







■ Compression-Style Router • CCNC • Inch

Material Group									
	Side Milling (A)		 KCN05		Feed per Tooth — fz information is for side milling (A).				
	A		Cutting Speed — vc SFM			D1 — Diameter			
	ap	ae	min	max	frac	1/4	3/8	1/2	
C	1	Ap1 max	0.5 x D	330	500	fz	.0007	.0012	.0014





NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
 Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
 Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.

■ Down-Cut Router • CDDC • Inch

Material Group									
	Side Milling (A)		 KCN05		Feed per Tooth — fz information is for side milling (A).				
	A		Cutting Speed — vc SFM			D1 — Diameter			
	ap	ae	min	max	frac	1/4	3/8	1/2	
C	1	Ap1 max	1 x D	330	500	fz	.0018	.0030	.0036

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
 Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
 Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.

■ Burr-Style Router • CBDB • Inch

Material Group										
	Side Milling (A) and Slotting (B)			 KCN05		Feed per Revolution — Inch per revolution (IPR) information is for side milling (A). For Slotting (B), reduce IPR by 10%.				
	A		B	Cutting Speed — vc SFM			D1 — Diameter			
	ap	ae	ap	min	max	frac	1/4	3/8	1/2	
C	1	Ap1 max	0.2 x D	1 x D	330	500	IPR	.0059	.0098	.0118

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
 Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.
 Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.