

ABDF • MaxiMet™															
Group	A		B	K600		Recommended Feed per Tooth (fz=inch/th) for Side Milling (A). For Slotting (B), reduce fz by 20%.									
	ap	ae	ap	Cutting Speed vc SFM		frac.	D1 – Diameter								
	1.5 x D	0.5 x D	1 x D	Min	Max		1/8"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	
N1	1.5 x D	0.5 x D	1 x D	≤6000	-	≤6000	fz	0.0011	0.0023	0.0028	0.0034	0.0045	0.0056	0.0068	0.009
N2	1.5 x D	0.5 x D	1 x D	≤6000	-	N/A	fz	0.0009	0.0018	0.0023	0.0027	0.0036	0.0045	0.0054	0.0072

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 on diameters greater than 1/2".  
For long lengths, reduce fz by 20%.

ABDE • MaxiMet															
Group	A		B	K600		Recommended Feed per Tooth (fz=inch/th) for Side Milling (A). For Slotting (B), reduce fz by 20%.									
	ap	ae	ap	Cutting Speed vc SFM		frac.	D1 – Diameter								
	1.5 x D	0.5 x D	1 x D	Min	Max		1/8"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	
N1	1.5 x D	0.5 x D	1 x D	≤6000	-	≤6000	fz	0.0011	0.0023	0.0028	0.0034	0.0045	0.0056	0.0068	0.009
N2	1.5 x D	0.5 x D	1 x D	≤6000	-	N/A	fz	0.0009	0.0018	0.0023	0.0027	0.0036	0.0045	0.0054	0.0072

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Solid End Mills • General Purpose+ Solid Carbide End Mills • Roughing/Finishing