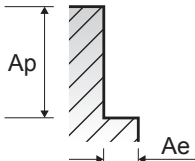


E5H89, E5H95 Uncoated

SQUARE / 4 FLUTE - SIDE CUTTING / METRIC

SFM = ft./min. IPT = In./tooth
RPM = rev./min. IPM = In./min.

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)											
						3	4	5	6	8	10	12	16	18	20	25	
P	1-2	Non-alloy steel	0.1D	1.5D	SFM	110	110	110	110	110	110	110	110	110	110	110	
					RPM	3560	2670	2130	1780	1330	1070	890	670	590	530	430	
					IPT	.00061	.00086	.00114	.00125	.00172	.00228	.00250	.00382	.00424	.00468	.00577	
	3-4		0.1D	1.5D	IPM	9	9	10	9	9	10	9	10	10	10	10	
					SFM	95	95	95	95	95	95	95	95	95	95	95	
					RPM	3070	2300	1840	1540	1150	920	770	580	510	460	370	
	5		0.1D	1.5D	IPT	.00063	.00090	.00118	.00126	.00180	.00236	.00252	.00386	.00422	.00463	.00565	
					IPM	8	8	9	8	8	9	8	9	9	9	8	
					SFM	80	80	80	80	80	80	80	80	80	80	80	
	6	Low alloy steel	0.1D	1.5D	RPM	2590	1940	1550	1290	970	780	650	490	430	390	310	
					IPT	.00058	.00081	.00105	.00116	.00161	.00210	.00229	.00395	.00432	.00474	.00578	
					IPM	6	6	7	6	6	7	6	8	7	7	7	
	7		0.1D	1.5D	SFM	110	110	110	110	110	110	110	110	110	110	110	
					RPM	3560	2670	2130	1780	1330	1070	890	670	590	530	430	
					IPT	.00061	.00086	.00114	.00125	.00172	.00228	.00250	.00382	.00424	.00468	.00577	
	8-9		0.1D	1.5D	IPM	9	9	10	9	9	10	9	10	10	10	10	
					SFM	95	95	95	95	95	95	95	95	95	95	95	
					RPM	3070	2300	1840	1540	1150	920	770	580	510	460	370	
10	High alloyed steel, and tool steel	0.1D	1.5D	IPT	.00063	.00090	.00118	.00126	.00180	.00236	.00252	.00386	.00422	.00463	.00565		
				IPM	8	8	9	8	8	9	8	9	9	9	8		
				SFM	80	80	80	80	80	80	80	80	80	80	80		
11.1		0.1D	1.5D	RPM	2590	1940	1550	1290	970	780	650	490	430	390	310		
				IPT	.00058	.00081	.00105	.00116	.00161	.00210	.00229	.00395	.00432	.00474	.00578		
				IPM	6	6	7	6	6	7	6	8	7	7	7		
M		14.1	Stainless steel	0.1D	1.5D	SFM	110	110	110	110	110	110	110	110	110	110	
						RPM	3560	2670	2130	1780	1330	1070	890	670	590	530	430
						IPT	.00061	.00086	.00114	.00125	.00172	.00228	.00250	.00382	.00424	.00468	.00577
K	15-20	Grey cast iron Nodular cast iron Malleable cast iron	0.1D	1.5D	IPM	9	9	10	9	9	10	9	10	10	10		
					SFM	80	80	80	80	80	80	80	80	80	80	80	
					RPM	2590	1940	1550	1290	970	780	650	490	430	390	310	
N	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	0.1D	1.5D	IPT	.00058	.00081	.00105	.00116	.00161	.00210	.00229	.00395	.00432	.00474	.00578	
					IPM	6	6	7	6	6	7	6	8	7	7	7	
					SFM	100	100	100	100	100	100	100	100	100	100	100	
	26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	0.1D	1.5D	RPM	3230	2430	1940	1620	1210	970	810	610	540	490	390	
					IPT	.00032	.00045	.00058	.00065	.00090	.00117	.00129	.00202	.00231	.00259	.00329	
					IPM	4	4	5	4	4	5	4	5	5	5	5	
	21-25	Aluminum-wrought alloy Aluminum-cast, alloyed	0.1D	1.5D	SFM	125	125	125	125	125	125	125	125	125	125	125	
					RPM	4040	3030	2430	2020	1520	1210	1010	760	670	610	490	
					IPT	.00090	.00125	.00167	.00216	.00317	.00429	.00527	.00760	.00866	.00968	.01224	
26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	0.1D	1.5D	IPM	15	15	16	17	19	21	21	23	23	24	24		
				SFM	315	315	315	315	315	315	315	315	315	315	315		
				RPM	10190	7640	6110	5090	3820	3060	2550	1910	1700	1530	1220		
26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	0.1D	1.5D	IPT	.00073	.00107	.00140	.00161	.00228	.00297	.00329	.00456	.00499	.00548	.00668		
				IPM	30	33	34	33	35	36	34	35	34	34	33		
				SFM	235	235	235	235	235	235	235	235	235	235	235		
26-29.1	Copper and Copper Alloys (Bronze / Brass) Non Metallic Materials	0.1D	1.5D	RPM	7600	5700	4560	3800	2850	2280	1900	1420	1270	1140	910		
				IPT	.00068	.00096	.00125	.00163	.00232	.00302	.00326	.00464	.00508	.00558	.00680		
				IPM	21	22	23	25	26	28	25	26	26	25	25		



Side Cutting