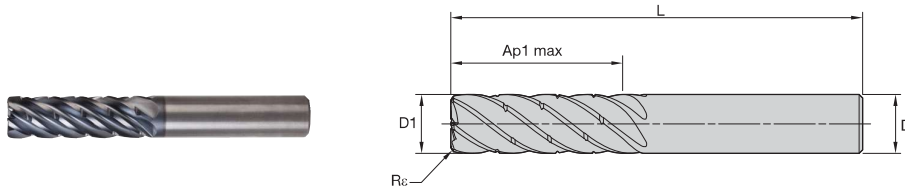


HARVI™ III • TJDE • 6 FLUTES



- first choice
- alternate choice

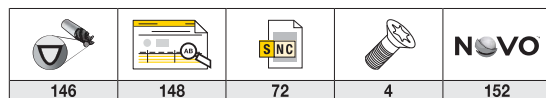
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M	<input checked="" type="radio"/>
K	<input type="radio"/>
N	<input type="radio"/>
S	<input checked="" type="radio"/>
H	<input type="radio"/>

order number	catalog number	D1	D	Ap1 max	L	Rε	KCSM15
6565581	TJDE0375J6CRB	3/8	3/8	1 1/8	3	.030	●
6565582	TJDE0500J6CRB	1/2	1/2	1 1/2	3 1/2	.030	●
6565583	TJDE0625N6CRB	5/8	5/8	1 7/8	4	.030	●
6565585	TJDE0750N6CRC	3/4	3/4	2 1/4	5	.060	●
6565586	TJDE1000N6CRC	1	1	3	6	.060	●



HARVI III • TJDE • 6 FLUTES • APPLICATION DATA • AE 10% OF D1

Material Group	Side Milling (A)		KCSM15				Recommended feed per tooth (IPT = inch/th) for side milling (A).					
	A		Cutting Speed – vc SFM				D1 – Diameter					
	ap	ae	min	max	frac.	3/8	1/2	5/8	3/4	1		
	ap max	0.1 x D	500	1440	dec.	0.3750	0.5000	0.6250	0.7500	1.0000		
P	0	Ap max	0.1 x D	500	–	1440	IPT	0.0033	0.0041	0.0047	0.0053	0.0059
	1	Ap max	0.1 x D	500	–	1440	IPT	0.0033	0.0041	0.0047	0.0053	0.0059
	2	Ap max	0.1 x D	460	–	1370	IPT	0.0033	0.0041	0.0047	0.0053	0.0059
	3	Ap max	0.1 x D	400	–	1150	IPT	0.0027	0.0035	0.0041	0.0046	0.0054
	4	Ap max	0.1 x D	300	–	1080	IPT	0.0025	0.0031	0.0036	0.0040	0.0046
	5	Ap max	0.1 x D	200	–	720	IPT	0.0022	0.0028	0.0033	0.0037	0.0043
M	6	Ap max	0.1 x D	170	–	540	IPT	0.0018	0.0023	0.0027	0.0030	0.0034
	1	Ap max	0.1 x D	300	–	830	IPT	0.0027	0.0035	0.0041	0.0046	0.0054
	2	Ap max	0.1 x D	200	–	580	IPT	0.0022	0.0028	0.0033	0.0037	0.0043
K	3	Ap max	0.1 x D	200	–	510	IPT	0.0018	0.0023	0.0027	0.0030	0.0034
	1	Ap max	0.1 x D	400	–	1080	IPT	0.0033	0.0041	0.0047	0.0053	0.0059
	2	Ap max	0.1 x D	370	–	1010	IPT	0.0027	0.0035	0.0041	0.0046	0.0054
S	3	Ap max	0.1 x D	370	–	940	IPT	0.0022	0.0028	0.0033	0.0037	0.0043
	1	Ap max	0.1 x D	170	–	650	IPT	0.0027	0.0035	0.0041	0.0046	0.0054
	2	Ap max	0.1 x D	80	–	580	IPT	0.0022	0.0028	0.0033	0.0037	0.0043
	3	Ap max	0.1 x D	80	–	290	IPT	0.0015	0.0018	0.0022	0.0025	0.0029
H	4	Ap max	0.1 x D	170	–	430	IPT	0.0020	0.0026	0.0030	0.0034	0.0040
	1	Ap max	0.1 x D	270	–	1010	IPT	0.0025	0.0031	0.0036	0.0040	0.0046
	2	Ap max	0.1 x D	230	–	870	IPT	0.0018	0.0023	0.0027	0.0030	0.0034

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.
 Side milling applications – for longest reach (L3) tools, reduce ae by 30%.
 For better surface finish, reduce feed per tooth.





