

SPECIFICATIONS

KOR™ 5 • 5 Flutes • Application Data



		Side Milling (A) and Slotting (B)			K600		Recommended feed per tooth (IPT = inch/th)						
							D1 — Diameter						
Material Group		A		B	Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min		max	dec.	0.375	0.5	0.625	0.75	1
N	1	0.5 x D1	0.5 x D1	0.25 x D1	640	–	6560	IPT	0.003	0.005	0.006	0.008	0.009
	2	0.5 x D1	0.5 x D1	0.25 x D1	640	–	4920	IPT	0.0025	0.0045	0.0055	0.007	0.0085

To calculate application specific cutting data, please use above coefficient for adaptation of feed. $Fz_{new} = IPT * Feed\ Multiplier$ Calculation example: Application: $D = 1"$; N1 material group; $Ae\ 0.1"$ Cutting data recommendation: 640 SFM; $fz = 0.0090\ IPT$ Adjustment coefficients: $Ae = 0.1"$ equals 10.00 %; Feed Multiplier = 1.7 Final cutting data recommendation: $FZ_{new} = .0090\ IPT * 1.7 = .0153\ IPT$

Ae/D1	100%	50%	40%	30%	20%	10%	5%	2%
Max Ap	.25 x D1	.5 x D1	1 x D1	2 x D1	Ap1 Max	Ap1 Max	Ap1 Max	Ap1 Max
Feed Multiplier	0.9	1	1.02	1.09	1.25	1.7	2.3	3.6