

■ HPFT • Stainless Steels and High-Temp Alloys

Material Group	Side Milling (A)		KC635M		Recommended feed per tooth (IPT = inch/th) for side milling (A).									
	A		Cutting Speed – vc SFM		frac.	D1 – Diameter								
	ap	ae	min	max		dec.	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4
	0	1	2	3	4	5	6	1	2	3	1	2	3	
P	1.5 x D	0.05 x D	490	660	IPT	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	
	1.5 x D	0.05 x D	490	660	IPT	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	
	1.5 x D	0.05 x D	460	620	IPT	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	
	1.5 x D	0.05 x D	390	520	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	
	1.5 x D	0.05 x D	300	490	IPT	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	
	1.5 x D	0.05 x D	200	330	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	
M	1.5 x D	0.04 x D	160	250	IPT	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	
	1.5 x D	0.05 x D	300	380	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	
	1.5 x D	0.05 x D	200	260	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	
K	1.5 x D	0.05 x D	200	230	IPT	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	
	1.5 x D	0.05 x D	390	490	IPT	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	
	1.5 x D	0.05 x D	360	460	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	
S	1.5 x D	0.05 x D	360	430	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	
	1.5 x D	0.04 x D	160	300	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	
	1.5 x D	0.04 x D	80	130	IPT	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	
H	1.5 x D	0.04 x D	80	130	IPT	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	
	1.5 x D	0.05 x D	160	200	IPT	.0008	.0011	.0014	.0017	.0019	.0021	.0025	.0028	
H	1.5 x D	0.04 x D	260	460	IPT	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	

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
 These guidelines may require variations to achieve optimum results.



High-Performance Solid Carbide End Mills