

■ MaxiMet • ABDF • Wiper Facet

Material Group																		
	Side Milling (A) and Slotting (B)				short		medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.					
	A		B		adapter reach									D1 – Diameter				
					K600			K600			K600			frac.	3/8	1/2	5/8	3/4
	ap	ae	ap	Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		dec.	.3750	.5000	.6250	.7500
N	1	1.5 x D	0.3 x D	1.0 x D	1640	–	6560	1312	–	3936	984	–	3936	IPT	.0029	.0038	.0048	.0057
	2	1.5 x D	0.3 x D	1.0 x D	1640	–	4920	1312	–	2952	984	–	2952	IPT	.0023	.0031	.0038	.0046
	3	1.5 x D	0.3 x D	1.0 x D	1640	–	4920	1312	–	2952	984	–	2952	IPT	.0020	.0027	.0033	.0040
	4	1.5 x D	0.3 x D	1.0 x D	1310	–	2460	1048	–	1476	786	–	1476	IPT	.0020	.0027	.0033	.0040
	5	1.5 x D	0.3 x D	1.0 x D	820	–	3280	656	–	1968	492	–	1968	IPT	.0026	.0034	.0043	.0052

NOTE: Ap for spindle with ceramic bearings multiply by 0.5.
 For better surface finish reduce feed per tooth.
 Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
 For side milling with Ap bigger than 1 x D reduce Fz by 20%!
 Cylindrical shanks not recommended for full slotting.



Duo-Lock Modular Milling

■ MaxiMet • ABDE • Wiper Facet • Unequal Flute Spacing

Material Group																		
	Side Milling (A) and Slotting (B)				short		medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.					
	A		B		adapter reach									D1 – Diameter				
					K600			K600			K600			frac.	3/8	1/2	5/8	3/4
	ap	ae	ap	Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		dec.	.3750	.5000	.6250	.7500
N	1	1.5 x D	0.3 x D	1.0 x D	1640	–	6560	1312	–	3936	984	–	3936	IPT	.0029	.0038	.0048	.0057
	2	1.5 x D	0.3 x D	1.0 x D	1640	–	4920	1312	–	2952	984	–	2952	IPT	.0023	.0031	.0038	.0046
	3	1.5 x D	0.3 x D	1.0 x D	1640	–	4920	1312	–	2952	984	–	2952	IPT	.0020	.0027	.0033	.0040
	4	1.5 x D	0.3 x D	1.0 x D	1310	–	2460	1048	–	1476	786	–	1476	IPT	.0020	.0027	.0033	.0040
	5	1.5 x D	0.3 x D	1.0 x D	820	–	3280	656	–	1968	492	–	1968	IPT	.0026	.0034	.0043	.0052

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