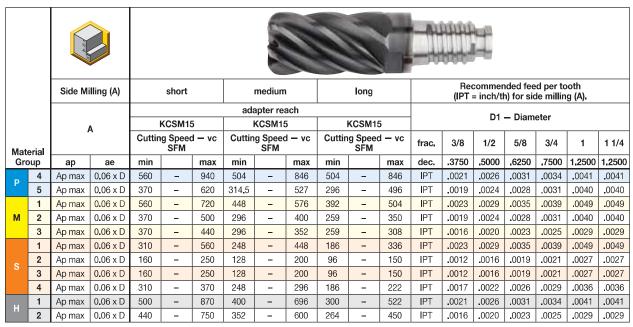


■ HARVI III • UJDV • Unequal Flute Spacing • Roughing

		Side Milling (A)		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).						
Material Group		А			adapter reach D1 - Diameter														
				KCSM15			KCSM15			KCSM15 Cutting Speed - vc SFM			D1 — Diameter						
				Cutting Speed — vc SFM		Cutting Speed — vc SFM		frac.	3/8				1/2	5/8	3/4	1	1 1/4		
		ар	ae	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500	1.2500
Р	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
М	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
Н	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



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.

