

### ■ HPRST

Material Group					KC643M		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
	A		B	Cutting Speed – vc SFM		frac. dec.	D1 – Diameter							
	ap	ae	ap	min	max		1/4	5/16	3/8	1/2	5/8	3/4	1	
P	3	1.0 x D	0.5 x D	0.75 x D	390	520	IPT	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	1.0 x D	0.3 x D	0.75 x D	300	490	IPT	.0014	.0017	.0020	.0026	.0030	.0034	.0039
	5	1.0 x D	0.5 x D	0.75 x D	200	330	IPT	.0012	.0016	.0018	.0023	.0027	.0031	.0036
	6	1.0 x D	0.3 x D	0.3 x D	160	250	IPT	.0010	.0013	.0015	.0019	.0022	.0025	.0028
M	1	1.0 x D	0.5 x D	0.75 x D	300	380	IPT	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	1.0 x D	0.5 x D	0.75 x D	200	260	IPT	.0012	.0016	.0018	.0023	.0027	.0031	.0036
	3	1.0 x D	0.5 x D	0.75 x D	200	230	IPT	.0010	.0013	.0015	.0019	.0022	.0025	.0028
K	1	1.0 x D	0.5 x D	1 x D	390	490	IPT	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	1.0 x D	0.5 x D	1 x D	360	460	IPT	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	3	1.0 x D	0.5 x D	1 x D	360	430	IPT	.0012	.0016	.0018	.0023	.0027	.0031	.0036
S	1	1.0 x D	0.3 x D	0.75 x D	160	300	IPT	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	1.0 x D	0.3 x D	0.75 x D	80	130	IPT	.0008	.0010	.0012	.0015	.0018	.0021	.0024
	3	1.0 x D	0.3 x D	0.75 x D	80	130	IPT	.0008	.0010	.0012	.0015	.0018	.0021	.0024
	4	1.0 x D	0.4 x D	0.75 x D	160	200	IPT	.0011	.0014	.0017	.0021	.0025	.0028	.0033
H	1	1.0 x D	0.3 x D	0.3 x D	260	460	IPT	.0014	.0017	.0020	.0026	.0030	.0034	.0039
	2	1.0 x D	0.2 x D	0.2 x D	230	390	IPT	.0010	.0013	.0015	.0019	.0022	.0025	.0028
	3	1.0 x D	0.2 x D	0.2 x D	200	300	IPT	.0008	.0010	.0012	.0015	.0018	.0021	.0024

NOTE: These guidelines may require variations to achieve optimum results.

Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.

Higher value of cutting speed is used for finishing applications or for lower hardness (machinability) within group.

Above parameters are based on ideal conditions. For smaller taper machining centers, please adjust parameters accordingly on >1/2" diameter.

