



# JET-POWER END MILLS

## RECOmmENDED CUTTING CONDITIONS EmPFOHLENE SCHNEIDPARAMETER

### EH911, EH912 SERIES

### 2 FLUTE - **S**LOTTING

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)										
						2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0
P	1-4	Non-alloy steel	1.0D	0.5D (upto2302D)	Vc	75	85	95	100	105	105	100	105	110	105	105
					fz	0.008	0.012	0.02	0.025	0.031	0.045	0.051	0.051	0.05	0.051	0.048
	RPM		11937	9019	7560	6366	5570	4178	3183	2785	2188	1671	1337			
	FEED		191	216	302	318	345	376	325	284	219	170	128			
	5	Non-alloy steel	1.0D	0.5D (upto2302D)	Vc	50	50	60	60	65	65	65	65	70	65	65
					fz	0.008	0.013	0.019	0.025	0.033	0.04	0.04	0.039	0.04	0.038	0.042
	RPM		7958	5305	4775	3820	3448	2586	2069	1724	1393	1035	828			
	FEED		127	138	181	191	228	207	166	134	111	79	70			
	6-7	Low alloy steel	1.0D	0.5D (upto2302D)	Vc	75	85	95	100	105	105	100	105	110	105	105
					fz	0.008	0.012	0.02	0.025	0.031	0.045	0.051	0.051	0.05	0.051	0.048
	RPM		11937	9019	7560	6366	5570	4178	3183	2785	2188	1671	1337			
	FEED		191	216	302	318	345	376	325	284	219	170	128			
8-9	Low alloy steel	1.0D	0.5D (upto2302D)	Vc	50	50	60	60	65	65	65	65	70	65	65	
				fz	0.008	0.013	0.019	0.025	0.033	0.04	0.04	0.039	0.04	0.038	0.042	
RPM		7958	5305	4775	3820	3448	2586	2069	1724	1393	1035	828				
FEED		127	138	181	191	228	207	166	134	111	79	70				
10	High alloyed steel, and tool steel	1.0D	0.5D (upto2302D)	Vc	75	85	95	100	105	105	100	105	110	105	105	
				fz	0.008	0.012	0.02	0.025	0.031	0.045	0.051	0.051	0.05	0.051	0.048	
RPM		11937	9019	7560	6366	5570	4178	3183	2785	2188	1671	1337				
FEED		191	216	302	318	345	376	325	284	219	170	128				
11.1 - 11.2	High alloyed steel, and tool steel	1.0D	0.5D (upto2302D)	Vc	50	50	60	60	65	65	65	65	70	65	65	
				fz	0.008	0.013	0.019	0.025	0.033	0.04	0.04	0.039	0.04	0.038	0.042	
RPM		7958	5305	4775	3820	3448	2586	2069	1724	1393	1035	828				
FEED		127	138	181	191	228	207	166	134	111	79	70				
M	14.1	Stainlesssteel	1.0D	0.5D (upto2302D)	Vc	40	45	50	50	55	55	50	55	55	55	
					fz	0.007	0.013	0.019	0.025	0.032	0.043	0.048	0.048	0.052	0.048	0.044
S	36-37	Titanium Alloys	1.0D	0.5D (upto2302D)	RPM	6366	4775	3979	3183	2918	2188	1751	1326	1094	875	700
					FEED	89	124	151	159	187	188	168	127	114	84	62
H	40	Chilled Cast Iron	1.0D	0.5D (upto2302D)	Vc	50	50	60	60	65	65	65	65	70	65	65
					fz	0.008	0.013	0.019	0.025	0.033	0.04	0.04	0.039	0.04	0.038	0.042
H	40	Chilled Cast Iron	1.0D	0.5D (upto2302D)	RPM	7958	5305	4775	3820	3448	2586	2069	1724	1393	1035	828
					FEED	127	138	181	191	228	207	166	134	111	79	70

