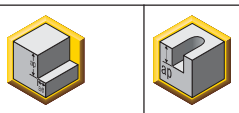
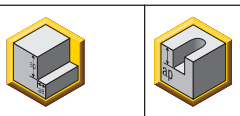
AADE and AADF



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600/KC651M/KC625M Cutting Speed — vc SFM min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter inch	1/8 0.125	3/16 0.188	1/4 0.250	5/16 0.313	3/8 0.375	7/16 0.438	1/2 0.500	5/8 0.625	3/4 0.750	1 1.000
N	1	1 x D	0.5 x D	1.0 x D	1600	6500	fz	0.0011	0.0017	0.0023	0.0028	0.0034	0.0039	0.0055	0.0065	0.0080	0.0095
	2	1 x D	0.5 x D	1.0 x D	1600	4500	fz	0.0010	0.0015	0.0020	0.0025	0.0030	0.0035	0.0050	0.0060	0.0070	0.0090



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600/KC651M/KC625M Cutting Speed — vc SFM min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter inch	1/8 0.125	3/16 0.188	1/4 0.250	5/16 0.313	3/8 0.375	7/16 0.438	1/2 0.500	5/8 0.625	3/4 0.750	1 1.000
N	1	1 x D	0.5 x D	1.0 x D	1600	6500	fz	0.0011	0.0017	0.0023	0.0028	0.0034	0.0039	0.0055	0.0065	0.0080	0.0095
	2	1 x D	0.5 x D	1.0 x D	1600	4500	fz	0.0010	0.0015	0.0020	0.0025	0.0030	0.0035	0.0050	0.0060	0.0070	0.0090

These guidelines may require variations to achieve optimum results.
For cutting aluminum with high silicon, coating is recommended.
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. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.

SFRHEC



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600/KC625M Cutting Speed — vc SFM min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. D1 — Diameter inch	1/4 0.250	3/8 0.375	1/2 0.500	5/8 0.625	3/4 0.750	1 1.000
N	1	1.25 x D	0.5 x D	1 x D	1650	6500	fz	0.0028	0.0041	0.0055	0.0070	0.0085	0.0110
	2	1.25 x D	0.5 x D	1 x D	1650	5050	fz	0.0025	0.0037	0.0050	0.0060	0.0075	0.0010

These guidelines may require variations to achieve optimum results.
For cutting aluminum with high silicon, coating is recommended.
ap for spindle with ceramic bearings, multiply by 0.5.
Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.