





■ HARVI III • UJDV • Unequal Flute Spacing • Roughing

| Material Group |  | |  | | | | | | | | | Recommended feed per tooth (IPT = inch/th) for side milling (A). | | | | | | | |
|----------------|---|--------|--|-----|-----|------------------------|-----|-----|------------------------|-----|---|--|-------|-------|-------|--------|--------|--------|-------|
| | | | | | | | | | | | | Side Milling (A) | | | short | medium | | | long |
| | A | | adapter reach | | | | | | | | | D1 – Diameter | | | | | | | |
| | | | KCSM15 | | | KCSM15 | | | KCSM15 | | | frac. | 3/8 | 1/2 | 5/8 | 3/4 | 1 | 1 1/4 | |
| | | | Cutting Speed – vc SFM | | | Cutting Speed – vc SFM | | | Cutting Speed – vc SFM | | | dec. | .3750 | .5000 | .6250 | .7500 | 1.2500 | 1.2500 | |
| ap | ae | min | | max | min | | max | min | | max | | | | | | | | | |
| P | 4 | Ap max | 0,4 x D | 300 | – | 490 | 270 | – | 441 | 270 | – | 441 | IPT | .0017 | .0022 | .0026 | .0029 | .0034 | .0034 |
| | 5 | Ap max | 0,4 x D | 200 | – | 330 | 170 | – | 280.5 | 160 | – | 264 | IPT | .0016 | .0020 | .0023 | .0026 | .0033 | .0033 |
| M | 1 | Ap max | 0,4 x D | 300 | – | 380 | 240 | – | 304 | 210 | – | 266 | IPT | .0019 | .0025 | .0029 | .0033 | .0041 | .0041 |
| | 2 | Ap max | 0,4 x D | 200 | – | 260 | 160 | – | 208 | 140 | – | 182 | IPT | .0016 | .0020 | .0023 | .0026 | .0033 | .0033 |
| | 3 | Ap max | 0,4 x D | 200 | – | 230 | 160 | – | 184 | 140 | – | 161 | IPT | .0013 | .0016 | .0019 | .0021 | .0024 | .0024 |
| S | 1 | Ap max | 0,4 x D | 160 | – | 300 | 128 | – | 240 | 96 | – | 180 | IPT | .0019 | .0025 | .0029 | .0033 | .0041 | .0041 |
| | 2 | Ap max | 0,4 x D | 80 | – | 130 | 64 | – | 104 | 48 | – | 78 | IPT | .0010 | .0013 | .0015 | .0018 | .0022 | .0022 |
| | 3 | Ap max | 0,4 x D | 80 | – | 130 | 64 | – | 104 | 48 | – | 78 | IPT | .0010 | .0013 | .0015 | .0018 | .0022 | .0022 |
| | 4 | Ap max | 0,4 x D | 160 | – | 200 | 128 | – | 160 | 96 | – | 120 | IPT | .0014 | .0018 | .0021 | .0024 | .0030 | .0030 |
| H | 1 | Ap max | 0,4 x D | 260 | – | 460 | 208 | – | 368 | 156 | – | 276 | IPT | .0017 | .0022 | .0026 | .0029 | .0034 | .0034 |
| | 2 | Ap max | 0,4 x D | 230 | – | 390 | 184 | – | 312 | 138 | – | 234 | IPT | .0013 | .0016 | .0019 | .0021 | .0024 | .0024 |

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. Please adjust parameters according to system stability.
 For side milling with Ap bigger than 1 x D, reduce fz by 20%!
 Cylindrical shanks not recommended for full slotting.

■ HARVI III • UJDV • Unequal Flute Spacing • Finishing

| Material Group |  | |  | | | | | | | | | Recommended feed per tooth (IPT = inch/th) for side milling (A). | | | | | | | |
|----------------|---|--------|--|-----|-----|------------------------|-------|-----|------------------------|-----|---|--|-------|-------|-------|--------|--------|--------|-------|
| | | | | | | | | | | | | Side Milling (A) | | | short | medium | | | long |
| | A | | adapter reach | | | | | | | | | D1 – Diameter | | | | | | | |
| | | | KCSM15 | | | KCSM15 | | | KCSM15 | | | frac. | 3/8 | 1/2 | 5/8 | 3/4 | 1 | 1 1/4 | |
| | | | Cutting Speed – vc SFM | | | Cutting Speed – vc SFM | | | Cutting Speed – vc SFM | | | dec. | .3750 | .5000 | .6250 | .7500 | 1.2500 | 1.2500 | |
| ap | ae | min | | max | min | | max | min | | max | | | | | | | | | |
| P | 4 | Ap max | 0,06 x D | 560 | – | 940 | 504 | – | 846 | 504 | – | 846 | IPT | .0021 | .0026 | .0031 | .0034 | .0041 | .0041 |
| | 5 | Ap max | 0,06 x D | 370 | – | 620 | 314.5 | – | 527 | 296 | – | 496 | IPT | .0019 | .0024 | .0028 | .0031 | .0040 | .0040 |
| M | 1 | Ap max | 0,06 x D | 560 | – | 720 | 448 | – | 576 | 392 | – | 504 | IPT | .0023 | .0029 | .0035 | .0039 | .0049 | .0049 |
| | 2 | Ap max | 0,06 x D | 370 | – | 500 | 296 | – | 400 | 259 | – | 350 | IPT | .0019 | .0024 | .0028 | .0031 | .0040 | .0040 |
| | 3 | Ap max | 0,06 x D | 370 | – | 440 | 296 | – | 352 | 259 | – | 308 | IPT | .0016 | .0020 | .0023 | .0025 | .0029 | .0029 |
| S | 1 | Ap max | 0,06 x D | 310 | – | 560 | 248 | – | 448 | 186 | – | 336 | IPT | .0023 | .0029 | .0035 | .0039 | .0049 | .0049 |
| | 2 | Ap max | 0,06 x D | 160 | – | 250 | 128 | – | 200 | 96 | – | 150 | IPT | .0012 | .0016 | .0019 | .0021 | .0027 | .0027 |
| | 3 | Ap max | 0,06 x D | 160 | – | 250 | 128 | – | 200 | 96 | – | 150 | IPT | .0012 | .0016 | .0019 | .0021 | .0027 | .0027 |
| | 4 | Ap max | 0,06 x D | 310 | – | 370 | 248 | – | 296 | 186 | – | 222 | IPT | .0017 | .0022 | .0026 | .0029 | .0036 | .0036 |
| H | 1 | Ap max | 0,06 x D | 500 | – | 870 | 400 | – | 696 | 300 | – | 522 | IPT | .0021 | .0026 | .0031 | .0034 | .0041 | .0041 |
| | 2 | Ap max | 0,06 x D | 440 | – | 750 | 352 | – | 600 | 264 | – | 450 | IPT | .0016 | .0020 | .0023 | .0025 | .0029 | .0029 |

NOTE: Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.
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 Above parameters are based on ideal conditions. Please adjust parameters according to system stability.
 For side milling with Ap bigger than 1 x D, reduce fz by 20%!
 Cylindrical shanks not recommended for full slotting.