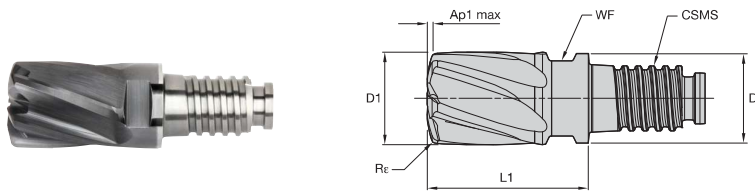


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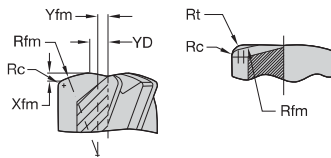
● first choice

○ alternate choice

P	●	○
M	●	○
K	●	○
N	●	○
S	●	○
H	●	○

order number	catalog number	D1	D	Ap1 max	L1	CSMS	WF	Re	KC643M
6626700	KSDB0375Y6BQX	3/8	.359	.020	.655	DL10	.315	.023	●
6626761	KSDB0500Y6BQX	1/2	.480	.027	1.126	DL12	.374	.031	●
6626763	KSDB0625Y6BQX	5/8	.605	.034	1.406	DL16	.512	.039	●
6626764	KSDB0750Y6BQX	3/4	.730	.040	1.689	DL20	.630	.047	●

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catalog number	D1	Ap1 max	Rfm	Rt	Rc	Xfm	Yfm	YD	Number of flutes	ramping guide for circular and linear interpolation						
										circular interpolation		linear interpolation				
										allowed range of hole diameter		calculated length per ramp angle				
									smallest	largest	1°	2°	3°	4°	5°	
KSDB0375Y6BQX	3/8	.020	3/8	.0399	.0235	.0200	.0469	.0788	6	.5325	.75	1.14	.57	.38	.29	.23
KSDB0500Y6BQX	1/2	.027	1/2	.0538	.0320	.0266	.0625	.1050	6	.7100	1.00	1.52	.76	.51	.38	.30
KSDB0625Y6BQX	5/8	.034	5/8	.0672	.0400	.0333	.0781	.1313	6	.8875	1.25	1.91	.95	.63	.48	.38
KSDB0750Y6BQX	3/4	.040	3/4	.0798	.0470	.0399	.0938	.1575	6	1.0650	1.50	2.29	1.14	.76	.57	.46
recommended degree of programmed feed rate to use while ramping											100%	70%	50%	30%	10%	

NOTE: YRC = distance from center line to the crown of the R radius.
 RCN = distance from centerline to the start of the cutting edge. This dimension can also help determine the minimum circle size when helical ramping.
 R = the head radius size.
 Rc = the shoulder radius or radius at the corner of the cutter.

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Material Group	Side Milling (A)		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).				
	A		adapter reach									D1 – Diameter				
			KC643M			KC643M			KC643M			frac.	3/8	1/2	5/8	3/4
	ap	ae	Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		dec.	.3750	.5000	.6250	.7500	
5	0.05 x D	0.55 x D	min	max	min	max	min	max	min	max						
P	5	0.05 x D	0.55 x D	200	330	170	281	160	264	160	264	IPT	.0110	.0139	.0164	.0185
P	6	0.05 x D	0.55 x D	160	250	136	213	128	200	128	200	IPT	.0092	.0115	.0134	.0149
M	1	0.05 x D	0.55 x D	300	380	240	304	210	266	210	266	IPT	.0137	.0173	.0205	.0232
M	2	0.05 x D	0.55 x D	200	260	160	208	140	182	140	182	IPT	.0110	.0139	.0164	.0185
M	3	0.05 x D	0.55 x D	200	230	160	184	140	161	140	161	IPT	.0092	.0115	.0134	.0149
S	1	0.05 x D	0.55 x D	160	300	128	240	96	180	96	180	IPT	.0137	.0173	.0205	.0232
S	2	0.05 x D	0.55 x D	80	130	64	104	48	78	48	78	IPT	.0073	.0092	.0109	.0124
S	3	0.05 x D	0.55 x D	80	130	64	104	48	78	48	78	IPT	.0073	.0092	.0109	.0124
S	4	0.05 x D	0.55 x D	160	200	128	160	96	120	96	120	IPT	.0101	.0128	.0151	.0170

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 diameters greater than 1/2".
 For cutting aluminum, with high silicon TiCN coating is recommended.
 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%.

