



RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

EI997, EIB93, EIB87 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)										
						0.4	0.6	0.8	1.0	1.2	1.5	2.0	3.0	4.0	5.0	6.0
N	29.2	Graphite	0.2D	0.2D	Vc	50	75	100	125	150	190	250	255	250	250	265
					fz	0.008	0.010	0.012	0.015	0.018	0.020	0.025	0.041	0.073	0.091	0.104
					RPM	39789	39789	39789	39789	39789	40319	39789	27056	19894	15915	14059
					FEED	637	796	955	1194	1432	1613	1989	2219	2905	2897	2924

