

■ 4-Flute with Neck • Inch

Material Group											
	Side Milling (A) and Slotting (B)				KYS40		Recommended feed per tooth (IPT=inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.				
	A		B		Cutting Speed – vc SFM		D1 – Diameter				
							3/16	1/4	5/16	3/8	1/2
	ap	ae	ap		min	max	inch	.1875	.2500	.3125	.3750
S 3	Ap1 max	0.1 x D*	0.5 x D	825	3300	IPT	.00094	.00100	.00109	.00113	.00133

* For above cutting data, do not exceed an overall ae of .039".

■ 6-Flute • Inch

Material Group											
	Side Milling (A) and Profiling				KYS40		Recommended feed per tooth (IPT=inch/th) for side milling (A).				
	A				Cutting Speed – vc SFM		D1 – Diameter				
							3/16	1/4	5/16	3/8	1/2
	ap	ae	min	max	inch		.1875	.2500	.3125	.3750	.5000
S 3	Ap1 max	0.1 x D*	825	3300	IPT	.00094	.00100	.00109	.00113	.00133	

* For above cutting data, do not exceed an overall ae of .039".



Solid End Milling