96	96	108	114	108	114
			fz	0.013	0.017	0.022	0.030	0.042	0.050	0.061	0.090	0.105
			RPM	10185	8115	6495	5095	3820	3440	3025	2150	1815
			FEED	270	270	280	305	320	345	370	385	380
	3-4		Vc	60	66	66	66	66	66	72	78	72
			fz	0.013	0.017	0.021	0.030	0.040	0.050	0.068	0.084	0.107
			RPM	6365	5250	4200	3500	2625	2100	1910	1550	1145
			FEED	170	175	180	210	210	210	260	260	245
	5		Vc	54	60	60	60	54	66	66	66	66
			fz	0.013	0.015	0.020	0.028	0.042	0.045	0.060	0.076	0.100
			RPM	5730	4775	3820	3185	2150	2100	1750	1315	1050
			FEED	150	145	150	180	180	190	210	200	210
	6	Low alloy steel	Vc	96	102	102	96	96	108	114	108	114
			fz	0.013	0.017	0.022	0.030	0.042	0.050	0.061	0.090	0.105
			RPM	10185	8115	6495	5095	3820	3440	3025	2150	1815
			FEED	270	270	280	305	320	345	370	385	380
	7		Vc	60	66	66	66	66	66	72	78	72
			fz	0.013	0.017	0.021	0.030	0.040	0.050	0.068	0.084	0.107
			RPM	6365	5250	4200	3500	2625	2100	1910	1550	1145
			FEED	170	175	180	210	210	210	260	260	245
	8-9		Vc	54	60	60	60	54	66	66	66	66
			fz	0.013	0.015	0.020	0.028	0.042	0.045	0.060	0.076	0.100
			RPM	5730	4775	3820	3185	2150	2100	1750	1315	1050
			FEED	150	145	150	180	180	190	210	200	210
	10	High alloyed steel, and tool steel	Vc	96	102	102	96	96	108	114	108	114
fz			0.013	0.017	0.022	0.030	0.042	0.050	0.061	0.090	0.105	
RPM			10185	8115	6495	5095	3820	3440	3025	2150	1815	
FEED			270	270	280	305	320	345	370	385	380	
11.1	Vc		54	60	60	60	54	66	66	66	66	
	fz		0.013	0.015	0.020	0.028	0.042	0.045	0.060	0.076	0.100	
	RPM		5730	4775	3820	3185	2150	2100	1750	1315	1050	
	FEED		150	145	150	180	180	190	210	200	210	
M	14.1	Stainless steel	Vc	30	35	40	35	40	45	45	45	40
			fz	0.008	0.01	0.013	0.018	0.024	0.027	0.036	0.046	0.069
			RPM	3183	2785	2546	1857	1592	1432	1194	895	637
			FEED	51	56	66	67	76	77	86	82	88
K	15	Grey cast iron	Vc	80	85	85	80	80	90	95	90	95
			fz	0.008	0.010	0.013	0.018	0.025	0.030	0.037	0.054	0.063
			RPM	8488	6764	5411	4244	3183	2865	2520	1790	1512
			FEED	136	135	141	153	159	172	186	193	191
	16		Vc	50	55	55	55	55	55	60	65	60
			fz	0.008	0.010	0.013	0.018	0.024	0.030	0.041	0.050	0.064
			RPM	5305	4377	3501	2918	2188	1751	1592	1293	955
			FEED	85	88	91	105	105	105	131	129	122
	17	Nodular cast iron	Vc	80	85	85	80	80	90	95	90	95
			fz	0.008	0.010	0.013	0.018	0.025	0.030	0.037	0.054	0.063
			RPM	8488	6764	5411	4244	3183	2865	2520	1790	1512
			FEED	136	135	141	153	159	172	186	193	191
	18		Vc	50	55	55	55	55	55	60	65	60
			fz	0.008	0.010	0.013	0.018	0.024	0.030	0.041	0.050	0.064
			RPM	5305	4377	3501	2918	2188	1751	1592	1293	955
			FEED	85	88	91	105	105	105	131	129	122
19	Malleable cast iron	Vc	80	85	85	80	80	90	95	90	95	
		fz	0.008	0.010	0.013	0.018	0.025	0.030	0.037	0.054	0.063	
		RPM	8488	6764	5411	4244	3183	2865	2520	1790	1512	
		FEED	136	135	141	153	159	172	186	193	191	
20		Vc	50	55	55	55	55	55	60	65	60	
		fz	0.008	0.010	0.013	0.018	0.024	0.030	0.041	0.050	0.064	
		RPM	5305	4377	3501	2918	2188	1751	1592	1293	955	
		FEED	85	88	91	105	105	105	131	129	122	
N	21~22	Aluminum-wrought alloy	Vc	185	210	210	205	205	225	230	230	230
			fz	0.008	0.01	0.013	0.019	0.03	0.037	0.045	0.05	0.064
			RPM	19629	16711	13369	10876	8157	7162	6101	4576	3661
			FEED	314	334	348	413	489	530	549	458	469
23~25	Aluminum-cast, alloyed	Vc	185	210	210	205	205	225	230	230	230	
		fz	0.008	0.01	0.013	0.019	0.03	0.037	0.045	0.05	0.064	
		RPM	19629	16711	13369	10876	8157	7162	6101	4576	3661	
		FEED	314	334	348	413	489	530	549	458	469	
S	36-37	Titanium Alloys	Vc	30	35	40	35	40	45	45	45	40
			fz	0.008	0.01	0.013	0.018	0.024	0.027	0.036	0.046	0.069
			RPM	3183	2785	2546	1857	1592	1432	1194	895	637
			FEED	51	56	66	67	76	77	86	82	88