




SPECIFICATIONS

KOR™ 5 • 5 Flutes • Application Data

												
		Side Milling (A) and Slotting (B)			K600			Recommended feed per tooth (fz = mm/th)				
		A		B	Cutting Speed — vc m/min			D1 — Diameter				
Material Group		ap	ae	ap	min		max	mm	10	12	16	20
N	1	0.5 x D1	0.5 x D1	0.25 x D1	200	–	2000	fz	0,080	0,120	0,160	0,200
	2	0.5 x D1	0.5 x D1	0.25 x D1	200	–	1500	fz	0,070	0,110	0,140	0,180

To calculate application specific cutting data, please use above coefficient for adaptation of feed. $Fz_{new} = IPT * Feed\ Multiplier$ Calculation example: Application: $D = 20mm$; N1 material group; Ae 2mm Cutting data recommendation: 200 m/min; $fz = 0,200mm$ Adjustment coefficients: Ae = 2 mm equals 10.00 %; Feed Multiplier = 1.7 Final cutting data recommendation: $Fz_{new} = 0,2mm * 1.7 = 0,34mm$

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