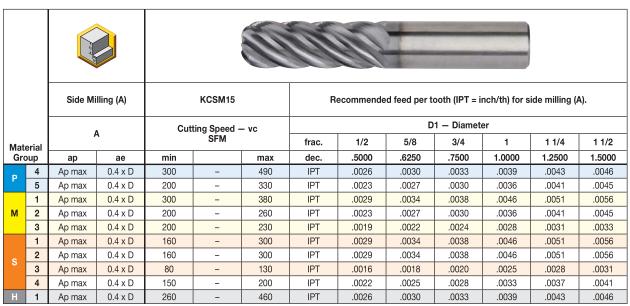


HARVI III™ • UJDE • Unequal Flute Spacing



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.



Adjustment factor table for feed and speed calculation

	Ae/D	0.50%	1.00%	1.60%	2.00%	4.00%	5.00%	8.00%	10.00%	20.00%	30.00%
Speed factor	Kv	2.9	2.85	2.8	2	1.5	1.45	1.4	1.35	1.25	1.2
Feed factor	KFz	2.8	2.6	2.5	2.4	2.3	2.2	2	1.7	1.25	1.02

To calculate application specific cutting data, please use above KV coefficient for adaptation of cutting speed and KFz for feed respectively.

Vc new = Vc * Kv

Fz new = IPT * KFz

Calculation example:

Application: D = 1 inch; S4 material group; Ae 0,02 inch Cutting data recommendation: 150 SFM; fz = 0.0033 IPT

Adjustment coefficients: Ae = 0,02 = inch equals 2,00%; Kv = 2; KFz = 2.4

Final cutting data recommendation:

Vc new = 150 SFM * 2 = 300 SFM Fz new = .0033 IPT * 2.4 = .0079 IPT

