AADF

Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc SFM min	max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
							dec.	.125	.188	.250	.313	.375	.500	.625	.750	1.000
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0009	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0010	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

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.

AADE

Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc SFM min	max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
							dec.	0.125	0.188	0.250	0.313	0.375	0.500	0.625	0.750	1.000
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0009	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0010	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

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.

SFRHEC

Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600/KC625M Cutting Speed — vc SFM min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. frac.	D1 — Diameter 1/4	3/8	1/2	5/8	3/4	1
							dec.	0.250	0.375	0.500	0.625	0.750	1.000
N	1	1.25 x D	0.5 x D	1 x D	1650	6500	fz	.0028	.0041	.0055	.0070	.0085	.0110
	2	1.25 x D	0.5 x D	1 x D	1650	5050	fz	.0025	.0037	.0050	.0060	.0075	.0010

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.