

■ HARVI II • UGDE • Unequal Flute Spacing • 3 x D Lengths of Cut

Material Group													
	Side Milling (A)		KC643M		Recommended feed per tooth (IPT = inch/th) for side milling (A).								
	A		Cutting Speed – vc SFM		D1 – Diameter								
	ap	ae	min	max	frac.	1/4	5/16	3/8	1/2	5/8	3/4	1	
				dec.	.2500	.3125	.3750	.5000	.6250	.7500	1.0000		
P	0	Ap max	0.05 x D	980	1310	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	1	Ap max	0.05 x D	980	1310	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	2	Ap max	0.05 x D	920	1250	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	3	Ap max	0.05 x D	790	1050	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	4	Ap max	0.05 x D	590	980	IPT	.0017	.0021	.0025	.0031	.0036	.0040	.0046
	5	Ap max	0.05 x D	390	660	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
M	6	Ap max	0.05 x D	330	490	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034
	1	Ap max	0.05 x D	590	750	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.05 x D	390	520	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
K	3	Ap max	0.05 x D	390	460	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034
	1	Ap max	0.05 x D	790	980	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	2	Ap max	0.05 x D	720	920	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
S	3	Ap max	0.05 x D	720	850	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
	1	Ap max	0.05 x D	330	590	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.05 x D	160	260	IPT	.0010	.0012	.0015	.0018	.0022	.0025	.0029
	3	Ap max	0.05 x D	160	260	IPT	.0010	.0012	.0015	.0018	.0022	.0025	.0029
H	4	Ap max	0.05 x D	330	390	IPT	.0013	.0017	.0020	.0026	.0030	.0034	.0040
	1	Ap max	0.05 x D	520	920	IPT	.0017	.0021	.0025	.0031	.0036	.0040	.0046
	2	Ap max	0.05 x D	460	790	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034

* For the above cutting data, do not exceed an overall ae of .031".

NOTE: 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.



High-Performance Solid Carbide End Mills