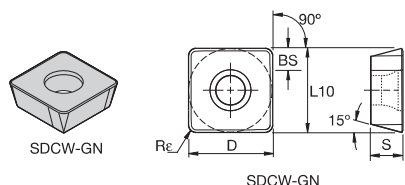

























































- Heavy machining.
- Precision ground.
- 0° rake face flat top.
- Four cutting edges.



■ SDCW-GN

[illegible]

									
P									
M									
K									
N									
S									
H									
Cutting edges			KC410M						
	4	-	-	KC520M	-	-	-	-	●
	4	-	-	-	-	-	-	-	●
	4	-	-	-	-	-	-	-	●

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	.005	.017	.030	.003	.012	.021	.003	.009	.016	.002	.008	.014	.002	.007	.013	.F..LE
.E..LD	.007	.019	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.E..LD
.E..LD2	.005	.018	.032	.004	.013	.023	.003	.010	.017	.002	.009	.015	.002	.008	.014	.E..LD2
.E..GB	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.E..GB
.E..GB2	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.E..GB2
.S..GB	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB
.S..GB2	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB2
.S..GN	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GN

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Shoulder Milling