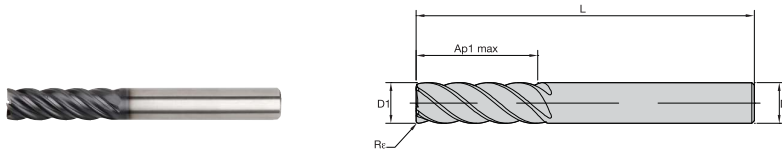


HARVI™ II • TCDE • 5 FLUTES



- first choice
- alternate choice

P	●	○
M	●	○
K	●	○
N	●	○
S	●	○
H	●	○

order number	catalog number	D1	D	Ap1 max	L	Rε	KC643M
6558727	TCDE0250J5CRA	1/4	1/4	7/8	2 1/2	.015	●
6558728	TCDE0375J5CRB	3/8	3/8	1 1/8	3	.030	●
6558729	TCDE0500J5CRB	1/2	1/2	1 1/2	3 1/2	.030	●
6558730	TCDE0625N5CRB	5/8	5/8	1 7/8	4	.030	●
6558781	TCDE0750N5CRC	3/4	3/4	2 1/4	5	.060	●
6558782	TCDE1000N5CRC	1	1	3	6	.060	●

HARVI II • TCDE • 5 FLUTES • APPLICATION DATA • AE 10% OF D1

Material Group	Side Milling (A)		KC643M											
			Cutting Speed – vc SFM		Recommended feed per tooth (IPT = inch/th) for side milling (A).									
	A		min		max		D1 – Diameter							
	ap	ae	min	max	dec.	0.2500	0.3750	0.5000	0.6250	0.7500	1.0000			
P	0	Ap max 0.1 x D	500	1440	IPT	0.0022	0.0033	0.0041	0.0047	0.0053	0.0059			
	1	Ap max 0.1 x D	500	1440	IPT	0.0022	0.0033	0.0041	0.0047	0.0053	0.0059			
	2	Ap max 0.1 x D	460	1370	IPT	0.0022	0.0033	0.0041	0.0047	0.0053	0.0059			
	3	Ap max 0.1 x D	400	1150	IPT	0.0018	0.0027	0.0035	0.0041	0.0046	0.0054			
	4	Ap max 0.1 x D	300	1080	IPT	0.0017	0.0025	0.0031	0.0036	0.0040	0.0046			
	5	Ap max 0.1 x D	200	720	IPT	0.0015	0.0022	0.0028	0.0033	0.0037	0.0043			
M	1	Ap max 0.1 x D	170	540	IPT	0.0012	0.0018	0.0023	0.0027	0.0030	0.0034			
	2	Ap max 0.1 x D	300	830	IPT	0.0018	0.0027	0.0035	0.0041	0.0046	0.0054			
K	1	Ap max 0.1 x D	200	580	IPT	0.0015	0.0022	0.0028	0.0033	0.0037	0.0043			
	3	Ap max 0.1 x D	200	510	IPT	0.0012	0.0018	0.0023	0.0027	0.0030	0.0034			
S	1	Ap max 0.1 x D	400	1080	IPT	0.0022	0.0033	0.0041	0.0047	0.0053	0.0059			
	2	Ap max 0.1 x D	370	1010	IPT	0.0018	0.0027	0.0035	0.0041	0.0046	0.0054			
	3	Ap max 0.1 x D	370	940	IPT	0.0015	0.0022	0.0028	0.0033	0.0037	0.0043			
H	1	Ap max 0.1 x D	170	650	IPT	0.0018	0.0027	0.0035	0.0041	0.0046	0.0054			
	2	Ap max 0.1 x D	80	580	IPT	0.0015	0.0022	0.0028	0.0033	0.0037	0.0043			
	3	Ap max 0.1 x D	80	290	IPT	0.0010	0.0015	0.0018	0.0022	0.0025	0.0029			
H	4	Ap max 0.1 x D	170	430	IPT	0.0013	0.0020	0.0026	0.0030	0.0034	0.0040			
	1	Ap max 0.1 x D	270	1010	IPT	0.0017	0.0025	0.0031	0.0036	0.0040	0.0046			
H	2	Ap max 0.1 x D	230	870	IPT	0.0012	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.

146	148	72	4	152

