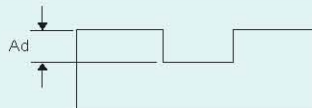


EA302 Series

Material	Cast Iron		Mild Steels Carbon Steels		Alloys 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		Aluminium Alloys	
Hardness					Up to 30 HRc		30 to 38 HRc		38 to 45 HRc			
Strength			Up to 750N/mm									
Diameter (INCH)	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1/32	20,790	6.6	18,950	4.5	15,900	1.9	13,450	1.4	10,640	1.2	47,700	9.4
3/64	15,225	6.6	13,590	4.5	11,430	1.9	9,660	1.4	7,595	1.2	34,140	9.4
1/16	11,970	6.6	10,660	4.6	9,000	2.0	7,540	1.4	5,925	1.2	26,520	9.4
5/64	8,705	6.6	7,730	4.7	6,570	2.1	5,415	1.4	4,260	1.2	18,900	9.4
3/32	7,480	6.8	6,635	4.7	5,650	2.4	4,650	1.4	3,645	1.2	16,305	9.4
7/64	6,335	6.9	5,610	4.7	4,790	2.6	3,935	1.4	3,075	1.2	13,925	9.4
1/8	5,445	7.1	4,815	4.7	4,125	3.0	3,375	1.4	2,640	1.2	12,060	10.3
9/64	4,870	7.3	4,310	4.7	3,700	3.4	3,020	1.4	2,380	1.2	10,845	12.1
5/32	4,300	7.5	3,815	4.7	3,270	3.7	2,660	1.4	2,115	1.2	9,630	14.0
11/64	3,945	7.6	3,490	4.7	2,990	3.8	2,440	1.4	1,940	1.2	8,835	14.2
3/16	3,615	7.7	3,180	4.7	2,735	3.8	2,225	1.4	1,775	1.2	8,075	14.2
13/64	3,320	8.0	2,920	4.7	2,505	3.8	2,040	1.4	1,630	1.2	7,415	14.2
7/32	3,080	8.6	2,730	4.7	2,345	3.8	1,895	1.4	1,510	1.2	6,915	14.2
1/4	2,690	9.5	2,400	4.7	2,060	3.8	1,660	1.4	1,320	1.2	6,070	14.2
9/32	2,405	10.2	2,140	4.7	1,845	3.8	1,490	1.4	1,185	1.2	5,430	14.2
5/16	2,115	10.8	1,875	4.7	1,630	3.8	1,330	1.4	1,055	1.2	4,785	14.2
11/32	1,940	10.9	1,725	4.7	1,485	3.8	1,220	1.4	970	1.2	4,385	14.2
3/8	1,775	10.9	1,580	4.7	1,340	3.8	1,120	1.4	885	1.2	4,005	14.2
13/32	1,630	10.9	1,455	4.7	1,230	3.8	1,035	1.4	815	1.2	3,680	14.2
7/16	1,510	10.9	1,360	4.7	1,155	3.8	965	1.4	755	1.2	3,440	14.2
1/2	1,310	10.9	1,190	4.7	1,020	3.8	840	1.4	660	1.2	3,010	14.2
9/16	1,175	10.9	1,060	4.7	905	3.8	740	1.4	585	1.2	2,645	14.2
5/8	1,080	11.1	960	4.7	815	3.8	670	1.6	520	1.2	2,355	14.2
11/16	980	11.1	870	4.7	740	3.8	610	1.7	470	1.2	2,160	14.2
3/4	880	11.1	780	4.7	665	3.8	545	1.7	425	1.2	1,920	14.2
7/8	765	11.1	675	4.7	580	3.8	480	1.7	370	1.2	1,660	14.2
1	670	10.9	590	4.7	500	3.8	420	1.7	330	1.2	1,475	14.2

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



	Ad
D < 1/8	0.3D
1/8 ≤ D	0.5D

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.