

E2535, E2492 SERIES

2 FLUTE BALL NOSE

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

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)								
						3.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0	25.0
P	1	Non-alloy steel	0.7D	0.3D	Vc	40	40	40	40	40	40	40	40	40
					fz	0.011	0.018	0.031	0.05	0.069	0.085	0.094	0.117	0.13
					RPM	4244	3183	2122	1592	1273	1061	796	637	509
	2		0.7D	0.3D	FEED	93	115	132	159	176	180	150	149	132
					Vc	30	30	30	30	30	30	30	30	30
					fz	0.01	0.017	0.026	0.044	0.06	0.066	0.083	0.085	0.088
	3-4		0.7D	0.3D	RPM	3183	2387	1592	1194	955	796	597	477	382
					FEED	64	81	83	105	115	105	99	81	67
					Vc	20	20	20	20	20	15	20	20	15
	5		0.7D	0.3D	fz	0.008	0.013	0.023	0.036	0.054	0.061	0.079	0.083	0.091
					RPM	2122	1592	1061	796	637	398	398	318	191
					FEED	34	41	49	57	69	49	63	53	35
6	0.7D	0.3D	Vc	15	15	15	15	15	10	15	15	15		
			fz	0.007	0.013	0.018	0.03	0.044	0.055	0.07	0.088	0.094		
			RPM	1592	1194	796	597	477	265	298	239	191		
7	0.7D	0.3D	FEED	22	31	29	36	42	29	42	42	36		
			Vc	30	30	30	30	30	30	30	30	30		
			fz	0.01	0.017	0.026	0.044	0.06	0.066	0.083	0.085	0.088		
8-9	0.7D	0.3D	RPM	3183	2387	1592	1194	955	796	597	477	382		
			FEED	64	81	83	105	115	105	99	81	67		
			Vc	20	20	20	20	20	15	20	20	15		
10	0.7D	0.3D	fz	0.008	0.013	0.023	0.036	0.054	0.061	0.079	0.083	0.091		
			RPM	2122	1592	1061	796	637	398	398	318	191		
			FEED	34	41	49	57	69	49	63	53	35		
11.1	0.7D	0.3D	Vc	15	15	15	15	15	10	15	15	15		
			fz	0.007	0.013	0.018	0.03	0.044	0.055	0.07	0.088	0.094		
			RPM	1592	1194	796	597	477	265	298	239	191		
N	21-22	Aluminum-wrought alloy	0.7D	0.3D	FEED	22	31	29	36	42	29	42	42	36
					Vc	105	100	105	100	100	95	100	100	100
					fz	0.01	0.016	0.025	0.044	0.056	0.068	0.075	0.088	0.096
	23-24	Aluminum-cast, alloyed	0.7D	0.3D	RPM	11141	7958	5570	3979	3183	2520	1989	1592	1273
					FEED	223	255	279	350	357	343	298	280	244
					Vc	68	65	68	65	65	62	65	65	65
		0.7D	0.3D	fz	0.01	0.016	0.025	0.044	0.056	0.068	0.075	0.088	0.096	
				RPM	7215	5173	3608	2586	2069	1645	1293	1035	828	
				FEED	144	166	180	228	232	224	194	182	159	

※The FEED, in long & extra long types, should be reduced by around 50%

