

■ BNEC • 2-Flute

		Side Milling (A) and Slotting (B)			K600		KC610M		KC635M		Feed per Tooth – fz information is for side milling (A). For slotting (B), reduce fz by 20%.									
		A		B	Cutting Speed – vc SFM						D1 – Diameter									
Material Group		ap	ae	ap	min	max	min	max	min	max	inch	1/16	1/8	1/4	3/8	1/2	5/8	3/4	1	
												0.063	0.125	0.250	0.375	0.500	0.625	0.750	1.000	
P	1	1-1.5 x D	0.1 x D	0.25 x D	200	265	390	525	490	660	fz	0.0003	0.0007	0.0015	0.0022	0.0028	0.0032	0.0034	0.004	
	2	1-1.5 x D	0.1 x D	0.25 x D	185	250	370	500	460	620	fz	0.0003	0.0006	0.0012	0.0018	0.0023	0.0027	0.003	0.0036	
	3	1-1.5 x D	0.1 x D	0.25 x D	–	–	310	416	390	520	fz	0.0002	0.0005	0.0011	0.0016	0.0021	0.0024	0.0026	0.0031	
	4	1-1.5 x D	0.1 x D	0.25 x D	–	–	240	400	300	490	fz	0.0002	0.0006	0.0012	0.0018	0.0023	0.0027	0.003	0.0036	
M	1	1-1.5 x D	0.1 x D	0.25 x D	–	–	210	265	260	330	fz	0.0003	0.0005	0.001	0.0015	0.0019	0.0022	0.0024	0.0029	
	2	1-1.5 x D	0.1 x D	0.25 x D	–	–	160	210	200	260	fz	0.0004	0.0007	0.0015	0.0022	0.0028	0.0032	0.0034	0.004	
K	1	1-1.5 x D	0.1 x D	0.25 x D	155	210	310	415	390	520	fz	0.0003	0.0006	0.0012	0.0018	0.0023	0.0027	0.003	0.0036	
	2	1-1.5 x D	0.1 x D	0.25 x D	–	–	290	370	360	460	fz	0.0003	0.0007	0.0015	0.0022	0.0028	0.0032	0.0034	0.004	
N	1	1-1.5 x D	0.1 x D	0.25 x D	1640	6550	–	–	–	–	fz	0.0003	0.0006	0.0012	0.0018	0.0024	0.0027	0.003	0.0037	
	2	1-1.5 x D	0.1 x D	0.25 x D	1640	4900	–	–	–	–	fz	0.0002	0.0005	0.001	0.0015	0.0019	0.0022	0.0024	0.0029	
	5	1-1.5 x D	0.1 x D	0.25 x D	820	2450	–	–	–	–	fz	0.0005	0.001	0.002	0.003	0.004	0.005	0.006	0.0081	
	6	1-1.5 x D	0.1 x D	0.25 x D	330	1650	–	–	–	–	fz	0.0005	0.0010	0.0020	0.0030	0.0040	0.0050	0.0060	0.0081	

■ BNEC • 3-Flute

Solid End Milling

		Side Milling (A) and Slotting (B)			K600		KC610M		Feed per Tooth – fz information is for side milling (A). For slotting (B), reduce fz by 20%.											
		A		B	Cutting Speed – vc SFM						D1 – Diameter									
Material Group		ap	ae	ap	min	max	min	max	inch	1/16	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1	
												0.063	0.125	0.188	0.250	0.313	0.375	0.500	0.625	0.750
P	1	1D-1.5 x D	0.1 x D	0.25 x D	200	265	390	525	fz	0.0003	0.0007	0.0011	0.0015	0.0019	0.0022	0.0028	0.0032	0.0034	0.0040	
	2	1D-1.5 x D	0.1 x D	0.25 x D	185	250	370	500	fz	0.0003	0.0007	0.0011	0.0015	0.0019	0.0022	0.0028	0.0032	0.0034	0.0040	
	3	1D-1.5 x D	0.1 x D	0.25 x D	–	–	310	416	fz	0.0003	0.0006	0.0009	0.0012	0.0016	0.0018	0.0023	0.0027	0.0030	0.0036	
	4	1D-1.5 x D	0.1 x D	0.25 x D	–	–	240	400	fz	0.0002	0.0005	0.0008	0.0011	0.0014	0.0016	0.0021	0.0024	0.0026	0.0031	
M	1	1D-1.5 x D	0.1 x D	0.25 x D	–	–	210	265	fz	0.0002	0.0006	0.0009	0.0012	0.0016	0.0018	0.0023	0.0027	0.0030	0.0036	
	2	1D-1.5 x D	0.1 x D	0.25 x D	–	–	160	210	fz	0.0003	0.0005	0.0007	0.0010	0.0013	0.0015	0.0019	0.0022	0.0024	0.0029	
K	1	1D-1.5 x D	0.1 x D	0.25 x D	155	210	310	415	fz	0.0004	0.0007	0.0011	0.0015	0.0019	0.0022	0.0028	0.0032	0.0034	0.0040	
	2	1D-1.5 x D	0.1 x D	0.25 x D	–	–	290	370	fz	0.0003	0.0006	0.0009	0.0012	0.0016	0.0018	0.0023	0.0027	0.0030	0.0036	
N	1	1D-1.5 x D	0.1 x D	0.25 x D	1640	6550	–	–	fz	0.0003	0.0007	0.0011	0.0015	0.0019	0.0022	0.0028	0.0032	0.0034	0.0040	
	2	1D-1.5 x D	0.1 x D	0.25 x D	1640	4900	–	–	fz	0.0003	0.0006	0.0009	0.0012	0.0016	0.0018	0.0024	0.0027	0.0030	0.0037	
	5	1D-1.5 x D	0.1 x D	0.25 x D	820	2450	–	–	fz	0.0002	0.0005	0.0007	0.0010	0.0013	0.0015	0.0019	0.0022	0.0024	0.0029	
	6	1D-1.5 x D	0.1 x D	0.25 x D	330	1650	–	–	fz	0.0005	0.0010	0.0015	0.0020	0.0025	0.0030	0.0040	0.0050	0.0060	0.0081	

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.
 For long lengths, reduce fz by 20%.