HARVI™ III • TJDE • 5 FLUTES • APPLICATION DATA • AE 5% OF D1

Material Group							Recommended feed per tooth (IPT = inch/th) for side milling (A).					
							D1 – Diameter					
		A		Cutting Speed – vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	dec.	0.3750	0.5000	0.6250	0.7500	1.0000
P	0	Ap max	0.05 x D	500	–	1770	IPT	0.0044	0.0054	0.0063	0.0070	0.0078
	1	Ap max	0.05 x D	500	–	1770	IPT	0.0044	0.0054	0.0063	0.0070	0.0078
	2	Ap max	0.05 x D	460	–	1680	IPT	0.0044	0.0054	0.0063	0.0070	0.0078
	3	Ap max	0.05 x D	400	–	1420	IPT	0.0037	0.0046	0.0055	0.0062	0.0072
	4	Ap max	0.05 x D	300	–	1330	IPT	0.0033	0.0041	0.0048	0.0054	0.0062
	5	Ap max	0.05 x D	200	–	890	IPT	0.0029	0.0037	0.0044	0.0049	0.0058
M	6	Ap max	0.05 x D	170	–	660	IPT	0.0024	0.0031	0.0036	0.0040	0.0045
	1	Ap max	0.05 x D	300	–	1020	IPT	0.0037	0.0046	0.0055	0.0062	0.0072
	2	Ap max	0.05 x D	200	–	710	IPT	0.0029	0.0037	0.0044	0.0049	0.0058
K	3	Ap max	0.05 x D	200	–	620	IPT	0.0024	0.0031	0.0036	0.0040	0.0045
	1	Ap max	0.05 x D	400	–	1330	IPT	0.0044	0.0054	0.0063	0.0070	0.0078
	2	Ap max	0.05 x D	370	–	1240	IPT	0.0037	0.0046	0.0055	0.0062	0.0072
S	3	Ap max	0.05 x D	370	–	1150	IPT	0.0029	0.0037	0.0044	0.0049	0.0058
	1	Ap max	0.05 x D	170	–	800	IPT	0.0037	0.0046	0.0055	0.0062	0.0072
	2	Ap max	0.05 x D	80	–	710	IPT	0.0029	0.0037	0.0044	0.0049	0.0058
	3	Ap max	0.05 x D	80	–	350	IPT	0.0019	0.0025	0.0029	0.0033	0.0039
H	4	Ap max	0.05 x D	170	–	530	IPT	0.0027	0.0034	0.0040	0.0045	0.0053
	1	Ap max	0.05 x D	270	–	1240	IPT	0.0033	0.0041	0.0048	0.0054	0.0062
	2	Ap max	0.05 x D	230	–	1060	IPT	0.0024	0.0031	0.0036	0.0040	0.0045

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.
 Side milling applications – for longest reach (L3) tools, reduce ae by 30%.
 For better surface finish, reduce feed per tooth.

HARVI III • TJDE • 5 FLUTES • APPLICATION DATA • AE 2% OF D1

Material Group							Recommended feed per tooth (IPT = inch/th) for side milling (A).				
							D1 – Diameter				
		A		Cutting Speed – vc SFM			frac.	3/8	1/2	5/8	3/4
		ap	ae	min		max	dec.	0.3750	0.5000	0.6250	0.7500
P	0	Ap max	0.02 x D	500	–	2170	IPT	0.0063	0.0078	0.0091	0.0101
	1	Ap max	0.02 x D	500	–	2170	IPT	0.0063	0.0078	0.0091	0.0101
	2	Ap max	0.02 x D	460	–	2060	IPT	0.0063	0.0078	0.0091	0.0101
	3	Ap max	0.02 x D	400	–	1730	IPT	0.0053	0.0066	0.0079	0.0089
	4	Ap max	0.02 x D	300	–	1620	IPT	0.0047	0.0059	0.0069	0.0078
	5	Ap max	0.02 x D	200	–	1080	IPT	0.0042	0.0053	0.0063	0.0071
M	6	Ap max	0.02 x D	170	–	810	IPT	0.0035	0.0044	0.0051	0.0057
	1	Ap max	0.02 x D	300	–	1250	IPT	0.0053	0.0066	0.0079	0.0089
	2	Ap max	0.02 x D	200	–	870	IPT	0.0042	0.0053	0.0063	0.0071
K	3	Ap max	0.02 x D	200	–	760	IPT	0.0035	0.0044	0.0051	0.0057
	1	Ap max	0.02 x D	400	–	1620	IPT	0.0063	0.0078	0.0091	0.0101
	2	Ap max	0.02 x D	370	–	1520	IPT	0.0053	0.0066	0.0079	0.0089
S	3	Ap max	0.02 x D	370	–	1410	IPT	0.0042	0.0053	0.0063	0.0071
	1	Ap max	0.02 x D	170	–	970	IPT	0.0053	0.0066	0.0079	0.0089
	2	Ap max	0.02 x D	80	–	870	IPT	0.0042	0.0053	0.0063	0.0071
	3	Ap max	0.02 x D	80	–	430	IPT	0.0028	0.0035	0.0042	0.0047
H	4	Ap max	0.02 x D	170	–	650	IPT	0.0039	0.0049	0.0058	0.0065
	1	Ap max	0.02 x D	270	–	1520	IPT	0.0047	0.0059	0.0069	0.0078
	2	Ap max	0.02 x D	230	–	1300	IPT	0.0035	0.0044	0.0051	0.0057

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.
 Side milling applications – for longest reach (L3) tools, reduce ae by 30%.
 For better surface finish, reduce feed per tooth.

