ABDF...

Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc SFM min	K600 Cutting Speed — vc SFM max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

ABDE...

Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc SFM min	K600 Cutting Speed — vc SFM max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

ABDE... with Neck

Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc SFM min	K600 Cutting Speed — vc SFM max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
N	1	1 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	1 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	3	1 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0018	.0022	.0026	.0035	.0044	.0053	.0070
	4	1 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0018	.0022	.0026	.0035	.0044	.0053	.0070
	5	1 x D	0.5 x D	1.0 x D	820	3280	IPT	.0023	.0028	.0034	.0045	.0056	.0068	.0090

NOTE: These guidelines may require variations to achieve optimum results. 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.
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.
For tools with reach > 3 x D, reduce fz by 20%.
For tools with reach > 5 x D, reduce fz by 30%.
For tools with reach > 10 x D, reduce vc and fz by 30%.