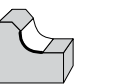
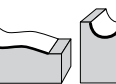
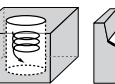
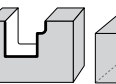
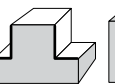
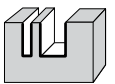
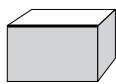
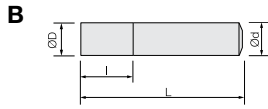
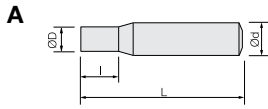


EPP Series

**EPP3-CS
Three Flute**



Helix Angle	43°
D (Ø3-6)	0/-0.015
D (Ø8-12)	0/-0.020
d	h5

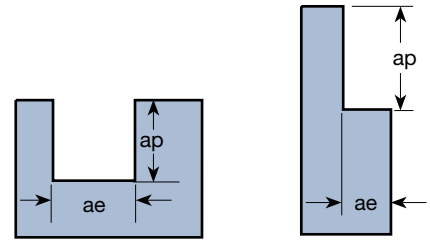
EPP3-CS - METRIC

Part No.	Flutes	ØD	I	L	Ød	Type
EPP3030-CS	3	3	8	60	6	A
EPP3040-CS	3	4	11	60	6	A
EPP3050-CS	3	5	13	60	6	A
EPP3060-CS	3	6	13	60	6	B
EPP3080-CS	3	8	19	75	8	B
EPP3100-CS	3	10	22	80	10	B
EPP3120-CS	3	12	26	100	12	B

EPP Series



EPP3-CS Cutting Conditions Metric



Work Material (Hardness)	Cutting Range	Slotting Dia. (mm)	Side Milling Dia. (mm)	Cutting Condition	Tool Dia.						
					Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12
Aluminium Alloy Wrought A7075, A5052	High Speed	ap≤0.5D	ap=1.5D	N (Rpm)	37,000	28,000	22,000	19,000	14,000	11,000	9,300
		ae=1D	ae=0.1D	Vf (mm/min)	2,800	2,900	3,200	3,500	3,600	3,300	3,100
	General	ap≤1D	ap=1.5D	N (Rpm)	21,000	16,000	13,000	11,000	8,000	6,400	5,300
		ae=1D	ae=0.2D	Vf (mm/min)	1,600	1,700	1,900	2,000	2,000	1,900	1,700
Cast Iron 150 200HB	High Speed	ap≤0.5D	ap=1.5D	N (Rpm)	6,400	4,800	3,800	3,200	2,400	1,900	1,600
		ae=1D	ae=0.1D	Vf (mm/min)	480	500	550	600	610	570	530
	General	ap≤1D	ap=1.5D	N (Rpm)	4,200	3,200	2,500	2,100	1,600	1,300	1,100
		ae=1D	ae=0.2D	Vf (mm/min)	320	340	360	390	410	390	360
Carbon Steel 180 220HB	High Speed	ap≤0.5D	ap=1.5D	N (Rpm)	9,600	7,200	5,700	4,800	3,600	2,900	2,400
		ae=1D	ae=0.1D	Vf (mm/min)	860	860	940	1,010	1,030	1,000	900
	General	ap≤1D	ap=1.5D	N (Rpm)	7,400	5,600	4,500	3,700	2,800	2,200	1,900
		ae=1D	ae=0.2D	Vf (mm/min)	560	590	650	690	710	660	630
Alloy Steel 200 250HB	High Speed	ap≤0.5D	ap=1.5D	N (Rpm)	7,400	5,600	4,500	3,700	2,800	2,200	1,900
		ae=1D	ae=0.1D	Vf (mm/min)	670	670	740	780	800	760	710
	General	ap≤1D	ap=1.5D	N (Rpm)	5,300	4,000	3,200	2,700	2,000	1,600	1,300
		ae=1D	ae=0.15D	Vf (mm/min)	400	420	460	500	510	480	430
Pre-hardened Steel 25 40HRC	General	ap≤0.5D	ap=1.5D	N (Rpm)	5,300	4,000	3,200	2,700	2,000	1,600	1,300
		ae=1D	ae=0.1D	Vf (mm/min)	360	360	400	430	430	410	370
Stainless Steel	General	ap≤0.5D	ap=1.5D	N (Rpm)	5,300	4,000	3,200	2,700	2,000	1,600	1,300
		ae=1D	ae=0.1D	Vf (mm/min)	290	290	320	340	340	330	290
Titanium Alloys Ti-6Al-4V	General	ap≤0.2D	ap=1.5D	N (Rpm)	5,300	4,000	3,200	2,700	2,000	1,600	1,300
		ae=1D	ae=0.1D	Vf (mm/min)	360	360	400	430	430	410	370
High Heat Resis- tant Alloys Inconel, Hasteloy	General	ap≤0.2D	ap=1.5D	N (Rpm)	2,100	1,600	1,300	1,100	800	640	530
		ae=1D	ae=0.05D	Vf (mm/min)	90	100	110	120	110	110	100

- For slotting, please refer to the chart above regarding the depth of cut for slotting.
- For side milling, please increase RPM to 1~1.3 times and Feed Rate to 1~1.5 times of the figures in the chart above.
- The RPM generally used for slotting is used for spot facing, just lower the feed rate by about 20%.