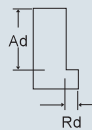


TECHNICAL DATA | GENERAL PURPOSE |

EA304 Series

Work Material	Cast Iron		Mild Steels Carbon Steels		Alloy Steels, Tool Steels, Ti Steels (Annealed)		Hardened Steels, Prehardened Steels, Ti, Alloys (Solution Treated & Aged)		Hardened Steels, Prehardened Steels, Stainless Steels, Inconel, Ni Bases Alloys		Aluminum Alloys	
Hardness	-		-		≤ 30 HRc		30 ~ 38 HRc		38 ~ 45 HRc		38 ~ 45 HRc	
Strength	-		Up to 108,779 lbf / inch ²		-		-		-		-	
Cutting Diameter (inch)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/32	21,150	23.9	23,240	11.8	15,900	10.9	14,600	4.5	12,200	3.5	50,000	39.4
3/64	14,140	23.9	15,680	11.8	11,390	10.9	10,305	4.5	8,145	3.5	40,275	39.4
1/16	11,115	23.9	12,105	11.8	8,895	10.9	8,045	4.5	6,390	3.5	31,710	39.4
5/64	8,090	23.9	8,535	11.8	6,395	10.9	5,780	4.5	4,625	3.5	23,135	39.4
3/32	6,970	23.9	7,320	12.6	5,495	10.9	4,965	4.4	3,960	3.4	19,820	40.6
7/64	5,920	23.9	6,200	13.5	4,660	10.9	4,205	4.3	3,340	3.4	16,725	41.8
1/8	5,090	24.6	5,330	14.4	4,005	10.9	3,610	4.3	2,870	3.3	14,370	42.9
9/64	4,545	26.3	4,785	15.4	3,580	10.9	3,225	4.3	2,585	3.3	12,935	43.8
5/32	4,000	28.0	4,240	16.4	3,150	10.9	2,850	4.3	2,295	3.3	11,505	44.8
11/64	3,670	28.1	3,885	16.9	2,895	11.2	2,620	4.3	2,100	3.3	10,565	45.2
3/16	3,360	28.1	3,555	17.2	2,655	11.6	2,405	4.3	1,910	3.3	9,660	45.6
13/64	3,090	28.1	3,260	17.6	2,445	11.8	2,205	4.3	1,750	3.3	8,880	46.0
7/32	2,870	28.1	3,020	17.9	2,285	11.8	2,045	4.3	1,630	3.3	8,280	46.3
1/4	2,520	28.1	2,640	18.2	2,000	11.8	1,775	4.3	1,430	3.3	7,280	46.8
9/32	2,260	28.1	2,380	18.3	1,785	11.8	1,580	4.3	1,295	3.3	6,520	47.0
5/16	1,995	28.1	2,115	18.4	1,570	11.8	1,390	4.3	1,150	3.3	5,760	47.2
11/32	1,820	28.3	1,940	19.4	1,445	11.8	1,290	4.3	1,055	3.3	5,280	47.2
3/8	1,655	28.6	1,775	20.4	1,325	11.8	1,200	4.3	965	3.3	4,830	47.2
13/32	1,515	28.9	1,630	21.0	1,220	11.8	1,110	4.3	885	3.3	4,430	48.0
7/16	1,420	29.1	1,510	21.1	1,140	11.8	1,035	4.3	825	3.3	4,120	49.8
1/2	1,250	30.9	1,310	22.5	995	12.2	900	4.3	720	3.3	3,585	52.0
9/16	1,120	34.3	1,175	24.9	880	13.1	795	4.3	635	3.3	3,170	52.0
5/8	1,005	35.5	1,055	25.7	790	13.8	720	4.3	570	3.3	2,840	52.0
11/16	915	38.4	960	25.9	720	13.9	650	4.3	515	3.3	2,595	52.0
3/4	820	39.4	860	26.3	640	13.9	580	4.1	465	3.3	2,340	52.0
7/8	710	35.5	750	23.6	560	12.6	510	3.7	405	3.0	2,015	49.1
1	630	31.2	660	20.7	490	10.9	440	3.3	360	2.6	1,775	43.5

RPM = rev. / min.
FEED = inch / min.



$A_d = 1.5D$
 $R_d = 0.1D$

Note

• for 2Flute

- Reduce Speeds & Feeds 25% for 2FL. Long length
- Reduce Speeds & Feeds 50% for 2FL. Extra Long length

• for Side Milling

- Increase Feeds 25% or More