

■ KMDA • Steels with Hardness <52 HRC

Material Group	3D Milling/Profiling		KC639M		frac.	D1 – Diameter						
			Cutting Speed – vc SFM			1/4	5/16	3/8	1/2	5/8	3/4	
	ap	ae	min	max	dec.	0.250	0.313	0.375	0.500	0.625	0.750	
P	4	0.05 x D	0.55 x D	528	594	fz	.0130	.0160	.0190	.0250	.0260	.0280
H	1	0.05 x D	0.55 x D	462	528	fz	.0130	.0160	.0190	.0250	.0260	.0280
	2	0.05 x D	0.55 x D	330	396	fz	.0080	.0090	.0110	.0150	.0190	.0230

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.

■ KHDA • Steels with Hardness >52 HRC

Material Group	3D Milling/Profiling		KC639M		frac.	D1 – Diameter						
			Cutting Speed – vc SFM			1/4	5/16	3/8	1/2	5/8	3/4	
	ap	ae	min	max	dec.	0.250	0.313	0.375	0.500	0.625	0.750	
H	2	0.03 x D	0.55 x D	330	396	fz	.0080	.0090	.0110	.0150	.0190	.0230
	3	0.03 x D	0.55 x D	265	330	fz	.0080	.0090	.0110	.0150	.0190	.0230
	4	0.03 x D	0.55 x D	165	230	fz	.0060	.0080	.0090	.0130	.0160	.0190

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.



High-Performance Solid Carbide End Mills