SPECIFICATIONS

HARVI™ I TE • 4 Flutes • Application Data • Inch

		Side Milling (A) and Slotting (B)						Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.														
					KCPM15			D1 — Diameter														
		A		B	Cutting Speed — vc SFM			frac.	1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	1	1-1/4
Material Group		**ap**	**ae**	**ap**	**min**		**max**	**dec.**	**0.125**	**0.1563**	**0.1875**	**0.2188**	**0.25**	**0.2813**	**0.3125**	**0.375**	**0.4375**	**0.5**	**0.625**	**0.75**	**1**	**1.25**
P	0	1.5 x D	0.5 x D	1.25 x D	490	–	660	IPT	0.001	0.0012	0.0015	0.0017	0.002	0.0023	0.0026	0.003	0.0034	0.0037	0.0043	0.0048	0.0054	0.0054
	1	1.5 x D	0.5 x D	1.25 x D	490	–	660	IPT	0.001	0.0012	0.0015	0.0017	0.002	0.0023	0.0026	0.003	0.0034	0.0037	0.0043	0.0048	0.0054	0.0054
	2	1.5 x D	0.5 x D	1.25 x D	460	–	620	IPT	0.001	0.0012	0.0015	0.0017	0.002	0.0023	0.0026	0.003	0.0034	0.0037	0.0043	0.0048	0.0054	0.0054
	3	1.5 x D	0.5 x D	1.25 x D	390	–	520	IPT	0.0008	0.001	0.0012	0.0014	0.0017	0.0019	0.0021	0.0025	0.0029	0.0032	0.0038	0.0042	0.005	0.0053
	4	1.5 x D	0.5 x D	1.25 x D	300	–	490	IPT	0.0007	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0022	0.0025	0.0028	0.0033	0.0037	0.0042	0.0044
	5	1.5 x D	0.5 x D	1.25 x D	200	–	330	IPT	0.0007	0.0008	0.001	0.0012	0.0014	0.0015	0.0017	0.002	0.0023	0.0025	0.003	0.0034	0.004	0.0043
	6	1.5 x D	0.5 x D	1.25 x D	160	–	250	IPT	0.0006	0.0007	0.0008	0.001	0.0011	0.0013	0.0014	0.0017	0.0019	0.0021	0.0025	0.0027	0.0031	0.0032
M	1	1.5 x D	0.5 x D	1.25 x D	300	–	380	IPT	0.0008	0.001	0.0012	0.0014	0.0017	0.0019	0.0021	0.0025	0.0029	0.0032	0.0038	0.0042	0.005	0.0053
	2	1.5 x D	0.5 x D	1.25 x D	200	–	260	IPT	0.0007	0.0008	0.001	0.0012	0.0014	0.0015	0.0017	0.002	0.0023	0.0025	0.003	0.0034	0.004	0.0043
	3	1.5 x D	0.5 x D	1.0 x D	200	–	230	IPT	0.0006	0.0007	0.0008	0.001	0.0011	0.0013	0.0014	0.0017	0.0019	0.0021	0.0025	0.0027	0.0031	0.0032
K	1	1.5 x D	0.5 x D	1.0 x D	390	–	490	IPT	0.001	0.0012	0.0015	0.0017	0.002	0.0023	0.0026	0.003	0.0034	0.0037	0.0043	0.0048	0.0054	0.0054
	2	1.5 x D	0.5 x D	1.0 x D	360	–	460	IPT	0.0008	0.001	0.0012	0.0014	0.0017	0.0019	0.0021	0.0025	0.0029	0.0032	0.0038	0.0042	0.005	0.0053
	3	1.5 x D	0.5 x D	1.0 x D	360	–	430	IPT	0.0007	0.0008	0.001	0.0012	0.0014	0.0015	0.0017	0.002	0.0023	0.0025	0.003	0.0034	0.004	0.0043
S	1	1.5 x D	0.3 x D	0.75 x D	160	–	300	IPT	0.0008	0.001	0.0012	0.0014	0.0017	0.0019	0.0021	0.0025	0.0029	0.0032	0.0038	0.0042	0.005	0.0053
	2	1.5 x D	0.3 x D	0.75 x D	160	–	260	IPT	0.0007	0.0008	0.001	0.0012	0.0014	0.0015	0.0017	0.002	0.0023	0.0025	0.003	0.0034	0.004	0.0043
	3	1.5 x D	0.5 x D	0.5 x D	80	–	130	IPT	0.0004	0.0005	0.0007	0.0008	0.0009	0.001	0.0011	0.0013	0.0015	0.0017	0.002	0.0023	0.0027	0.0029
	4	1.5 x D	0.5 x D	1.25 x D	160	–	200	IPT	0.0005	0.0007	0.0008	0.001	0.0012	0.0014	0.0016	0.0019	0.0021	0.0023	0.0028	0.0031	0.0036	0.0039
H	1	1.5 x D	0.5 x D	1.0 x D	260	–	460	IPT	0.0007	0.0009	0.0011	0.0013	0.0015	0.0017	0.0019	0.0022	0.0025	0.0028	0.0033	0.0037	0.0042	0.0044
	2	1.5 x D	0.2 x D	1.0 x D	230	–	390	IPT	0.0006	0.0007	0.0008	0.001	0.0011	0.0013	0.0014	0.0017	0.0019	0.0021	0.0025	0.0027	0.0031	0.0032

To calculate application specific cutting data, please use above KV coefficient for adaptation of cutting speed and KFz for feed respectively. Vc new = Vc * Kv Fz new = IPT * KFz Calculation example: Application: D = 1 inch; S4 material group; Ae 0,02 inch Cutting data recommendation: 150 SFM; fz = 0.0036 IPT Adjustment coefficients: Ae = 0,02 = inch equals 2,00%; Kv = 2; KFz = 2.4 Final cutting data recommendation: Vc new = 150 SFM * 2 = 300 SFM Fz new = .0036 IPT * 2.4 = .0086 IPT

	Ae/D	0.02	0.04	0.05	0.08	0.1	0.2	0.3	0.4	0.5
Speed factor	Kv	2	1.5	1.45	1.4	1.35	1.25	1.2	1	1
Feed factor	KFz	2.4	2.3	2.2	2	1.7	1.25	1.02	1	1