

■ CXE/CXER • Asymmetrical Flute Spacing

Material Group																				
	Side Milling (A) and Slotting (B)			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.																
	A		B	SP4060			D1 – Diameter													
	ap	ae	ap	Cutting Speed – vc SFM			frac.	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1			
			min		max	dec.	.125	.188	.250	.313	.375	.438	.500	.625	.750	1.000				
P	3	1.5 x D	0.5 x D	1 x D	390	–	520	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045		
	4	1.5 x D	0.5 x D	0.75 x D	300	–	490	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	.0039		
	5	1.5 x D	0.5 x D	1 x D	200	–	330	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036		
M	6	1.5 x D	0.5 x D	0.75 x D	160	–	250	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028		
	1	1.5 x D	0.5 x D	1 x D	300	–	380	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045		
	2	1.5 x D	0.5 x D	1 x D	200	–	260	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036		
S	3	1.5 x D	0.5 x D	1 x D	200	–	230	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028		
	1	1.5 x D	0.5 x D	1 x D	160	–	300	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045		
	2	1.5 x D	0.5 x D	1 x D	80	–	130	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024		
	3	1.5 x D	0.5 x D	1 x D	80	–	130	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024		
	4	1.5 x D	0.5 x D	1 x D	160	–	200	IPT	.0005	.0008	.0011	.0014	.0017	.0019	.0021	.0025	.0028	.0033		

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