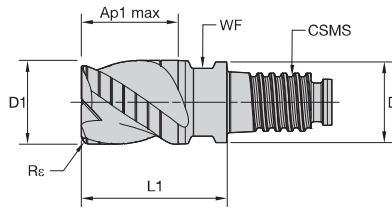


DUO-LOCK™ • RFDD • 3 FLUTES



● first choice
○ alternate choice

P	●
M	●
K	●
N	●
S	○
H	○

order number	catalog number	D1	D	Ap1 max	L1	CSMS	WF	Rc	KCPM15
6441025	RFDD0375Y3AQA	3/8	.359	9/32	.655	DL10	.315	.015	●
6441026	RFDD0500Y3AQA	1/2	.480	3/8	.876	DL12	.374	.015	●
6441027	RFDD0625Y3AQA	5/8	.605	15/32	1.093	DL16	.512	.015	●
6441028	RFDD0750Y3AQA	3/4	.730	9/16	1.314	DL20	.630	.015	●

DUO-LOCK™ • RFDD • 3 FLUTES • APPLICATION DATA

Material Group	Side Milling (A) and Slotting (B)		straight short				conical medium				conical long				Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. D1 – Diameter						
	A		B		KCPM15				KCPM15				KCPM15				frac.	3/8	1/2	5/8	3/4
	ap	ae	ap		Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		Cutting Speed – vc SFM		dec.	0.3750	0.5000	0.6250	0.7500		
	min	max	min	max	min	max	min	max	min	max	min	max	min	max							
P	0	0.75 x D	0.5 x D	0.5 x D	490	–	660	441	–	594	441	–	594	IPT	0.0023	0.0029	0.0034	0.0037			
	1	0.75 x D	0.5 x D	0.5 x D	490	–	660	441	–	594	441	–	594	IPT	0.0023	0.0029	0.0034	0.0037			
	2	0.75 x D	0.5 x D	0.5 x D	460	–	620	414	–	558	414	–	558	IPT	0.0023	0.0029	0.0034	0.0037			
	3	0.75 x D	0.5 x D	0.5 x D	390	–	520	351	–	468	351	–	468	IPT	0.0019	0.0025	0.0029	0.0033			
	4	0.75 x D	0.4 x D	0.5 x D	300	–	490	270	–	441	270	–	441	IPT	0.0017	0.0022	0.0026	0.0029			
	5	0.75 x D	0.5 x D	0.5 x D	200	–	330	170	–	281	160	–	264	IPT	0.0016	0.0020	0.0023	0.0026			
M	6	0.75 x D	0.4 x D	0.5 x D	160	–	250	136	–	213	128	–	200	IPT	0.0013	0.0016	0.0019	0.0021			
	1	0.75 x D	0.4 x D	0.5 x D	300	–	380	240	–	304	210	–	266	IPT	0.0019	0.0025	0.0029	0.0033			
	2	0.75 x D	0.4 x D	0.5 x D	200	–	260	160	–	208	140	–	182	IPT	0.0016	0.0020	0.0023	0.0026			
K	3	0.75 x D	0.4 x D	0.5 x D	200	–	230	160	–	184	140	–	161	IPT	0.0013	0.0016	0.0019	0.0021			
	1	0.75 x D	0.5 x D	0.5 x D	390	–	490	351	–	441	351	–	441	IPT	0.0023	0.0029	0.0034	0.0037			
	2	0.75 x D	0.5 x D	0.5 x D	360	–	460	324	–	414	324	–	414	IPT	0.0019	0.0025	0.0029	0.0033			
H	3	0.75 x D	0.4 x D	0.5 x D	360	–	430	324	–	387	324	–	387	IPT	0.0016	0.0020	0.0023	0.0026			
	1	0.75 x D	0.2 x D	0.3 x D	260	–	460	208	–	368	156	–	276	IPT	0.0017	0.0022	0.0026	0.0029			

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 diameters >1/2".
 For tools with reach > 3 x D, reduce fz by 20%.
 For tools with reach >5 x D, reduce fz by 30%.
 For tools with reach >10 x D, reduce Vc and fz by 30%.

146	148	58	4	152