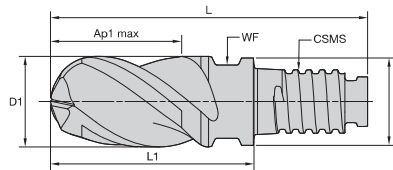


DUO-LOCK™ • MAXIMET™ • 3 FLUTES BALL NOSE



● first choice

○ alternate choice

P	■	■
M	■	■
K	■	■
N	■	●
S	■	■
H	■	■

order number	catalog number	D1	D	Ap1 max	L	L1	CSMS	WF	K600
6626767	ABBE0375Y3CN	3/8	.359	9/16	1.335	.843	DL10	.315	●
6626768	ABBE0500Y3CN	1/2	.480	3/4	1.717	1.126	DL12	.374	●
6626769	ABBE0625Y3CN	5/8	.605	15/16	2.193	1.406	DL16	.512	●
6626770	ABBE0750Y3CN	3/4	.730	1 1/8	2.630	1.689	DL20	.630	●

DUO-LOCK™ • MAXIMET™ • 3 FLUTES BALL NOSE • APPLICATION DATA

Material Group	Side Milling (A) and Slotting (B)		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
	A		B		adapter reach						D1 – Diameter							
	ap		ae		K600 Cutting Speed – vc SFM		K600 Cutting Speed – vc SFM		K600 Cutting Speed – vc SFM		frac.	3/8	1/2	5/8	3/4			
	min	max	min	max	min	max	min	max	min	max	dec.	.3750	.5000	.6250	.7500			
N	1	1.0 x D	0.5 x D	1.0 x D	1640	–	6560	1312	–	5248	984	–	3936	IPT	.0028	.0038	.0047	.0056
	2	1.0 x D	0.5 x D	1.0 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0023	.0030	.0038	.0045
	3	1.0 x D	0.5 x D	1.0 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0020	.0026	.0033	.0039
	4	1.0 x D	0.5 x D	1.0 x D	1310	–	2460	1048	–	1968	786	–	1476	IPT	.0020	.0026	.0033	.0039
	5	1.0 x D	0.5 x D	1.0 x D	820	–	3280	656	–	2624	492	–	1968	IPT	.0025	.0034	.0042	.0051
	6	1.0 x D	0.5 x D	1.0 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0028	.0038	.0047	.0056
	7	1.0 x D	0.5 x D	1.0 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0020	.0026	.0033	.0039

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 better surface finish, reduce feed per tooth.

