

■ HARVI II™ • UCDE • Unequal Flute Spacing

Solid End Milling

Material Group																
	Side Milling (A) and Slotting (B)			KCPM15/KC643M			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									
	ap	ae	ap	min	max	inch	3/16 0,188	1/4 0,250	5/16 0,313	3/8 0,375	7/16 0,438	1/2 0,500	5/8 0,625	3/4 0,750	1 1,000	
P	1	1.25 x D	0.5 x D	1 x D	490	660	IPT	.0014	.0018	.0023	.0027	.0031	.0035	.0039	.0043	.0050
	2	1.25 x D	0.5 x D	1 x D	460	620	IPT	.0014	.0018	.0023	.0027	.0031	.0035	.0039	.0043	.0050
	3	1.25 x D	0.5 x D	1 x D	390	520	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0038	.0046
	4	1.25 x D	0.5 x D	0.75 x D	300	490	IPT	.0010	.0014	.0018	.0020	.0023	.0026	.0030	.0033	.0039
	5	1.25 x D	0.5 x D	1 x D	200	330	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0030	.0036
	6	1.25 x D	0.5 x D	0.75 x D	160	250	IPT	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0024	.0028
M	1	1.25 x D	0.5 x D	1 x D	260	330	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0038	.0046
	2	1.25 x D	0.5 x D	1 x D	200	260	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0030	.0036
	3	1.25 x D	0.5 x D	1 x D	200	260	IPT	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0024	.0028
K	1	1.25 x D	0.5 x D	1 x D	390	520	IPT	.0014	.0018	.0023	.0027	.0031	.0035	.0039	.0043	.0050
	2	1.25 x D	0.5 x D	1 x D	360	460	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0038	.0046
	3	1.25 x D	0.5 x D	1 x D	330	430	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0030	.0036
S	1	1.0 x D	0.3 x D	0.3 x D	160	300	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0038	.0046
	2	1.25 x D	0.5 x D	1 x D	160	260	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0030	.0036
	3	1.0 x D	0.3 x D	0.3 x D	70	130	IPT	.0006	.0008	.0010	.0012	.0014	.0016	.0018	.0020	.0025
	4	1.25 x D	0.5 x D	1 x D	150	210	IPT	.0008	.0011	.0014	.0017	.0019	.0022	.0025	.0028	.0033
H	1	1.25 x D	0.5 x D	0.75 x D	260	460	IPT	.0010	.0014	.0018	.0020	.0023	.0026	.0030	.0033	.0039

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Material Group														
	Side Milling (A) and Slotting (B)			KCPM15/KC643M			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							
	ap	ae	ap	min	max	inch	1/4 0,250	3/8 0,375	1/2 0,500	5/8 0,625	3/4 0,750	1 1,000		
P	1	0.75 x D	0.5 x D	0.75 x D	490	660	IPT	.0018	.0027	.0035	.0039	.0043	.0050	
	2	0.75 x D	0.5 x D	0.75 x D	460	620	IPT	.0018	.0027	.0035	.0039	.0043	.0050	
	3	0.75 x D	0.5 x D	0.75 x D	390	520	IPT	.0015	.0023	.0029	.0034	.0038	.0046	
	4	0.75 x D	0.5 x D	0.5 x D	300	490	IPT	.0014	.0020	.0026	.0030	.0033	.0039	
	5	0.75 x D	0.5 x D	0.75 x D	200	330	IPT	.0012	.0018	.0023	.0027	.0030	.0036	
	6	0.75 x D	0.5 x D	0.5 x D	160	250	IPT	.0010	.0015	.0019	.0022	.0024	.0028	
M	1	0.75 x D	0.5 x D	0.75 x D	260	330	IPT	.0015	.0023	.0029	.0034	.0038	.0046	
	2	0.75 x D	0.5 x D	0.75 x D	200	260	IPT	.0012	.0018	.0023	.0027	.0030	.0036	
	3	0.75 x D	0.5 x D	0.75 x D	200	260	IPT	.0010	.0015	.0019	.0022	.0024	.0028	
K	1	0.75 x D	0.5 x D	0.75 x D	390	520	IPT	.0018	.0027	.0035	.0039	.0043	.0050	
	2	0.75 x D	0.5 x D	0.75 x D	360	460	IPT	.0015	.0023	.0029	.0034	.0038	.0046	
	3	0.75 x D	0.5 x D	0.75 x D	330	430	IPT	.0012	.0018	.0023	.0027	.0030	.0036	
S	1	0.75 x D	0.3 x D	0.3 x D	160	300	IPT	.0015	.0023	.0029	.0034	.0038	.0046	
	2	0.75 x D	0.5 x D	0.75 x D	160	260	IPT	.0012	.0018	.0023	.0027	.0030	.0036	
	3	0.75 x D	0.3 x D	0.3 x D	70	130	IPT	.0008	.0012	.0016	.0018	.0020	.0025	
	4	0.75 x D	0.5 x D	0.75 x D	150	210	IPT	.0011	.0017	.0022	.0025	.0028	.0033	
H	1	0.75 x D	0.5 x D	0.5 x D	260	460	IPT	.0014	.0020	.0026	.0030	.0033	.0039	

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.